

A1-F18AC-SRM-222

1 MAY 2001

TECHNICAL MANUAL

ORGANIZATIONAL, INTERMEDIATE, AND DEPOT MAINTENANCE

STRUCTURE REPAIR FORWARD FUSELAGE

NAVY MODEL
F/A-18A AND F/A-18B
161353 AND UP

N00421-98-D-1339

This manual supersedes A1-F18AC-SRM-222 dated, 1 March 1990
with Change 8 dated, 1 March 1997, including IRAC 1.

This volume is one of four volumes and is incomplete without A1-F18AC-SRM-220,
A1-F18AC-SRM-221 and A1-F18AC-SRM-223.

This volume contains WP025 00 through WP045 00.

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NUMERICAL INDEX OF EFFECTIVE WORK PACKAGES/PAGES

List of Current Changes

Original 0 1 May 2001
(Incl. IRAC 1)

Only those work packages assigned to the manual are listed in this index. Insert _____ dated _____. Dispose of superseded and deleted work packages/pages. Superseded and deleted classified work packages/pages shall be destroyed in accordance with applicable regulations. If changed pages are issued to a work package, insert the changed pages in the applicable work package. The portion of text affected in a changed or revised work package is indicated by change bars or the change symbol "R" in the outer margin of each column of text. Changes to illustrations are indicated by pointing hands or change bars, as applicable.

Total number of Pages in this manual is 664, consisting of the following:

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028 00 Reserved		032 00		1 - 39	0	045 00	
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14 Blank	0	1 - 30	0				

LIST OF TECHNICAL PUBLICATIONS DEFICIENCY REPORTS INCORPORATED

ORGANIZATIONAL, INTERMEDIATE, AND DEPOT MAINTENANCE

STRUCTURE REPAIR

FORWARD FUSELAGE

This WP supersedes TPDR WP, dated 1 March 1997.

1. The TPDRs listed below have been incorporated in this issue.

REPORT CONTROL NUMBER	LOCATION
39783-97-0090	WP 035 00, pg 9
21412-98-0037	WP 035 00, pg 9
03365-99-0032	WP 035 00, pg 9
52994-99-0014	WP 025 00, pg 2

WARNINGS APPLICABLE TO HAZARDOUS MATERIALS

Warnings in this manual alert personnel to hazards associated with the use of hazardous materials. Additional information related to hazardous materials is provided in OPNAVINST 5100.23, Navy Occupational Safety and Health (NAVOSH) program manual, NAVSUPINST 5100.27, Navy Hazardous Material Control Program, and the DOD 6050.5, Hazardous Materials Information System (HMIS) series publications. For each hazardous material used within the Navy, a Material Safety Data Sheet (MSDS) must be provided and available for review by users. Consult your local safety and health staff concerning any questions regarding hazardous materials, MSDS, personal protective equipment requirements, appropriate handling and emergency procedures, and disposal guidance.

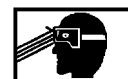
Under the heading "HAZARDOUS MATERIALS WARNINGS," complete warnings, including related icons(s) and numeric identifier, are provided for hazardous materials used in this manual.

In the text of the manual, the caption "WARNING" is not used for hazardous material warnings. Hazards are cited with appropriate icon(s), the nomenclature of the hazardous material, and the numeric identifier that relates to the complete warnings. Users of hazardous materials shall refer to the complete warnings, as necessary.

Biological



Eye Protection



Vapor



Fire



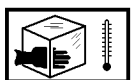
Chemical



Poison



Cryogenic



Radiation



Explosion



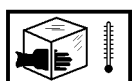
EXPLANATION OF HAZARDOUS SYMBOLS



The abstract symbol bug shows a material that may contain bacteria or viruses that present a danger to your life or health.



The symbol of a liquid dripping onto a hand shows that the material will cause burns or irritation to human skin or tissue.



The symbol of a hand in a block of ice shows that the material is extremely cold and can injure human skin or tissue.



The rapidly expanding symbol shows that the material may explode if subjected to high temperature, sources of ignition, or high pressure.



The symbol of a person wearing goggles shows that the material will injure the eyes.



The symbol of a fire shows that the material may ignite and cause burns.



The symbol of a skull and crossbones shows that the material is poisonous or is a danger to life.
























The symbol of three circular wedges shows that the material emits radioactive energy and can injure human tissue or organs.



The symbol of a human figure in a cloud shows that material vapors of a material present a danger to life or health.

HAZARDOUS MATERIALS WARNINGS

<u>Index</u>	<u>Material</u>	<u>Warning</u>
1	Sealing Compound, MIL-S-83430, Class B-4	Sealing compound MIL-S-83430, Class B-4 is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.
	   	
2	Primer, 519X303	Primer 519X303 is highly flammable and toxic. Do not use near open flame or sparks. Use only in well ventilated areas.
	  	
3	Thinner, Dope, A-A-857	Thinner, Dope, A-A-857 is highly flammable. Do not use near open flame or sparks. Use only in well ventilated areas.
	  	
4	Cleaning Compound, MIL-C-38736	Cleaning Compound, MIL-C-38736, irritates skin, nose, throat and respiratory tract. Avoid repeated/prolonged contact. Avoid heat, sparks, flames, and strong oxidizing agents. Keep away from open flames or other sources of ignition. Use only in well-ventilated areas. Protection: Full-face atmosphere supplying respirator, chemical resistant gloves and chemical goggles.
	     	
5	Sealing Compound, MIL-S-81733, Type 4-12	Sealing Compound, MIL-S-81733, Type 4-12, is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Keep away from open flames or other sources of ignition. Rubber gloves shall be used. Wash hands thoroughly with soap and water before eating, drinking or smoking. Contains chromates; follow approved toxic waste disposal procedures.
	    	

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HMWS-4

6 Sealing Compound, MIL-S-83430, Class A-1/2



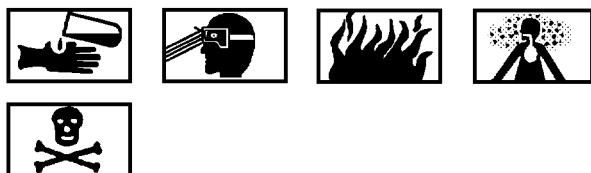
Sealing Compound, MIL-S-83430, is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.

7 Dry Cleaning Solvent, P-D-680 Type II



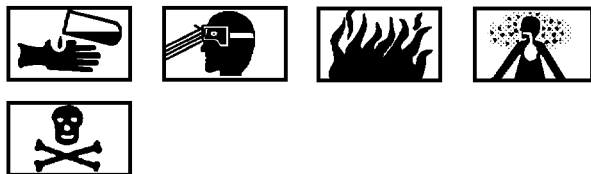
Dry Cleaning Solvent, P-D-680, Type II, is combustible - do not use near open flames, near welding areas, or on hot surfaces. Prolonged contact of skin with liquid can cause dermatitis. Repeated inhalation of vapor can irritate nose and throat and cause dizziness. If any liquid contacts skin or eyes, immediately flush affected area thoroughly with water. Remove solvent saturated clothing. If vapors cause dizziness, go to fresh air. When handling liquid or when applying it in air-exhausted, partially covered tank, wear approved gloves. When handling liquid or when applying it at unexhausted, uncovered tank or workbench wear approved respirator and goggles. Cleaning solvents shall not be applied by air spray and shall not be kept in open containers.

8 Adhesive, URALANE 5774 A/B



Adhesive, URALANE 5774 A/B is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection is required. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.

9 Methyl Isobutyl Ketone, D 1153



Methyl Isobutyl Ketone (MIBK) is toxic, flammable, and irritating to eyes and skin. Overexposure may cause dizziness, narcosis, nausea and vomiting. Do not use in confined areas. Protection: Chemical splash proof goggles, gloves, and good ventilation. Keep container closed. Keep sparks, flames, and heat away. Keep MIBK off skin, eyes, and clothes. Do not breathe vapors. Use of respiratory protection may be required, depending on work task(s) and location. Insure good personal hygiene prior to eating, drinking, or smoking.

10 Methyl Ethyl Ketone, TT-M-261



Methyl Ethyl Ketone, TT-I-261, is flammable - do not use near open flames, near welding areas, or on hot surfaces. Do not smoke when using it, and do not use it where others are smoking. Contact with liquid or vapor can cause skin irritation, dermatitis and drowsiness. If there is any prolonged skin contact, wash contacted area with soap and water. Remove solvent saturated clothing. If vapors cause drowsiness, go to fresh air. If irritation persists, get medical attention. When handling liquid at air-exhausted workbench, wear approved gloves, goggles and long sleeves. When handling liquid or liquid-soaked cloth in open unexhausted area, wear approved respirator, gloves and goggles. Dispose of liquid soaked rags in approved metal container. Metal containers of solution must be grounded to maintain electrical continuity.

11 Adhesive, RTV-732



Adhesive, RTV-732, is toxic to skin, eyes, and respiratory tract. Skin and eye protection required. Avoid repeated or prolonged contact. Good general ventilation is normally adequate.

12 Primer, Adhesive, 1200 RTV



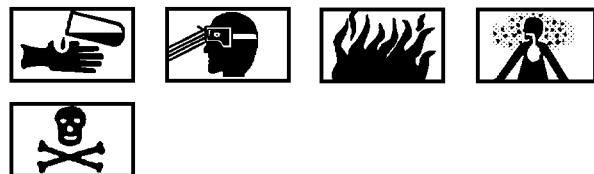
Adhesive Primer, 1200 RTV, is highly flammable and toxic. Do not use near open flame or sparks. Use only in well ventilated areas.

13 Adhesive, EC847



Adhesive, EC847, is highly flammable. Do not use near open flame or sparks. Use only in well ventilated areas.

14 Adhesive, EA956



Adhesive, EA956, is toxic and flammable. Avoid contact with skin or eyes. If eye contact is made, wash immediately with soap and water. Use in well ventilated area and avoid breathing vapors. Wash hands thoroughly after each use. Close container after each use. Store in a cool, dry, and well ventilated area. Avoid contact with strong oxidizing agents. Protection: rubber gloves, chemical resistant goggles, and protective skin compound; respirator with organic vapor cartridge required in poorly ventilated areas.

A1-F18AC-SRM-222

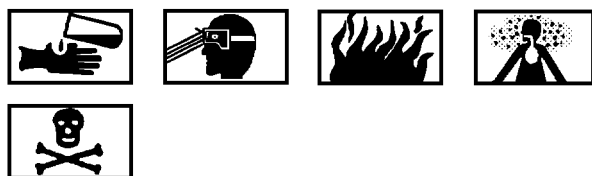
HMWS-6

15 Isopropyl Alcohol, TT-I-735



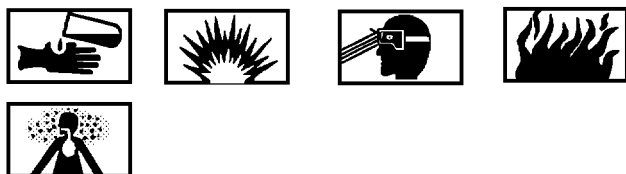
Isopropyl Alcohol, TT-I-735, is flammable - do not use near open flames, near welding areas, or on hot surfaces. Do not smoke when using it and do not use it where others are smoking. Inhalation of vapors can cause drowsiness, dizziness, and headache. Contact of liquid with skin may cause dermatitis and irritation. If any liquid contacts skin or eyes, immediately flush affected area thoroughly with water. Remove solvent-saturated clothing. If vapors cause drowsiness, go to fresh air. When handling large quantities greater than one gallon), work at air-exhausted workbench or covered tank. Store solvent and dispose of liquid-soaked clothes in approved metal safety container. Metal containers of liquid must be grounded to maintain electrical continuity.

16 Adhesive, EA934



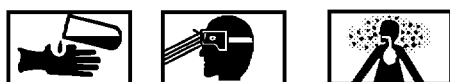
Adhesive, EA934 is toxic. Avoid breathing of vapors. Avoid contact with skin or eyes. Wear gloves and goggles while handling. If eye contact is made, wash immediately with large amount of water. If skin contact is made, wash immediately with soap and water.

17 Silicone Primer, SS-4004



Silicone Primer, SS-4004, irritates the eyes, skin and vapors may cause headaches, dizziness and nausea. Avoid heat, sparks and open flames. Protection: Safety glasses, respirator not required unless normal ventilation is inadequate.

18 Adhesive, RTV106



Adhesive, RTV106, is toxic to skin, eyes, and respiratory tract. Skin and eye protection required. Avoid repeated or prolonged contact. Good general ventilation is normally adequate.

19 Solvent, Cleaning, MMS-409



Cleaning Solvent, MMS-409, is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.

20 Adhesive, EC1357



Adhesive, EA1357 is toxic. Avoid breathing of vapors. Avoid contact with skin or eyes. Wear gloves and goggles while handling. If eye contact is made, wash immediately with large amount of water. If skin contact is made, wash immediately with soap and water.

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HMWS-7

21 Lubricate Oil, MIL-L-7808



Lubricating Oil, MIL-L-7808, is toxic to skin, eyes, and respiratory tract. Skin and eye protection required. Avoid repeated or prolonged contact. Good general ventilation is normally adequate.

22 Sealing Compound, MIL-S-83430, Class B-2



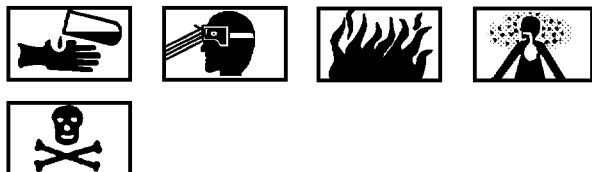
Sealing Compound, MIL-S-83430, Class B-2, is flammable and toxic to eyes, skin and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.

23 Corrosion Preventive Compound, MIL-C-16173, Grade 3



Corrosion Preventive Compound, MIL-C-16173, Grade 3, is flammable – keep it away from heat, sparks and open flames. Do not smoke when using it. Use in a well ventilated area. Inhalation of vapors is harmful. Wear rubber gloves, chemical goggles (or face shield), and protective neoprene apron. If splashed on clothing or in eyes, remove clothing immediately and flush skin/eyes with clear water for 15 minutes. If vapors cause light-headedness, go to fresh air. If liquid is swallowed, do not try to vomit. Get prompt medical attention. Keep away from pillage. Use absorbent to soak up spilled solution. Dispose of absorbent in accordance with local, state, and federal regulations. Keep solution away from oxygen and strong oxidants. Store in approved metal safety container. Keep containers closed when not in use.

24 Sealing Compound, MIL-S-81733, Class 1-1/2



Sealant Compound, MIL-S-81733, Class 1-1/2, is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames and other sources of ignition.

25 Nitrogen, BB-N-411, Type I (Gaseous)



Nitrogen, BB-N-411, Type I (Gaseous) acts as a natural asphyxiant. Use in well ventilated spaces.

26 Acetone, O-A-51



Acetone (O-A-51) is flammable - do not use near open flames, near welding areas or on hot surfaces. Do not smoke while using it and do not use it where others are smoking. Prolonged inhalation of vapor can irritate eyes and mucous membranes and can cause dizziness and headache. If any liquid contacts skin, immediately remove solvent-saturated clothing. If vapors cause drowsiness, go to fresh air. When handling large quantities of liquid (more than a gallon), use at air-exhausted workbench. Wear approved gloves. Store solvent and dispose of liquid-soaked rags in approved metal safety container. Metal containers of solvent must be grounded to maintain electrical continuity.

ORGANIZATIONAL MAINTENANCE**STRUCTURE REPAIR****FORWARD FUSELAGE FLOORS, AND CANOPY DECK**

Reference Material

Line Maintenance Procedures	A1-F18AC-LMM-000
Line Maintenance Access Doors	A1-F18AC-LMM-010
Structure Repair, General Information	A1-F18AC-SRM-200
Adhesive, Cement and Sealant; Preparation and Application	WP011 00
EMI Electrical Bonding Strip Contact Verification	WP004 25
Forming Sheet Metal	WP004 01
Shop Practices, Fasteners	WP004 06
Aircraft Corrosion Control	A1-F18AC-SRM-500
Windshield, Canopy, and Cockpit Finish System	WP021 00
Form In Place/EMI Seal On Structure At Doors 18, 26, 31, 40, 43 and 49	WP005 02
Chemical Treatment	WP008 00
Form In Place Sealing	WP010 00
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Fuel System	A1-F18AC-460-300
Fuel Tank Maintenance Precautions and General Preparation	WP013 00
Removal - No. 1 Fuel Tank - F/A-18B	WP014 00
Installation - No. 1 Fuel Tank - F/A-18B	WP015 00

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Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F/A-18 AFC 22	1 May 89	Lateral Primary Controls FOD protection, Improvement of (ECP MDA-F/A-18-00100C1)	1 Mar 86	-
F/A-18 AFC 49	28 Feb 90	Sealed Lead Acid Battery, Addition of (ECP MDA-F/A-18-0074)	1 Jul 86	-
F/A-18 AFC 27	-	Leading Edge Flap/Control Stick Changes, Incorporation of Design (ECP MDA-F/A-18-0044C2)	1 Jul 86	-
F/A-18 AFC 48	-	Automatic AC Bus Isolation, Incorporation of (ECP MDA-F/A-18-00121R1)	15 Nov 86	-
F/A-18 AFC 78	-	Nose Landing Gear Retrace Actuator Structural support (ECP MDA-F/A-18-00239)	1 Jul 87	-

1. **FLOORS.**

2. **DAMAGE EVALUATION.** Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. Types of material used are shown on figures 1, 2, 3, 4, and 5. Damage not listed or exceeding the following limits require depot engineering disposition.

3. **Negligible Damage.** Negligible damage is damage that may be allowed to exist as is. Damage to screens 74A314397, 74A314818, and 74A314296 not more than 1 inch in length or diameter is negligible. Other damage requires depot engineering disposition.

4. **Repairable Damage.** Repairable damage is damage that can be permanently repaired with no adverse affect on structural integrity, flight characteristics, or safety of the aircraft. Damage to screens 74A314397,

74A314818, and 74A314296 exceeding negligible damage require replacement. Other damage requires depot engineering disposition.

5. **REPAIRS.** Repairs require depot engineering disposition except for the following:

a. The up standing flange P/N 74A314903 Angle Brackets are allowed 0.010 inches of cleanup for corrosion. If corrosion does not clean up after blending, contact engineering for disposition. Aircraft is grounded until engineering disposition is incorporated.

6. **SCREEN REPLACEMENT.**

7. **Screen, 74A314397.** See figure 3. Screen damaged beyond acceptable limits must be replaced.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
304 Wire Cloth	8 Mesh, 0.025 Dia. Wire Stainless Steel Screen
MS20470AD5	Rivet (as required)
NAS2605V05	Pin
NAS1080AG05	Collar
MIL-S-83430 CLASS B-4	Sealing Compound



Be careful not to enlarge holes when drilling out rivets. Damage to web can occur.

- a. Remove rivets attaching retainer, doubler and screen to web.
- b. Remove pin and collar from doubler.
- c. Remove retainer, doubler and screen from web.
- d. Fabricate new screen from 304 wire cloth.
- e. Prepare surfaces for electrical bonding (A1-F18AC-LMM-000).



Sealing Compound, MIL-S-83430, Class B-4 1

- f. Fay surface seal new screen, retainer and doubler with sealing compound. For preparation and application (A1-F18AC-SRM-200, WP011 00).
- g. Wet install pin and rivets with sealing compound (A1-F18AC-SRM-200, WP011 00). Rivet length determined on installation.
- h. Refinish area (A1-F18AC-SRM-500, WP021 00).

8. **Screen, 74A314818.** See figure 3. Screen damaged beyond acceptable limits must be replaced.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
304 Wire Cloth	8 Mesh, 0.025 Dia. Wire Stainless Steel Screen
MS20470AD5	Rivet (as required)
BRFS5AD()	Rivet (as required)
MIL-S-83430 CLASS B-4	Sealing Compound
519X303	Primer



Be careful not to enlarge holes when drilling out rivets. Damage to web can occur.

- a. Remove rivets attaching retainer, doubler and screen to web.
- b. Remove retainer, doubler and screen from web.
- c. Fabricate new screen from 304 wire cloth.
- d. Prepare surface for electrical bonding (A1-F18AC-LMM-000).



Sealing Compound, MIL-S-83430, Class B-4 1

- e. Fay surface seal new screen, doubler and retainer with sealing compound. For preparation and application (A1-F18AC-SRM-200, WP011 00).

- f. Install MS20470AD5 rivets wet with sealing compound, sealant preparation and application (A1-F18AC-SRM-200, WP011 00). Rivet length determined on installation.



Primer, 519X303 2

- g. Install BRFS5AD() rivets wet with primer. Rivet length determined on installation.

- h. Refinish area (A1-F18AC-SRM-500, WP021 00).

9. **Screen, 74A314296.** See figure 5. Screen damaged beyond acceptable limits must be replaced.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
304 Wire Cloth	8 Mesh, 0.025 Dia. Wire Stainless Screen
MS20470AD4	Rivet (as required)
MIL-S-83430 CLASS B-4	Sealing Compound



Be careful not to enlarge holes when drilling out rivets. Damage to web can occur.

- a. Remove rivets attaching screen and doubler to web.
- b. Remove screen and doubler from web.
- c. Fabricate new screen from 304 wire cloth.
- d. Prepare surfaces for electrical bonding (A1-F18AC-LMM-000).



Sealing Compound, MIL-S-83430, Class B-4

1

- e. Lay surface seal new screen and doubler with sealing compound. For preparation and application (A1-F18AC-SRM-200, WP011 00).
- f. Install rivets wet with sealing compound (A1-F18AC-SRM-200, WP011 00). Rivet length determined on installation.
- g. Refinish area (A1-F18AC-SRM-500, WP021 00).

10. **BEARING REPLACEMENT.** Failure of bearings in 74A620036-2001, 74A314866-2009, -2007 and

74A314647-1003 supports require replacement of bearing only. Bearing failure in 74A610018-1001 support requires support assembly replacement.

11. MS27642 BEARING, 74A620036-2001 SUPPORT, REPLACEMENT.

Support Equipment Required

Part Number or Type Designation	Nomenclature
TD296M-44	Roller Staking Tool Kit

Materials Required

Specification or Part Number	Nomenclature
A-A-857	Thinner, Dope
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
MIL-C-83430 CLASS B-4	Sealing Compound

- a. Press out failed bearing.
- b. Inspect housing bore for burrs and/or scoring.
- c. Clean and deburr housing bore as required.
- d. Measure I.D. of housing bore. Diameter should be 1.751 +0.001, -0.000. If dimension exceeds these limits, replace support assembly.
- e. Install new bearing and center carefully in housing. Make sure bearing is not canted or bound.
- f. Select proper size staking tool and insert in drill press. Set drill press speed at approximately 50 RPM.
- g. Make sure that bearing and staking tools are aligned and housing is perpendicular to the axis of the spindle.

NOTE

A steady stream of air must be directed on work area. Temperature in tool/work area should not exceed touch temperature, approximately 130°F.

h. Gradually apply sufficient pressure to stake bearing, making sure bearing remains seated in hous-

ing. Staking is accomplished when roller begins to polish outside of stake area.



Thinner, Dope, A-A-857

3

i. Clean staked area with cheesecloth dampened with thinner.

j. Edge seal around periphery of enclosure per A1-F18AC-SRM-200, WP011 00.

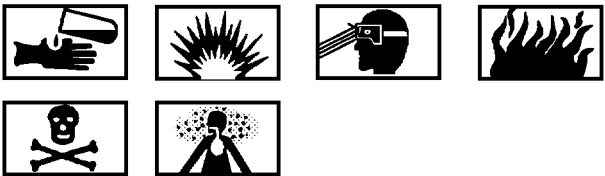
12. **MS27645 BEARING, 74A314647-1003 AND 74A314866-2009,-2007 SUPPORT, REPLACEMENT.**

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
MIL-C-38736 CCC-C-440 TYPE 1 CLASS 1	Cleaning Compound Cheesecloth
a. Press out failed bearing.	
b. Inspect housing bore for burrs and/or scoring.	
c. Clean deburr housing bore as required.	
d. Measure I.D. of housing bore. Diameter should be 0.8115 +0.0005, -0.0000 in 74A314647-1003 support and 1.9365 +0.0005, -0.0000 in 74A314866 support. If dimensions exceed these limits, replace support.	
e. Install new bearing and center carefully in housing. Make sure bearing is not canted or bound.	
f. Press fit bearing in housing, making sure insertion force is on outer race.	
g. Make sure, after bearing is seated, that bearing moves freely in housing.	



Cleaning Compound, MIL-C-38736

4

h. Clean bearing with cheesecloth dampened with cleaning compound.

13. CANOPY DECK.

14. **DAMAGE EVALUATION.** See figures 6 and 7. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. Types of material used are shown on figures 6 and 7. Damage not listed or exceeding following limits requires depot engineering disposition.

15. **Negligible Damage.** Damage requires depot engineering disposition.

16. **Repairable Damage.** Damage requires depot engineering disposition.

17. **REPAIRS.** Repair for forward fasteners attaching canopy actuator support can be done per paragraph 18. Broken tabs on 74A314092 bulkhead can be repaired per paragraph 19. Elongated holes on 74A314093 and 74A314701 angle brackets can be repaired per paragraph 20. Other repairs require depot engineering disposition.

18. **Canopy Actuator Support - F/A-18B, 161354 THRU 162885, 74A314838, Fastener Repair.** See figure 8. If any of the four forward attach bolts fail, repair by removing existing hardware, four places, and installing new hardware with radius blocks.

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Torque Wrench, 0 to 150 Inch-Pounds

Materials Required**Specification
or Part Number****Nomenclature**

AIC763-4-20	Bolt (4)
NAS1587-4C	Washer (4)
Fabricate	Radius Block (8)
AN960C416	Washer (4)
78686-4	Nut (4)
MIL-S-81733	Sealing Compound
TYPE 4-12	

a. Do general preparation for removal of fuel tank (A1-F18AC-460-300, WP013 00).

b. To gain access to nuts, remove No. 1 fuel tank as required (A1-F18AC-460-300, WP014 00).

c. Fabricate repair blocks as shown.

NOTE

Replace bolts one at a time.

d. Remove existing bolt, nut, and washer.

e. Enlarge existing fastener hole to 0.2495 +0.0025 -0.0000 diameter.

f. Deburr fastener hole.



Sealing Compound, MIL-S-81733, Type 4-12 5

g. Install bolt, wet with sealing compound, washers, radius blocks, and nut as shown on figure.

h. Torque bolt 60 to 90 inch-pounds.

i. Repeat steps d through h for each of remaining bolts.

j. Touch up finish system (A1-F18AC-SRM-500, WP021 00).

k. Install No. 1 fuel tank (A1-F18AC-460-300, WP015 00).

19. **Bulkhead, 74A314092, Broken Tab Repair.**
See figure 9.

Support Equipment Required

None

Materials Required**Specification
or Part Number****Nomenclature**

MIL-S-83430	Sealing Compound
CLASS A-1/2	
MS20426AD3	Solid Rivet (2)
HL40-5-4	Hi-Lok Pin (4)
SW1000-5M	Collar (4)
F51827-4-16	Plate Nut

a. Remove doors 7 and 18 (A1-F18AC-LMM-010).

b. Trim broken tab as shown, detail A.

c. Fabricate repair bracket to nest on aft side of bulkhead. For forming sheet metal (A1-F18AC-SRM-200, WP004 01).

d. Lay out and pilot drill four holes in repair bracket for 5/32 inch Hi-Lok pins. For Hi-Loks (A1-F18AC-SRM-200, WP004 06).

e. Position repair bracket on bulkhead and mate drill pilot holes.

f. Fabricate backing plate for forward side of bulkhead.

g. Position backing plate and mate drill pilot holes from bulkhead.

h. Enlarge pilot holes in repair bracket, bulkhead, and backing plate to 0.1635 +0.0025 -0.0000 inch diameter.

i. Temporarily install repair bracket and backing plate on bulkhead.

NOTE

Stock thickness of spacer as required to maintain upper contour of bulkhead.

j. Fabricate spacer to fit trimmed tab area and contour of bulkhead.

- k. Using door 18 as template, transfer fastener hole location to repair bracket.
- l. Pilot drill fastener hole location in repair bracket.
- m. Position and clamp spacer to repair bracket.
- n. Mate drill pilot hole from repair bracket to spacer.
- o. Enlarge pilot hole in spacer and repair bracket to 0.453 inch diameter.
- p. Position plate nut and drill attach holes 0.098 +0.008 -0.000 inch diameter.
- q. Countersink plate nut attach holes in spacer.
- r. Remove all repair parts, deburr holes, and clean up repair area.
- s. Apply finish system as required to repair parts and bulkhead (A1-F18AC-SRM-500, WP024 00).



Sealing Compound, MIL-S-83430, Class A-1/2 6

- t. Fay surface seal repair bracket and backing plate to bulkhead and wet install Hi-Lok pins using sealing compound. For preparation and application (A1-F18AC-SRM-200, WP011 00).
- u. Fay surface and butt joint seal spacer to repair bracket and bulkhead and wet install rivets, using sealing compound, through spacer, repair bracket and plate nut.
- v. Apply form in place seal as required (A1-F18AC-SRM-500, WP010 00).
- w. Install doors 7 and 18 (A1-F18AC-LMM-010).

20. Angle Bracket, 74A314093 and 74A314701, Repair. See figure 10. This repair corrects elongated holes and provides added strength to 74A314093 and 74A314701 (angle brackets). Other repairs to angle brackets require depot engineering disposition.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
Fabricate	7075-T6 Alclad 0.063 X 2.30 X 45.00
Fabricate	7075-T6 Alclad 0.063 X 2.30 X 11.50
MS20426E4	Rivet, (26)
MS20426AD3	Rivet, (26)
CCC-C-440	Cheesecloth
TYPE 1 CLASS 1	
P-D-680 Type II	Dry Cleaning Solution
MIL-S-83430	Sealing Compound
CLASS A-1/2	

- a. Remove door 18 (A1-F18AC-LMM-010).
- b. Pull EMI seal loose from repair area.
- c. Trim form in place seal from repair area.
- d. Drill out rivets attaching plate nuts to angle brackets, 26 places.
- e. Fabricate repair doublers from sheet metal:

NOTE

Do not allow sheet metal pieces to ride on bend radius of angle brackets.

- (1) Position sheet metal pieces behind angle brackets and secure in place using c-clamps, detail C.
- (2) Scribe outline contours of angle brackets on sheet metal pieces.
- (3) Remove sheet metal pieces and trim along scribed line.

NOTE

Sheet metal pieces will be called repair doublers once trimmed.

- (4) Position repair doublers behind angle brackets aligning contours and secure in place using c-clamps, detail D.
- (5) Back drill 0.281 +0.007 -0.001 inch diameter holes, 13 places, into repair doublers, detail E.
- (6) Back drill 0.098 +0.008 -0.000 inch diameter holes, 26 places, into repair doublers, detail E.

(7) Locate and drill 0.128 +0.006 -0.000 inch diameter added holes, 26 places, through angle brackets and repair doublers. Maintain four diameters edge distance from all holes and two diameters edge distance from all edges, detail E.

(8) Countersink 0.128 inch diameter added holes, 26 places, in angle brackets to flushness requirements of MS20426E4 rivets.

(9) Remove repair doublers and deburr all holes.



Dry Cleaning Solvent, P-D-680, Type II 7

f. Clean repair doublers and angle brackets using clean cheesecloth moistened with dry cleaning solution.

g. Apply finish system to repair doublers and angle brackets (A1-F18AC-SRM-500, WP024 00).

h. Position repair doublers behind angle brackets and secure in place using c-clamps.



Sealing Compound, MIL-S-83430, Class A-1/2 6

i. Wet install MS20426E4 rivets securing repair doublers to angle brackets, (A1-F18AC-SRM-200, WP011 00).

NOTE

Determine length of rivets on installation.

j. Wet install MS20426AD3 rivets securing plate nuts to angle brackets and repair doublers, (A1-F18AC-SRM-200, WP011 00).

k. Apply chemical treatment to EMI seal contact area on angle brackets if damaged during repair (A1-F18AC-SRM-500, WP008 00).

l. Apply form in place with EMI seal (A1-F18AC-SRM-500, WP005 02).

m. Install door 18 (A1-F18AC-LMM-010).

21. REPLACEMENT.

22. EMI ELECTRICAL BONDING STRIP. Electrical bonding strip (EMI Spring Fingers) damaged beyond acceptable limits shall be replaced. See figure 7 (20).

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
ST9M622-4-2400	Strip-Bonding Electrical
MS20426AD5	Rivet (as required)
MIL-S-83430	Sealing Compound
CLASS B-4	

a. Remove door CPE (A1-F18AC-LMM-010).



Be careful not to enlarge holes when drilling out rivets. Damage to support can occur.

b. Remove rivets attaching retainer and strip to support.

c. Remove retainer and damaged strip.

d. Cut to size new strip from ST9M622-4-2400 strip.

e. Prepare surfaces for electrical bonding (A1-F18AC-LMM-000).

f. Position new EMI strip and retainer; secure in place.

g. Punch holes in EMI strip.



Sealing Compound, MIL-S-83430, Class B-4

1

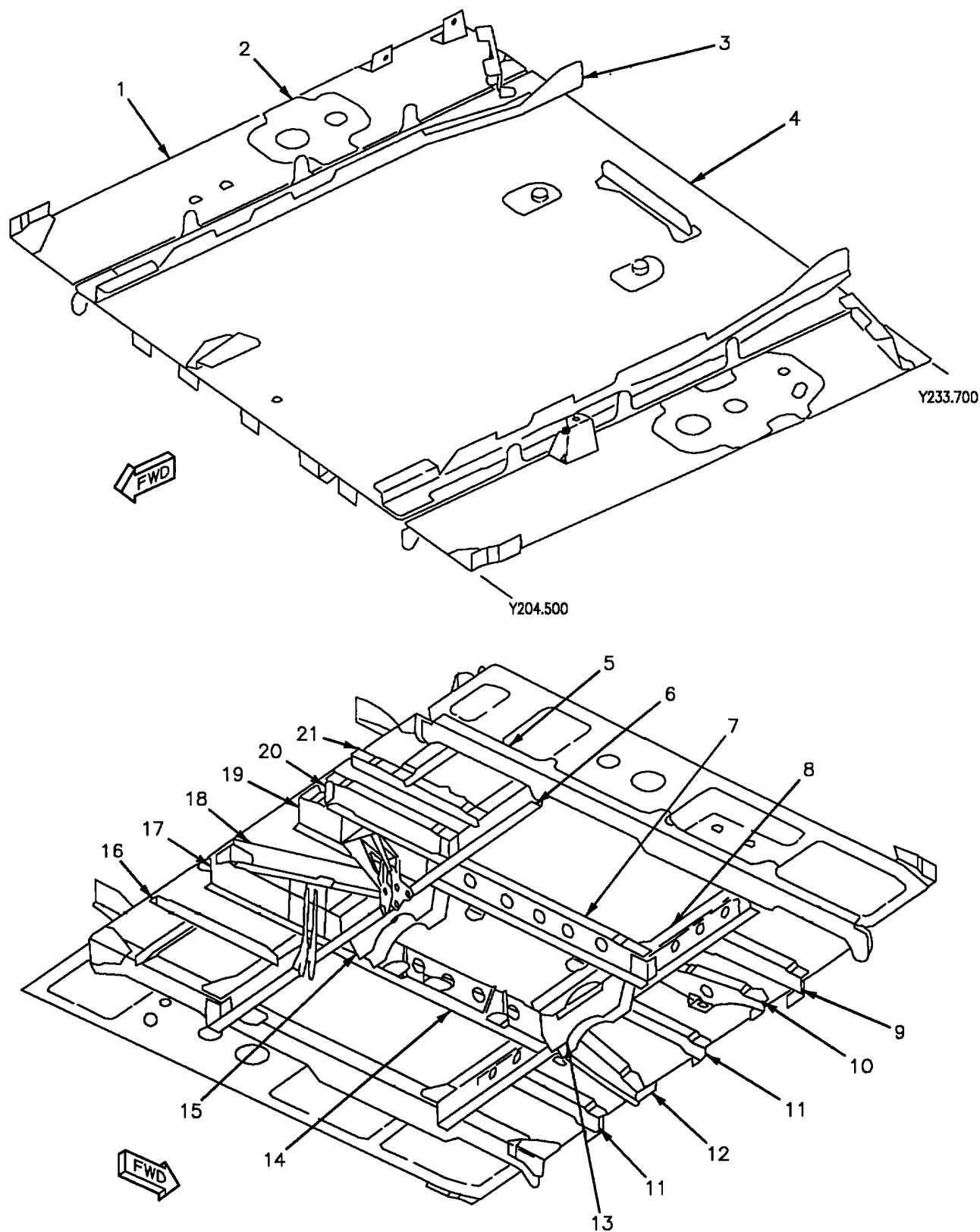
h. Wet install rivets with sealing compound (A1-F18AC-SRM-200, WP011 00). Rivet length determined on installation.

i. Fillet seal EMI strip with sealing compound (A1-F18AC-SRM-200, WP011 00).

j. Verify electrical bonding strip contact (A1-F18AC-SRM-200, WP004 25).

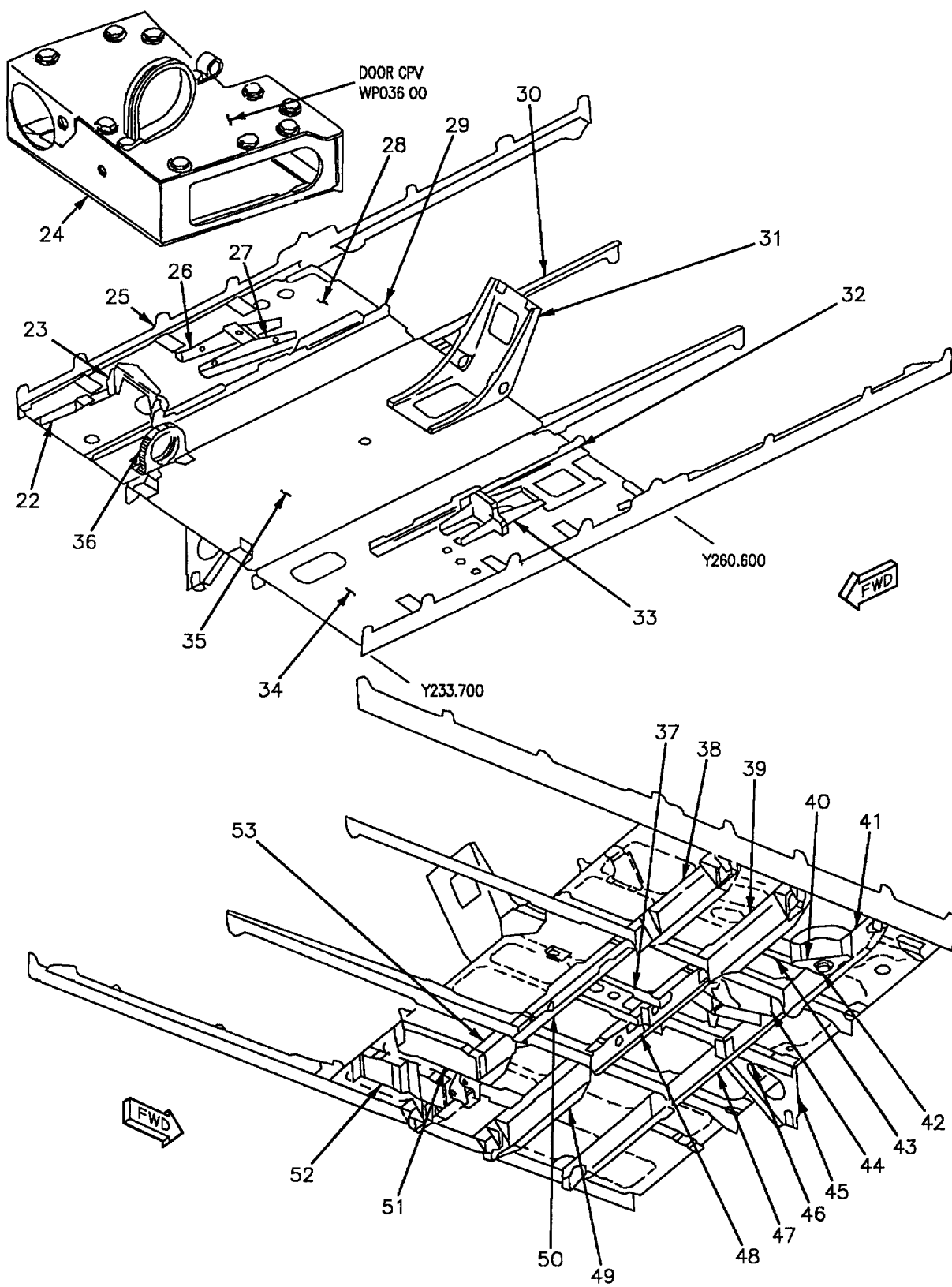
k. Refinish area (A1-F18AC-SRM-500, WP021 00).

l. Install door CPE (A1-F18AC-LMM-010).



18AC-SRM-222-(1-1)01-SCAN

Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 1)



18AC-SRM-222-(1-2)01-SCAN

Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 2)










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3	  	Angle 74A314602-2059, -2069 74A314602-9011, -2069 74A314602-2101, -2069	0.040 Sheet	7075-T6 Alclad
4	 	Web 74A314601-2001, -2003 74A314601-2003	 Sheet	7076-T6 Alclad
5		Support 74A314209-2007, -2005	1MA220D05-10010 Extr	7075-T73511 Al Aly
6		Support 74A314642-2005	1MA163D05-10041 Extr	7075-T73511 Al Aly
7		Support 74A314603-2057, -2040	0.050 Sheet	7075-T6 Alclad
8		Support 74A314644-2003	1MA163D05-10031 Ext	7075-T73511 Al Aly
9		Support 74A314602-2079	0.050 Sheet	7075-T6 Alclad
10		Support 74A314603-2063	0.050 Sheet	7075-T6 Alclad
11		Support 74A314602-2077	0.050 Sheet	7075-T6 Alclad
12		Support 74A314603-2061	0.050 Sheet	7075-T6 Alclad
13		Bracket 74A314602-2001	0.050 Sheet	7075-T6 Alclad
14		Support 74A314603-2057	0.050 Sheet	7075-T6 Alclad
15		Bracket 74A314602-2055	0.050 Sheet	7075-T6 Alclad
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Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 3)




















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19		Support 74A314603-2041	0.050 Sheet	7075-T6 Alclad
20	 	Support 74A314602-2019 74A314602-2081	0.050 Sheet	7075-T6 Alclad
21		Support 74A314602-2088	0.050 Sheet	7075-T6 Alclad
22	 	Angle 74A314230-2001 74A314230-2119	0.063 Sheet	7075-T6 Alclad
23	 	Bracket 74A314230-2035 74A314230-2111	0.050 Sheet	7075-T6 Alclad
24		Enclosure 74A620054-1001	Sheet	7075-T6 Alclad
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26		Tee 74A314230-2099	1MA160D06-10266 Extr	7075-T76511 Al Aly
27		Tee 74A314230-2101	1MA160D06-10266 Extr	7075-T76511 Al Aly
28	  	Web 74A314041-2017 74A314041-9007 74A314041-2033	 Sheet	7075-T6 Alclad
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Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 4)



























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
31	 	Support 74A314634-2005 74A314634-9003	Pressing	7075-T73 Al Aly
32	 	Angle 74A314230-2093 74A314230-2091	0.063 Sheet	7075-T6 Alclad
33	    	Support 74A314040-2007 74A314040-2011 74A314040-2015 74A314040-2009 74A314040-2013	2.25 Plate 2.25 Plate 4.00 Plate 4.00 Plate	7075-T7351 Al Aly 7075-T7351 Al Aly 4130 Steel Aly 4130 Steel Aly
34	    	Web 74A314041-2027 74A314041-9005 74A314041-9011 74A314041-2035 74A314041-9009	 Sheet	7075-T6 Alclad
35	 	Web 74A314605-2061 74A314605-2063	 Sheet	7075-T6 Alclad
36		Support 74A610018-1001	1MA160B04-10410 Extr	2024-T8511 Al Aly
37		Doubler 74A314605-2055	0.050 Sheet	7075-T6 Alclad
38	  	Support 74A314039-2006 74A314039-2008 74A314939-2007	2.00 Plate	7075-T7351 Al Aly
39	  	Support 74A314038-2010 74A314038-2014 74A314940-2004	2.00 Plate	7075-T7351 Al Aly
40		Support 74A620036-2001	Forging	7075-T73 Al Aly
41	 	Support 74A314037-2009, -2011 74A314037-2013,-2011	2.25 Plate	7075-T7351 Al Aly
42		Bearing MS27642-16	-	Steel Fed Std - 66

Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 5)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
43		Support 74A314628-2005	0.050 Sheet	7075-T6 Alclad
44	23	Support 74A314914-1003	1.25 Plate	7076-T7351 Al Aly
45		Support 74A314036-2017	0.050 Sheet	7075-T6 Alclad
46		Tee 74A314036-2009	1MA160D01-10431 Extr	7075-T7351 Al Aly
47	11 23	Support 74A314605-2067 74A314605-2041	0.071 Sheet	7075-T6 Alclad
48	11 23	Support 74A314605-2069 74A314605-2043	0.050 Sheet	7075-T6 Alclad
49	14 15 42 52 9 10	Support 74A314038-2007 74A314038-2015 74A314038-2019 74A314940-2003 74A314038-2011 74A314038-2017	2.00 Plate	7075-T7351 Al Aly
50	31 32 33 34	Support 74A314605-2075 74A314605-2087 74A314605-2077 74A314605-2089	0.050 Sheet	7075-T6 Alclad
51	47 48	Zee 74A314230-2088 74A314230-2122	1MA180D05-10252 Extr	7075-T73511 Al Aly
52	47 48	Zee 74A314230-2087 74A314230-2121	1MA180D05-10252 Extr	7075-T73511 Al Aly

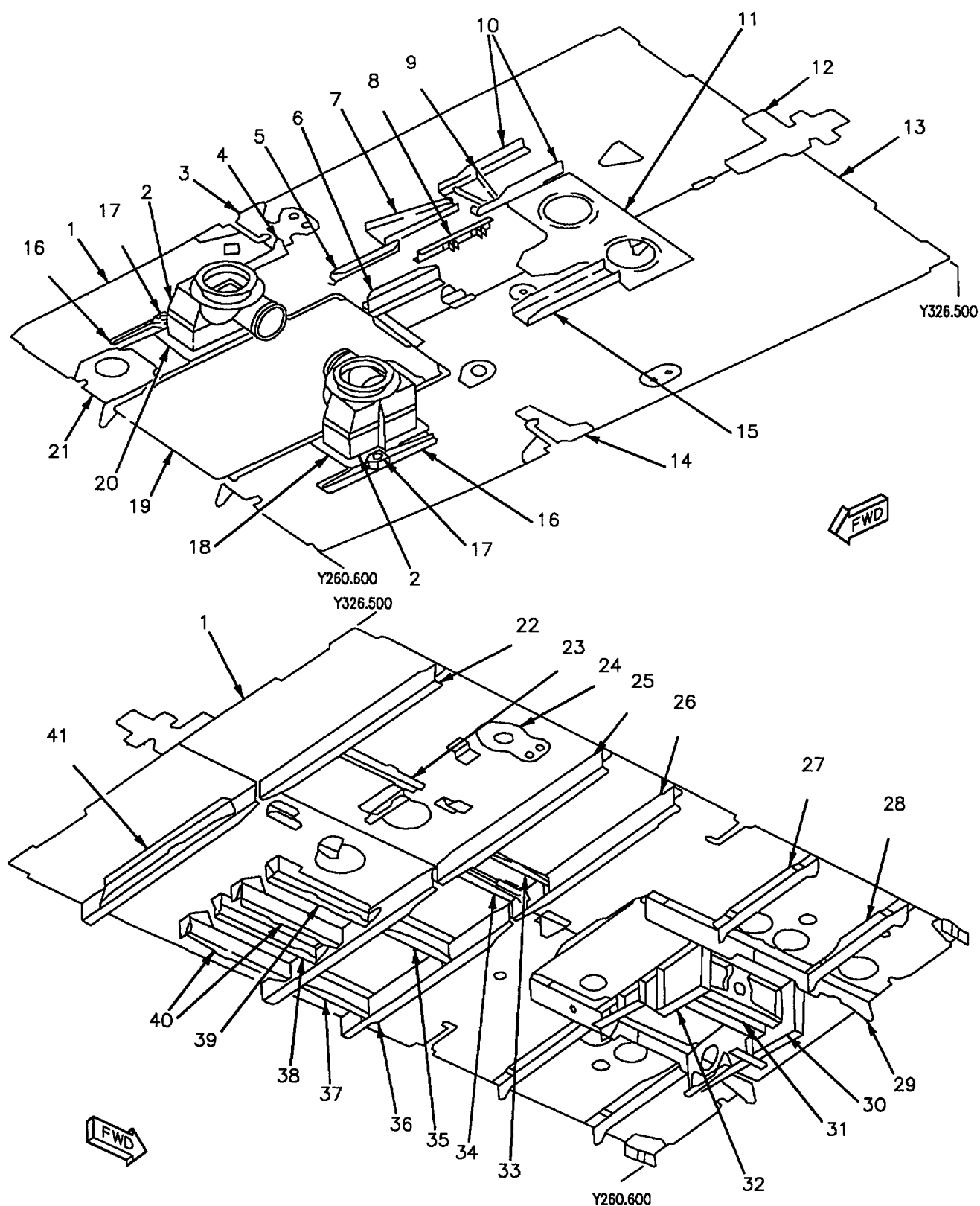
Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 6)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
53	<div>39</div> <div>40</div> <div>8</div> <div>41</div> <div>42</div> <div>52</div> <div>43</div> <div>44</div> <div>13</div> <div>45</div>	Support 74A314039-9001 74A314039-9003 74A314039-2011 74A314039-2007 74A314039-2015 74A314939-2005 74A314039-2009 74A314039-9005 74A314039-9007 74A314039-2017	2.00 Plate	7075-T7351 Al Aly
LEGEND <div>1</div> Lands are 0.050 and bays are 0.025. <div>2</div> Lands are 0.063 and bays are 0.029. <div>3</div> Lands are 0.050 and bays are 0.030. <div>4</div> Lands are 0.063 and bays are 0.042. <div>5</div> 161353 THRU 161519. <div>6</div> 161520 AND UP. <div>7</div> F/A-18A 161353 THRU 161519, 161702 THRU 161726 AND 161732 AND UP. <div>8</div> F/A-18A 161520 THRU 161528. <div>9</div> F/A-18B 161354 THRU 161360. <div>10</div> F/A-18B 161704 AND UP. <div>11</div> F/A-18A 161353 AND UP. <div>12</div> F/A-18B 161354 THRU 161360. <div>13</div> 161924 AND UP. <div>14</div> F/A-18A 161353 THRU 161519. <div>15</div> F/A-18A 161520 THRU 162414. <div>16</div> F/A-18A 161353 THRU 161528. <div>17</div> F/A-18A 161353 THRU 161708. <div>18</div> F/A-18A 161709 AND UP AND F/A-18B 161354 AND UP. <div>19</div> 161520 THRU 161717. <div>20</div> 161718 AND UP. <div>21</div> F/A-18A 161728 THRU 161731. <div>22</div> 161925 AND UP. <div>23</div> F/A-18B 161354 AND UP. <div>24</div> 161353 THRU 161924. <div>25</div> 161925 THRU 161979. <div>26</div> 161980 AND UP. <div>27</div> 161353 THRU 161359, 161361 AND 161362. <div>28</div> 161360, 161363 THRU 161979. <div>29</div> F/A-18B 161354 THRU 161360 AND 162402 AND UP. <div>30</div> F/A-18B 161704 THRU 161947. <div>31</div> F/A-18A 161353 THRU 161944. <div>32</div> F/A-18A 161945 AND UP. <div>33</div> F/A-18B 161354 THRU 161943. <div>34</div> F/A-18B 161947 AND UP. <div>35</div> 161980 THRU 162431.				

Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
36			162432 AND UP.	
37			161353 THRU 162395, 162411 AND UP.	
38			162396 THRU 162410.	
39			F/A-18A 161353.	
40			F/A-18A 161358 THRU 161526.	
41			F/A-18A 161702 THRU 162414.	
42			F/A-18A 162415 THRU 162881.	
43			F/A-18B 161354, 161355, 161707 THRU 162413.	
44			F/A-18B 161356 THRU 161360.	
45			F/A-18B 162419 AND UP.	
46			161520 THRU 161761 BEFORE F/A-18 AFC 22; 161353 THRU 161519 AFTER F/A-18 AFC 27.	
47			161353 THRU 162414.	
48			162415 AND UP.	
49			161353 THRU 161519 BEFORE F/A-18 AFC 22 OR F/A-18 AFC 27.	
50			161520 THRU 162880.	
51			162881 AND UP.	
52			F/A-18A 162882 AND UP.	
53			F/A-18A 162415 AND UP.	
54			161520 AND UP; ALSO 161353 THRU 161519 AFTER F/A-18 AFC 27.	

Figure 1. Upper Floor (Y204.5 - Y260.6) Material Index (Sheet 8)



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Figure 2. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18A (Sheet 1)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>4</div> <div>10</div> <div>18</div> <div>19</div>	Web 74A314397-2165 74A314397-2191 74A314397-2199 74A314397-2267	0.071 Sheet	7075-T6 Alclad
2	<div>20</div> <div>19</div>	Plenum Assy 74A314457-1001, -1002 74A314457-1003, -1004	Sheet	6061-T62 Al Aly
3		Splice Plate 74A314397-2103	0.160 Sheet	7075-T76 Alclad
4		Angle 74A314397-2159	0.063 Sheet	7075-T6 Alclad
5	<div>4</div> <div>21</div> <div>19</div>	Bracket 74A314397-2151, -2152 74A314397-2187, -2188 74A314397-2187, -2261	0.063 Sheet	7075-T6 Alclad
6	<div>5</div>	Channel 74A314397-2177	0.071 Sheet	7075-T6 Alclad
7	<div>4</div>	Angle 74A314397-2157	0.100 Sheet	7075-T76 Alclad
8	<div>4</div>	Channel 74A314397-2155	0.071 Sheet	7075-T6 Alclad
9	<div>5</div>	Channel 74A314397-2181	0.071 Sheet	7075-T6 Alclad
10	<div>4</div> <div>21</div> <div>19</div>	Stiffener 74A314020-2035, -2036 74A314020-2035, -2083 74A314020-2035, -2104	0.063 Sheet	7075-T6 Alclad
11	<div>4</div> <div>21</div> <div>19</div>	Doubler 74A314397-2077 74A314397-2183 74A314397-2275	0.125 Sheet <div>2</div>	7075-T76 Alclad
12	<div>20</div> <div>19</div>	Doubler 74A314397-2069 74A314397-2277	0.190 Sheet <div>3</div>	7075-T76 Alclad
13	<div>4</div> <div>21</div> <div>19</div>	Web 74A314397-2163 74A314397-2185 74A314397-2245	0.071 Sheet	7075-T6 Alclad

Figure 2. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18A (Sheet 2)























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
14	 	Splice Plate 74A314397-2173 74A314397-2279	0.160 Sheet	7076-T 76 Alclad
15	 	Channel 74A314397-2179 74A314397-2237	0.071 Sheet	7075-T6 Alclad
16	 	Support 74A314647-1001 74A314647-1003	0.500 Plate Forging	7075-T7351 Al Aly 7075-T73 Al Aly
17		Bearing M27645-5A		Steel Fed-Std -66
18		Doubler 74A314397-2147	0.090 Sheet	7075-T76 Alclad
19	   	Web 74A314607-2037 74A314607-2071 74A314607-9021 74A314607-2095	 Sheet	7075-T6 Alclad
20	 	Doubler 74A314397-2147 74A314397-2257	0.090 Sheet	7075-T76 Alclad
21		Doubler 74A314397-2149	0.050 Sheet	7075-T6 Alclad
22	  	Channel 74A314231-2030, -2071 74A314231-2030, -9019 74A314231-2030, -2071	0.090 Sheet	7075-T76 Alclad
23		Support 74A314397-2109	0.071 Sheet	7075-T6 Alclad
24	 	Doubler 74A314397-2115 74A314397-2201	0.063 Sheet	7075-T6 Alclad
25	   	Channel 74A314231-2042, -2053 74A314231-9015, -2101 74A314231-2104, -2101 74A314231-2106, -2101	0.090 Sheet	7075-T76 Alclad

Figure 2. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18A (Sheet 3)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
26	4 21 19	Channel 74A314231-2024 74A314231-2098 74A314231-2121	0.090 Sheet	7075-T76 Alclad
27		Angle 74A314231-2074, -2073	0.063 Sheet	7075-T6 Alclad
28		Tee 74A314231-2016, -2015	1MA160D01-10218 Extr	7075-T73 Al Aly
29	12 18 24 27	Support 74A314394-2010, -2009 74A314394-2012, -2011 74A314394-2013, -2014 74A314394-2013, -2018	1MA160D05-10408 Extr 1MA160D05-10514 Extr	7075-T73511 Al Aly
30	20 19	Support 74A314653-2009 74A314653-2019	Pressing	7075-T73 Al Aly
31		Support 74A314626-1003	3.25 Plate	6Al-4V Ti Aly
32	29 30 28 27	Support 74A314654-2007 74A314654-2017 74R310035-2005 74A314654-2027	Pressing	7075-T73 Al Aly
33	22 23	Support 74A314397-2129 74A314397-2229	0.063 Sheet 0.050 Sheet	7075-T6 Alclad 7075-T6 Alclad
34	14 15 23	Support 74A314397-2131 74A314397-2213 74A314397-2227	0.063 Sheet	7075-T6 Alclad
35		Channel 74A314231-2057	0.063 Sheet	7075-T6 Alclad
36	4 21 19	Channel 74A314231-2075 74A314231-2099 74A314231-2117	0.090 Sheet	7075-T76 Alclad
37		Channel 74A314231-2055	0.063 Sheet	7075-T6 Alclad
38		Bracket 74A314231-2064	0.063 Sheet	7075-T6 Alclad

Figure 2. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18A (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
39		Bracket 74A314231-2065	0.063 Sheet	7075-T6 Alclad
40		Bracket 74A314231-2063	0.063 Sheet	7075-T6 Alclad
41	<div>8</div> <div>9</div> <div>13</div>	Channel 74A314231-2083 74A314231-9021 74A314231-2083	0.050 Sheet	7075-T6 Alclad

LEGEND

- 1

 Lands are 0.063 and bays are 0.029.
- 2

 Lands are 0.125 around holes and other area is 0.071.
- 3

 Basic part is 0.190 with 0.140 on each side.
- 4

 F/A-18A 161353 THRU 161528.
- 5

 F/A-18A 161702 AND UP.
- 6

 F/A-18A 161702 THRU 161736.
- 7

 F/A-18A 161737 THRU 161987.
- 8

 F/A-18A 161353 THRU 161705.
- 9

 F/A-18A 161706 THRU 161968.
- 10

 F/A-18A 161702 THRU 161987.
- 11

 F/A-18A 162394 AND UP.
- 12

 F/A-18A 161353 THRU 161987.
- 13

 F/A-18A 161969 AND UP.
- 14

 F/A-18A 161353 THRU 161959.
- 15

 F/A-18A 161960 THRU 162863.
- 16

 F/A-18A 161353 THRU 162444.
- 17

 F/A-18A 162445 AND UP.
- 18

 F/A-18A 162394 THRU 162909.
- 19

 F/A-18A 163092 AND UP.
- 20

 F/A-18A 161353 THRU 162909.
- 21

 F/A-18A 161702 THRU 162909.
- 22

 F/A-18A 161353 THRU 162863.
- 23

 F/A-18A 162865 AND UP.
- 24

 F/A-18A 163092 THRU 163145.
- 25

 F/A-18A 163146 THRU 163169.
- 26

 F/A-18A 163170 AND UP.
- 27

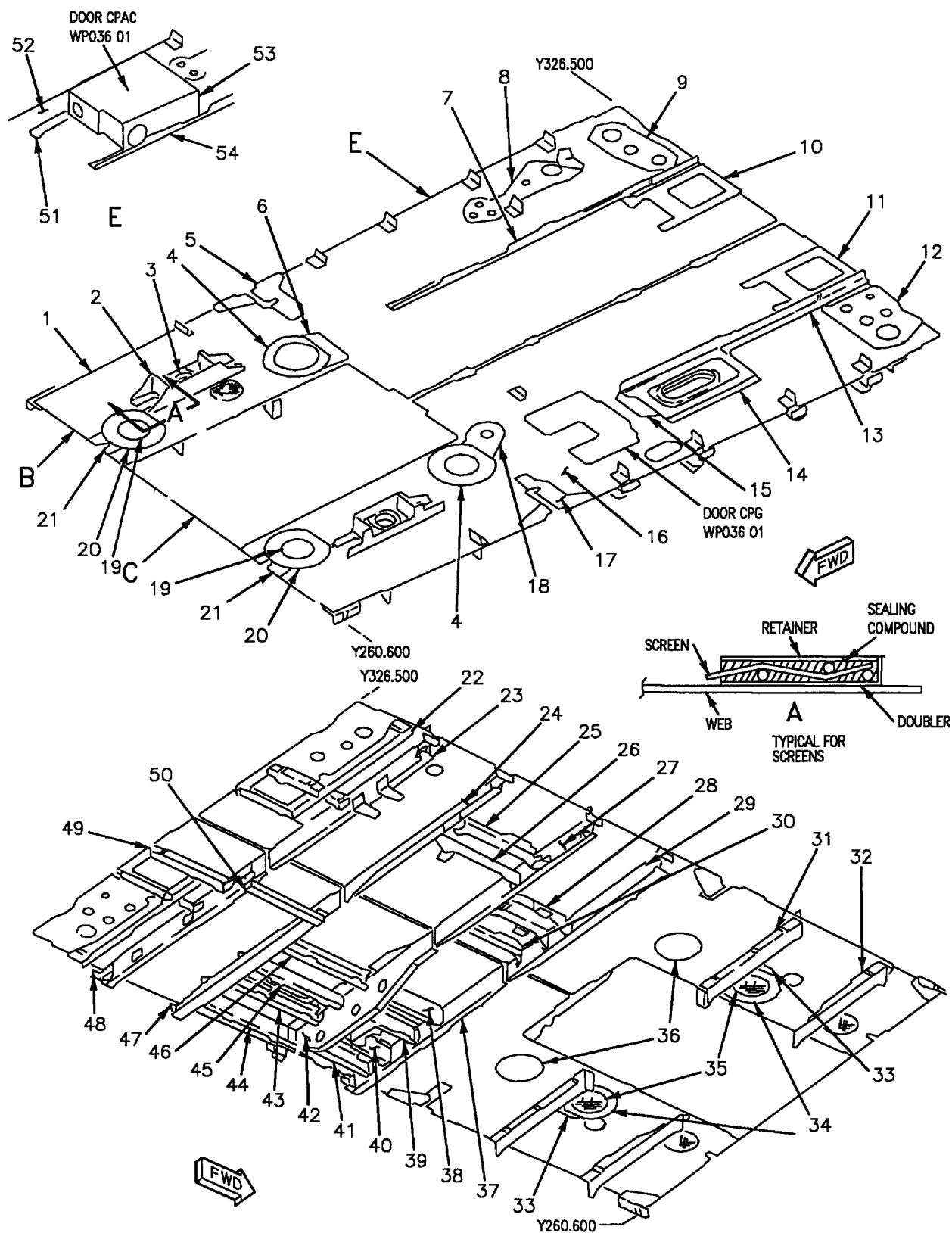
 F/A-18A 163146 AND UP.
- 28

 F/A-18A 161353 THRU 163145 AFTER F/A-18 AFC 78.
- 29

 F/A-18A 161353 THRU 162909 BEFORE F/A-18 AFC 78.
- 30

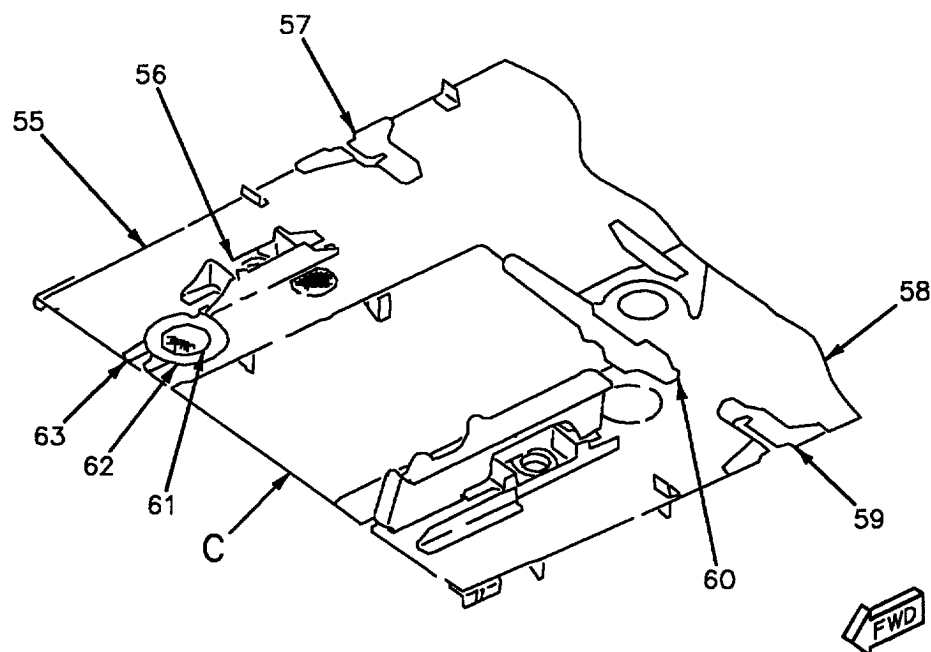
 F/A-18A 163092 THRU 163145 BEFORE F/A-18 AFC 78.

Figure 2. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18A (Sheet 5)



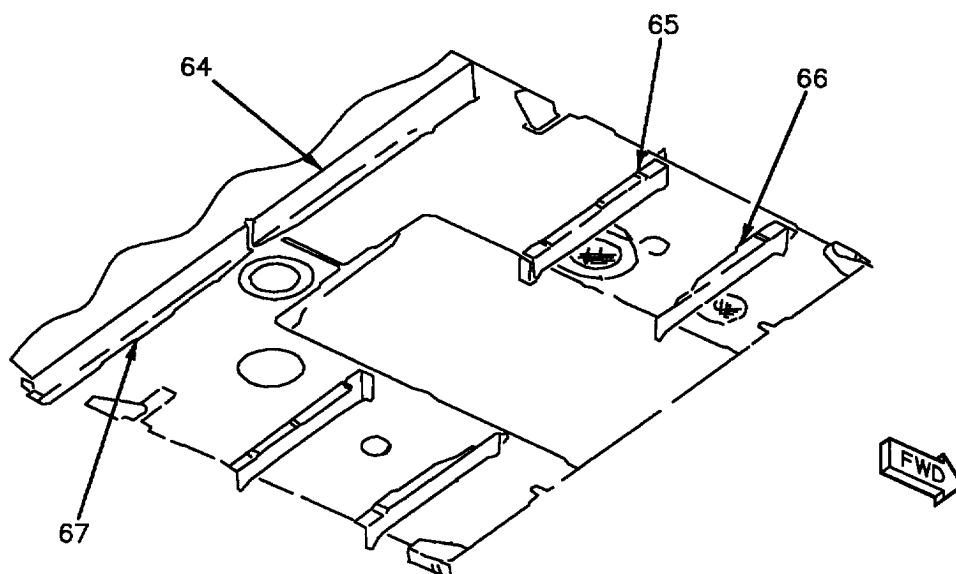
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Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 1)



F/A-18B 163104 AND UP

B



18AC-SRM-222-(3-2)01-SCAN

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 2)

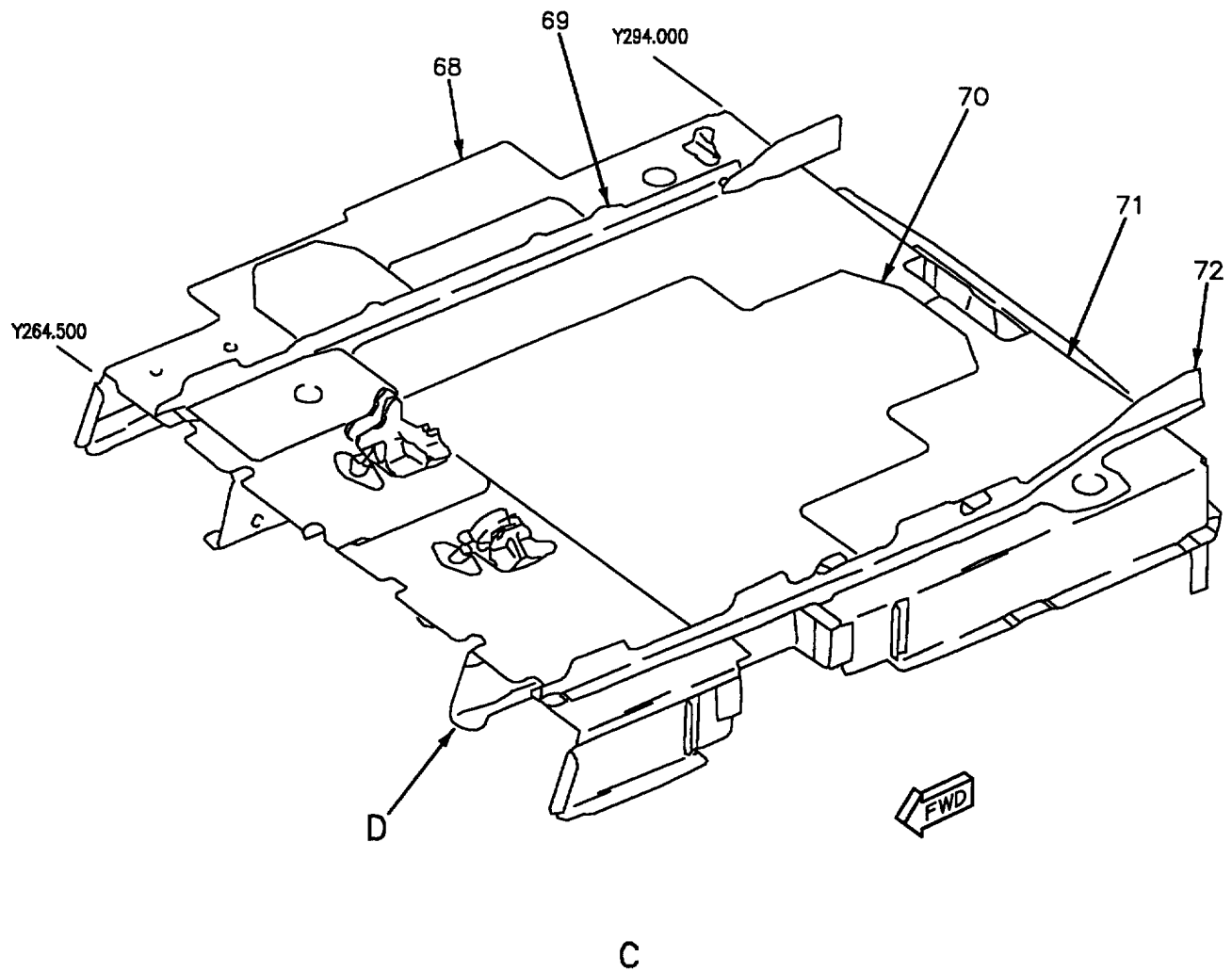


Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 3)

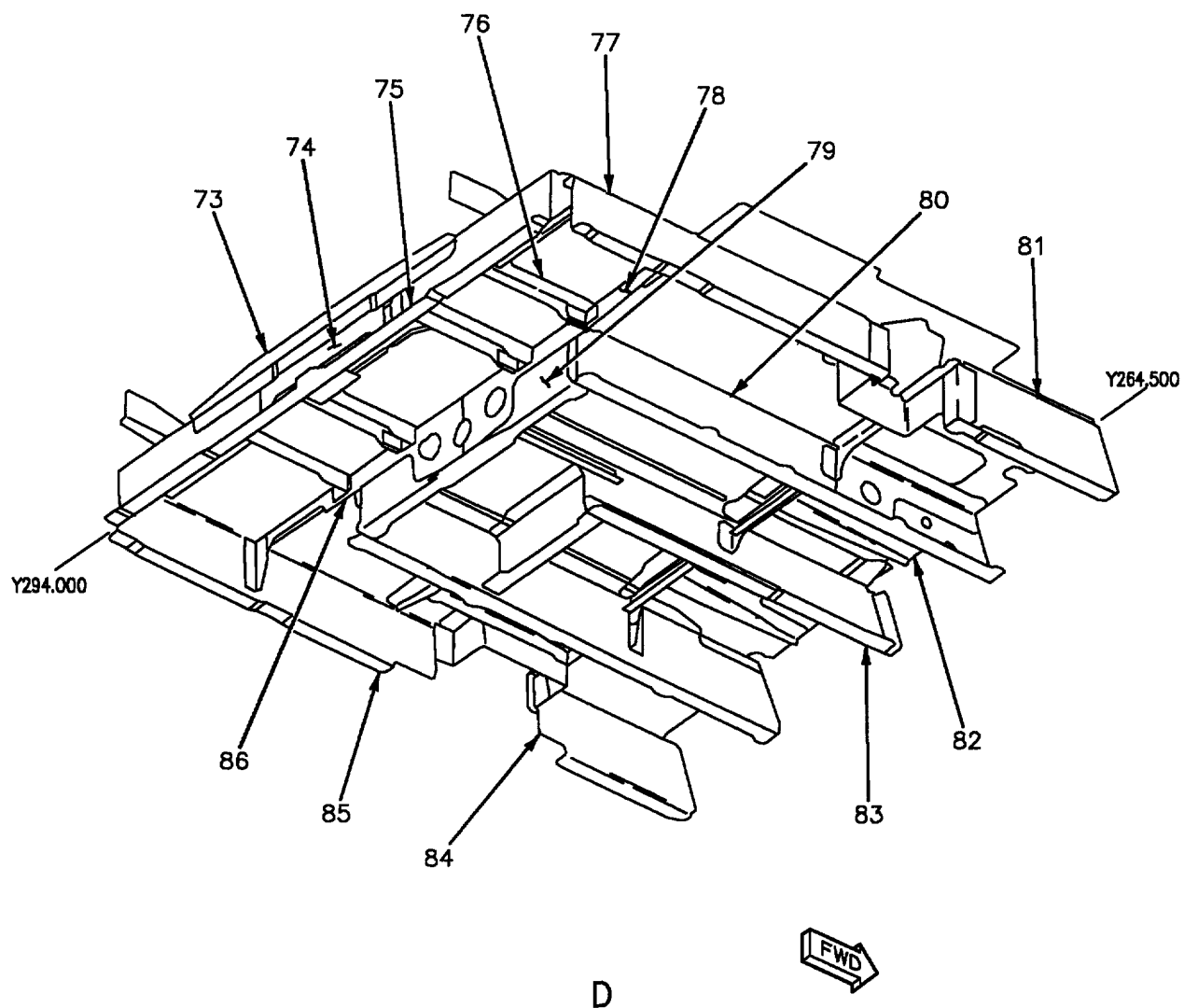


Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>1</div> <div>15</div> <div>18</div>	Web 74A314818-2055 74A314818-2093 74A314818-2109	0.071 Sheet	7075-T6 Alclad
2	<div>16</div>	Support 74A314866-2004, -2003	2.00 Plate	7075-T7351 Al Aly
3		Bearing MS27645-10	-	Steel Fed-Std -66
4	<div>16</div>	Retainer 74A314397-2021	0.040 Sheet	7075-T6 Alclad
5	<div>16</div>	Splice Plate 74A314818-2057	0.160 Sheet	7075-T76 Alclad
6	<div>16</div>	Doubler 74A314397-2019	0.050 Sheet	7075-T6 Alclad
7	<div>13</div>	Angle 74A314868-2011	0.071 Sheet	7075-T6 Alclad
8		Doubler 74A314818-2037	0.071 Sheet	7075-T6 Alclad
9	<div>1</div> <div>19</div>	Doubler 74A314818-2033 74A314818-2091	0.071 Sheet	7075-T6 Alclad
10	<div>2</div> <div>1</div>	Doubler 74A314915-2011 74A314915-2019	0.071 Sheet 0.160 Sheet	7075-T6 Alclad 7075-T76 Alclad
11		Doubler 74A314915-2011	0.071 Sheet	7075-T76 Alclad
12	<div>16</div>	Doubler 74A314818-2075	0.071 Sheet	7075-T6 Alclad
13	<div>10</div> <div>9</div>	Angle 74A314818-2073 74A314818-2115	0.071 Sheet	7075-T6 Alclad
14		Doubler 74A314818-2069	0.100 Sheet	7075-T76 Alclad
15		Doubler 74A314818-2071	0.100 Plate	7075-T6 Alclad
16	<div>16</div>	Web 74A314818-2081	0.071 Sheet	7075-T6 Alclad

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 5)















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
17		Doubler 74A314818-2011	0.160 Sheet	7075-T76 Alclad
18		Doubler 74A314818-2041	0.071 Sheet	7075-T6 Alclad
19		Screen 74A314397-2009	0.025 Dia Wire 5.00 x 5.00	304 Cres
20		Retainer 74A314397-2005	0.040 Sheet	7075-T6 Alclad
21		Doubler 74A314397-2007	0.050 Sheet	7075-T6 Alclad
22		Angle 74A314915-2002, -2017	0.090 Sheet	7075-T76 Alclad
23		Channel 74A314817-2012 74A314817-2074	0.090 Sheet	7075-T76 Alclad
24		Support 74A314817-2038 74A314817-2072	0.090 Sheet	7075-T76 Alclad
25		Support 74A314867-2002	0.080 Sheet	7075-T6 Alclad
26		Support 74A314867-2001	0.080 Sheet	7075-T6 Alclad
27		Channel 74A314817-2036 74A314817-2078	0.090 Sheet	7075-T76 Alclad
28		Channel 74A314861-2005 74A314861-2007	0.063 Sheet	7075-T6 Alclad
29		Channel 74A314817-2034 74A314817-2076	0.090 Sheet	7075-T76 Alclad
30		Support 74A314818-2049 74A314397-2227	0.063 Sheet	7075-T6 Alclad
31		Angle 74A314817-2004, -2003	0.063 Sheet	7075-T6 Alclad
32		Tee 74A314817-2002, -2001	1MA160D01-10218 Extr	7075-T73 Al Aly

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 6)


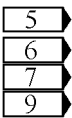

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
33		Doubler 74A314818-2007	0.050 Sheet	7075-T6 Alclad
34		Retainer 74A314818-2009	0.040 Sheet	7075-T6 Alclad
35		Screen 74A314818-2005	8 Mesh, 0.025 Dia Wire 4.44 x 4.60	304 Cres
36		Screen 74A314397-2017	8 Mesh, 0.025 Dia Wire 4.80 x 5.00	304 Cres
37		Channel 74A314817-2039 74A314817-2065	0.090 Sheet 0.125 Sheet	7075-T76 Alclad
38		Channel 74A314817-2051	0.063 Sheet	7075-T6 Alclad
39		Channel 74A314817-2049	0.063 Sheet	7075-T6 Alclad
40		Channel 74A314817-2047	0.063 Sheet	7075-T6 Alclad
41		Channel 74A314817-2045	0.063 Sheet	7075-T6 Alclad
42		Support 74A314927-2003 74A314927-9003 74A314927-9005 74A314927-2003	3.50 Plate	7075-T7351 Al Aly
43		Channel 74A314817-2041	0.063 Sheet	7075-T6 Al Aly
44		Channel 74A314817-2043	0.063 Sheet	7075-T6 Alclad
45		Channel 74A314817-2042	0.063 Sheet	7075-T6 Alclad
46		Channel 74A314817-2044	0.063 Sheet	7075-T6 Alclad
47		Support 74A314929-2001 74A314929-9001 74A314929-2001	2.00 Sheet	7075-T76 Alclad

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
48		Channel 74A314817-2057	0.090 Sheet	7075-T76 Alclad
49		Angle 74A314915-2013, -2014	0.080 Sheet	7075-T6 Alclad
50		Bracket 74A314231-2087	0.071 Sheet	7075-T6 Alclad
51	14	Angle 74A314818-2105	0.071 Sheet	075-T6 Alclad
52	9	Web 74A314818-2109	0.071 Sheet	7075-T6 Alclad
53	14	Enclosure 74A620057-2001	0.032 Sheet	7075-T6 Alclad
54	14	Angle 74A314818-2107	0.071 Sheet	7075-T6 Alclad
55	17	Web 74A314818-2125	0.125 Sheet	7075-T76 Alclad
56	17	Support 74A314866-2009, 2007	2.00 Plate	7075-T7351 Alclad
57	17	Splice Plate 74A314818-2137	0.160 Sheet	7075-T76 Alclad
58	17	Web 74A314818-2129	0.125 Sheet	7075-T76 Alclad
59	17	Doubler 74A314818-2139	0.160 Sheet	7075-T76 Alclad
60	17	Splice Plate 74A314818-2131	0.125 Sheet	7075-T76 Alclad
61 R	17	Screen 74A314397-2009	0.025 Dia Wire 5.00 x 5.00	304 Cres
62 R	17	Retainer 74A314397-2005	0.040 Sheet	7075-T6 Alclad
63 R	17	Doubler 74A314397-2007	0.050 Sheet	7075-T6 Alclad
64	17	Channel 74A314817-2083	0.090 Sheet	7075-T6 Alclad

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 8)














IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
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66		Tee 74A314817-2002, 2085	1MA160D01-10218 Extr	7075-T73 Al Aly
67		Channel 74A314817-2081	0.125 Sheet	7075-T76 Alclad
68	 	Cover 74A314888-2073 74A314888-2089	0.040 Sheet	7075-T6 Alclad
69		Angle 74A314888-2055	0.063 Sheet	7075-T6 Alclad
70	 	Cover 74A314889-2001 74A314889-2003	0.100 Sheet	7075-T6 Alclad
71		Cover 74A314888-2071	0.040 Sheet	7075-T6 Alclad
72		Angle 74A314888-2079	0.040 Sheet	7075-T6 Alclad
73		Angle 74A314909-2015	0.040 Sheet	7075-T6 Alclad
74		Angle 74A314909-2013	0.040 Sheet	7075-T6 Alclad
75		Angle 74A314909-2009	0.040 Sheet	7075-T6 Alclad
76		Angle 74A314888-2066, -2065	0.040 Sheet	7075-T6 Alclad
77	 	Zee 74A314885-2021 74A314885-2043	0.040 Sheet	7075-T6 Alclad
78	 	Angle 74A314887-2019 74A314887-2029	0.063 Sheet	7075-T6 Alclad
79	 	Angle 74A314887-2021 74A314887-2027	0.040 Sheet	7075-T6 Alclad

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 9)

































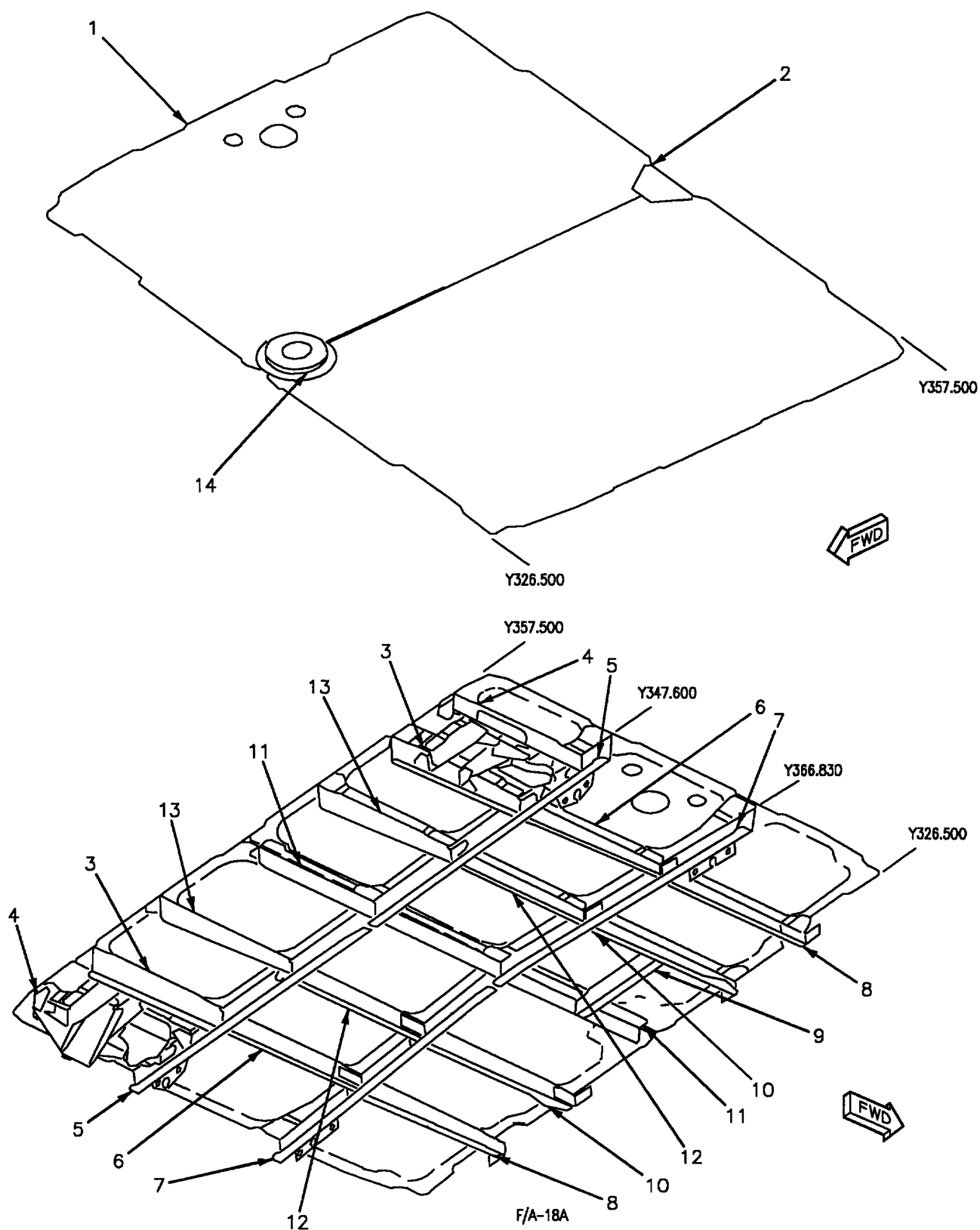
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
80	 	Zee 74A314884-2008, -2007 74A314884-2013, -2014	0.040 Sheet	7075-T6 Alclad
81	 	Angle 74A314885-2033 74A314885-2053	0.040 Sheet	7075-T6 Alclad
82		Channel 74A314888-2029, -2027	0.040 Sheet	7075-T6 Alclad
83	 	Support 74A314886-2011 74A314886-2013	0.040 Sheet	7075-T6 Alclad
84	 	Support 74A314885-2027 74A314885-2045	0.040 Sheet	7075-T6 Alclad
85		Cover 74A314888-2071	0.040 Sheet	7075-T6 Alclad
86	 	Angle 74A314887-2017 74A314887-2031	0.063 Sheet	7075-T6 Alclad
LEGEND				
 F/A-18B 161354 THRU 161360.  F/A-18B 161704 AND UP.  F/A-18B 161354 THRU 161932.  F/A-18B 162402 AND UP.  F/A-18B 161354 THRU 161714.  F/A-18B 161719 THRU 161733.  F/A-18B 161740 THRU 161924.  F/A-18B 161719 THRU 161924.  F/A-18B 161932 AND UP.  F/A-18B 161354 THRU 161924.  F/A-18B 161938 THRU 162885.  F/A-18B 161354 THRU 161947.  F/A-18B 161354 THRU 161924 BEFORE F/A-18 AFC 22.  F/A-18B 161932 AND UP; ALSO 161354 THRU 161924 AFTER F/A-18 AFC 22.  F/A-18B 161704 THRU 161924.  F/A-18B 161354 THRU 162885.  F/A-18B 163104 AND UP.  F/A-18B 161932 THRU 162885.  F/A-18B 161704 THRU 162885.  F/A-18B 161354 THRU 162864.  F/A-18B 162870 AND UP.  F/A-18B 162870 THRU 162885.				

Figure 3. Upper Floor (Y260.6 - Y326.5) Material Index, F/A-18B (Sheet 10)



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Figure 4. Upper Floor (Y326.5 - Y357.5) Material Index (Sheet 1)

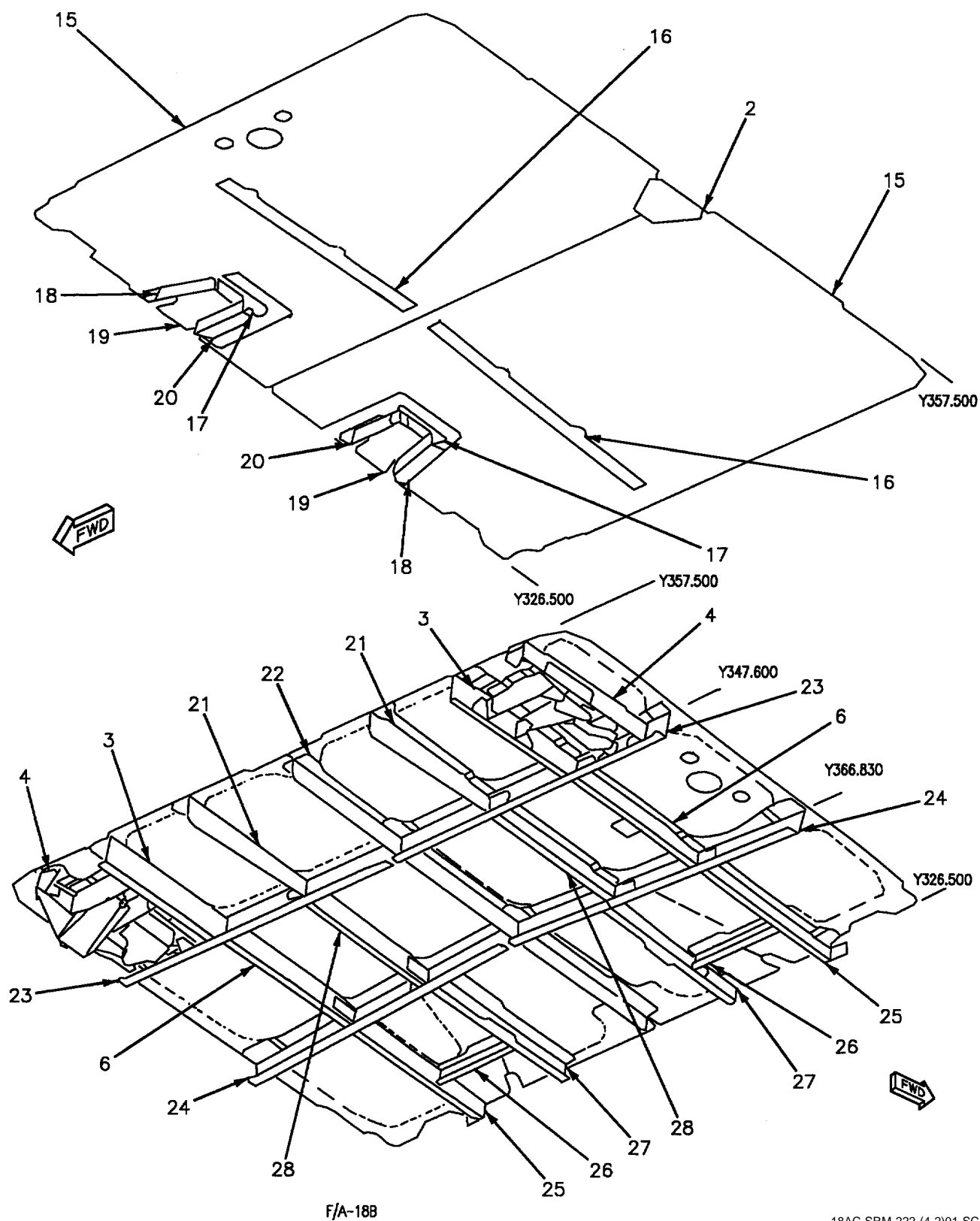


Figure 4. Upper Floor (Y326.5 - Y357.5) Material Index (Sheet 2)






















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Web		
R		74A314293-2038	0.063 Sheet	7075-T6 Alclad
R		74A314293-9013	0.090 Sheet	7070-T76 Alclad
R		74A314293-2045	0.090 Sheet	7075-T76 Alclad
L		74A314293-2037	0.063 Sheet	7075-T6 Alclad
2		Doubler		
		74A314293-2017	0.100 Sheet	7075-T76 Alclad
3		Bracket		
		74A314630-2001, -2002	0.063 Sheet	7075-T6 Alclad
4		Bracket		
		74A314630-2025, -2026	0.050 Sheet	7075-T6 Alclad
5		Support		
L		74A314295-2011	0.090 Sheet	7075-T76 Alclad
L		74A314295-2025		
R		74A314295-2022		
R		74A314295-2033		
6		Support		
L		74A314293-2009	0.050 Sheet	7075-T76 Alclad
R		74A314293-2010	0.050 Sheet	7075-T76 Alclad
R		74A314293-2051	0.090 Sheet	7075-T76 Alclad
R		74A314293-2071		
7		Support		
L		74A314295-2019	0.090 Sheet	7075-T76 Alclad
L		74A314295-2027		
L		74A314295-2029		
R		74A314295-2024		
		74A314295-2030		
8		Support		
L		74A314293-2029	0.050 Sheet	7075-T6 Alclad
L		74A314293-9007		
L		74A314293-2043		
R		74A314293-2030		
9		Support		
R		74A314293-2061	0.040 Sheet	7075-T6 Alclad
10		Support		
L		74A314293-2027	0.050 Sheet	7075-T6 Alclad
R		74A314293-2028		
R		74A314293-2066		

Figure 4. Upper Floor (Y326.5 - Y357.5) Material Index (Sheet 3)






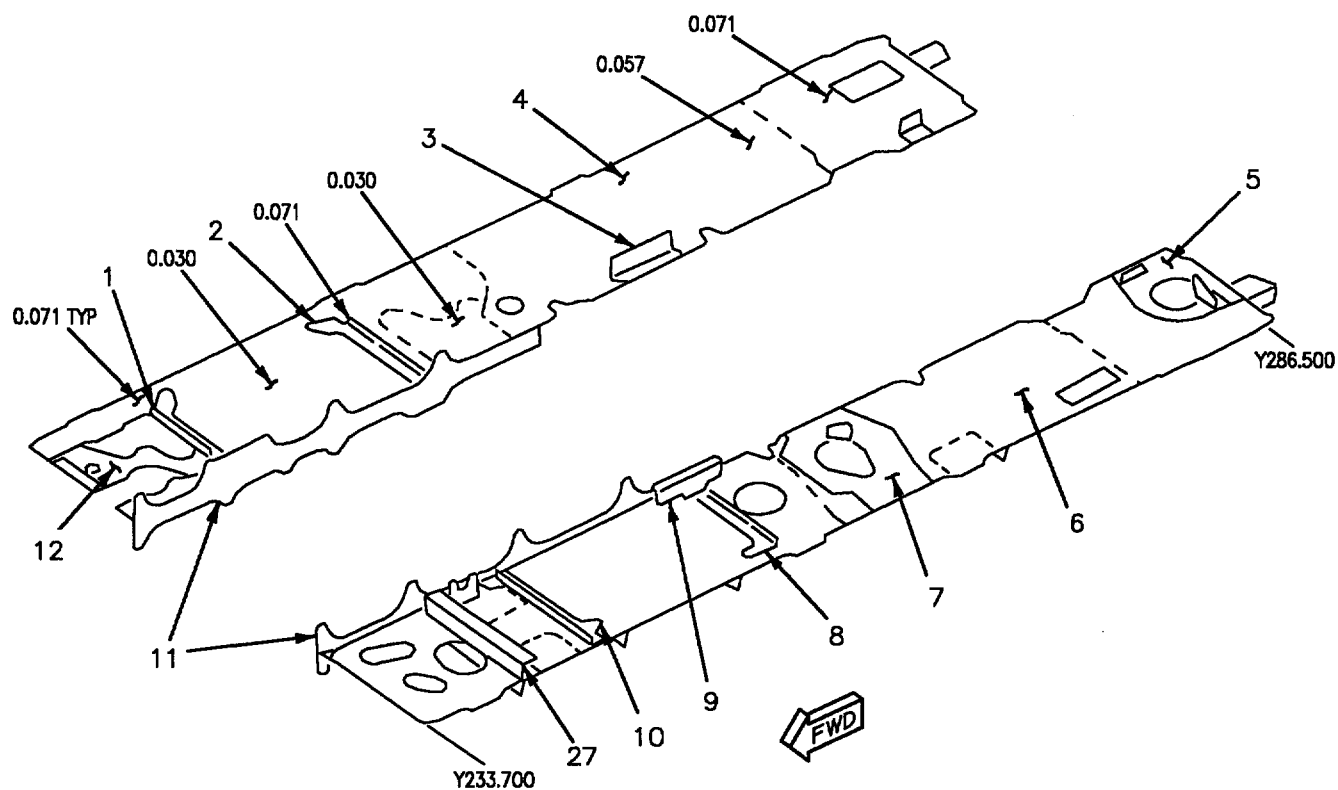
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
11		Longeron 74A314384-2003 74A314384-2007	1MA160D06-10395 Extr	7075-T76511 Al Aly
12		Support		
L		74A314293-2007	0.050 Sheet	7075-T6 Alclad
R		74A314293-2008	0.050 Sheet	7075-T6 Alclad
R		74A314293-2047	0.090 Sheet	7075-T76 Alclad
13		Support 74A314293-2011, -2012	0.063 Sheet	7075-T6 Alclad
14		Support 74A582061-2005	4.75 Plate	2024-T851 Al Aly
15		Web		
L		74A314826-2051	0.063 Sheet	7075-T6 Alclad
R		74A314826-2052	0.063 Sheet	7075-T6 Alclad
R		74A314826-2057	0.090 Sheet	7075-T76 Alclad
16		Strap		
L		74A314826-2049	0.063 Sheet	7075-T6 Alclad
R		74A314826-2050		
R		74A314826-2065		
17		Support 74A314826-2041, -2042	0.080 Sheet	7075-T6 Alclad
18		Support 74A314826-2015, -2016	0.080 Sheet	7075-T6 Alclad
19		Doubler 74A314826-2003	0.080 Sheet	7075-T6 Alclad
20		Support 74A314826-2017, -2018	0.080 Sheet	7075-T6 Alclad
21		Stiffener		
L		74A314826-2043	0.063 Sheet	7075-T6 Alclad
R		74A314293-2012		
22		Longeron 74A314384-2005	1MA160D06-10395 Extr	7075-T76511 Al Aly
23		Support		
L		74A314825-2003	0.090 Sheet	7075-T76 Alclad
L		74A314825-2017		
R		74A314825-2008		

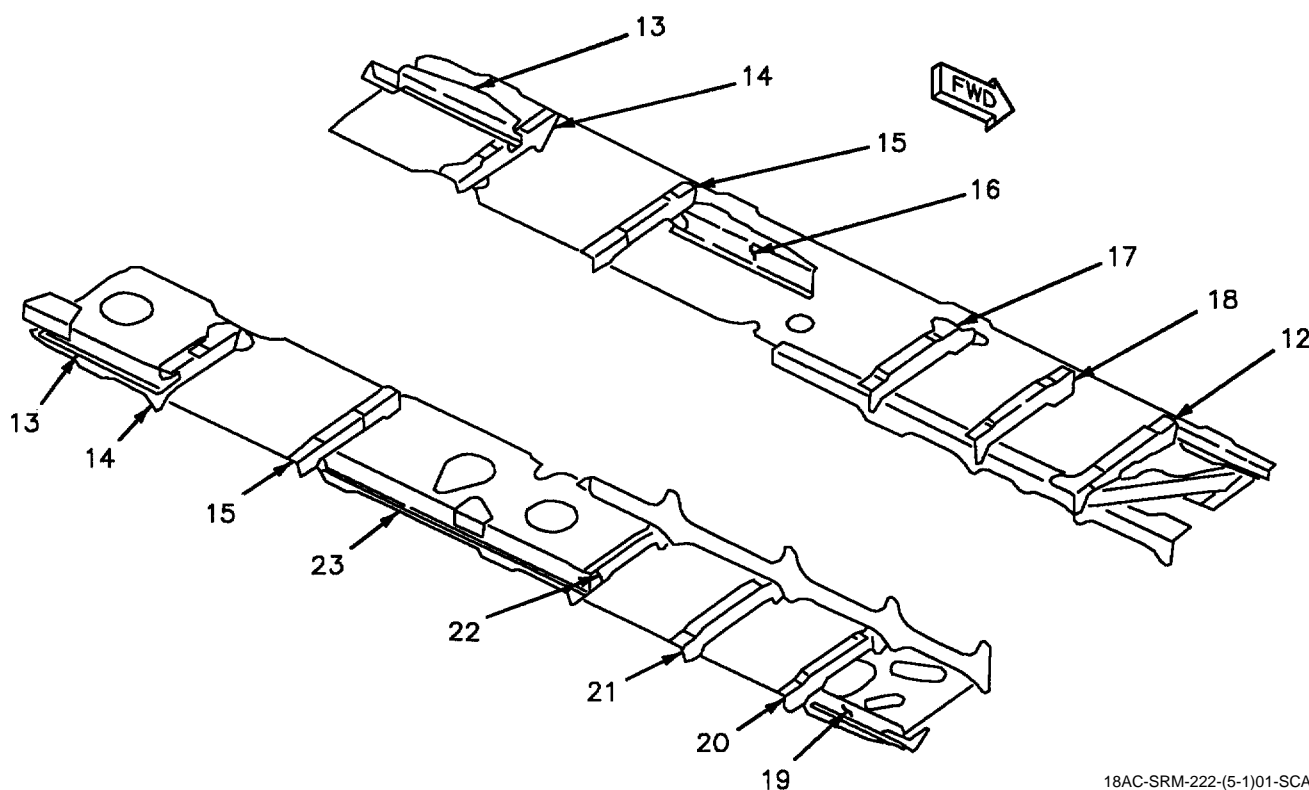
Figure 4. Upper Floor (Y326.5 - Y357.5) Material Index (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
24		Support		
L	12	74A314825-2011	0.080 Sheet	6Al-4V Ti Aly
L	13	74A314825-2019		
R		74A314825-2010		
25		Support		
		74A314826-2005, -2006	0.063 Sheet	7075-T6 Alclad
26		Support		
		74A314826-2011, -2012	0.080 Sheet	7076-T6 Alclad
27		Support		
L		74A314826-2039	0.080 Sheet	7075-T6 Alclad
R	12	74A314826-2008		
R	13	74A314826-2063		
28		Support		
L		74A314293-2007	0.080 Sheet	7075-T6 Alclad
R	12	74A314293-2008		
R	13	74A314293-2049		
LEGEND				
1		F/A-18A 161353 THRU 161987.		
2		F/A-18A 162396, 162398, 162400, 162403, 162405, 162406, 162409, 162411, 162414, 162415.		
3		F/A-18A 162394, 162395, 162397, 162399, 162401, 162404, 162407, 162410, 162412, 162416 AND UP.		
4		F/A-18A 161353 THRU 161528.		
5		F/A-18A 161702 AND UP.		
6		161353 THRU 161987.		
7		162394 THRU 162449.		
8		F/A-18A 161702 THRU 161987.		
9		F/A-18A 162394 AND UP.		
10		F/A-18A 161702 THRU 161724.		
11		F/A-18A 161725 AND UP.		
12		F/A-18B 161354 THRU 161947.		
13		F/A-18B 162402 AND UP.		
14		162450 AND UP.		
15		F/A-18A 161353 THRU 162880.		
16		F/A-18A 162881 AND UP.		

Figure 4. Upper Floor (Y326.5 - Y357.5) Material Index (Sheet 5)

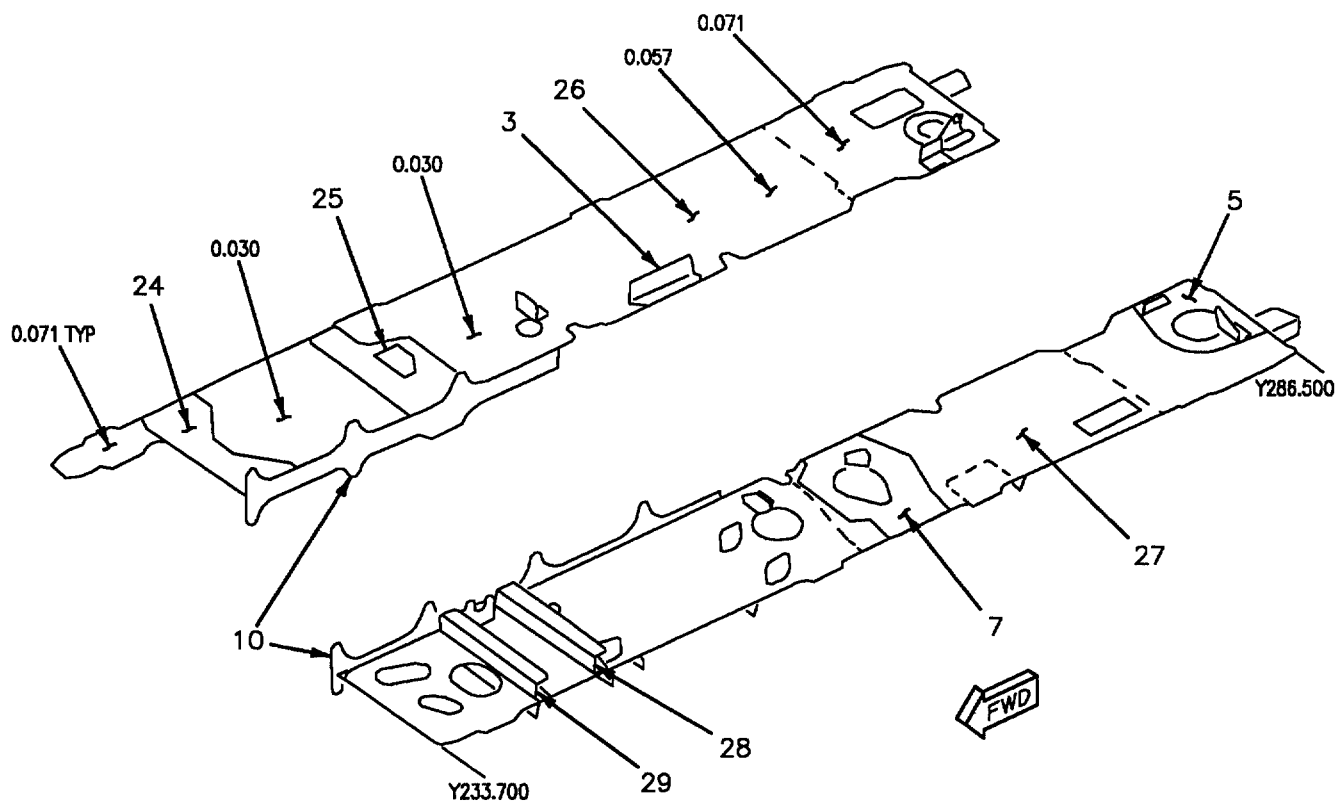


161353 THRU 161528

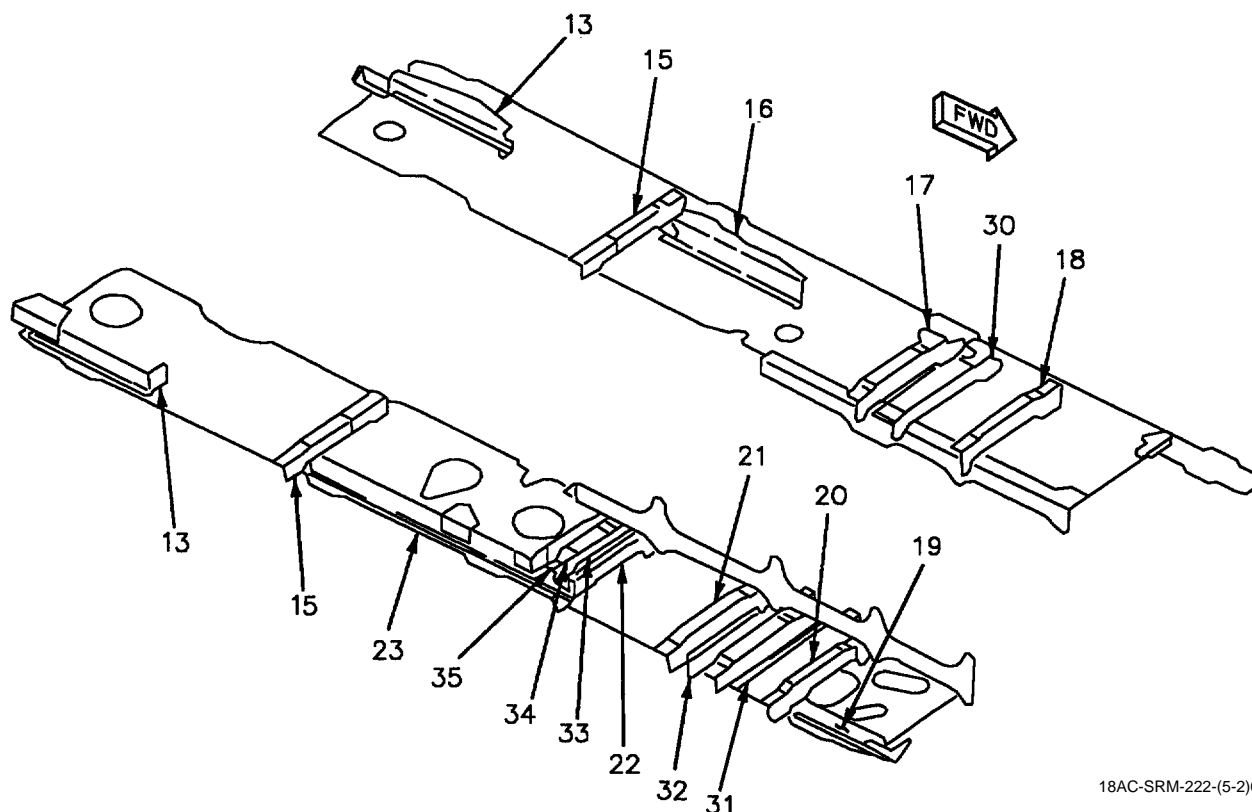


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Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 1)

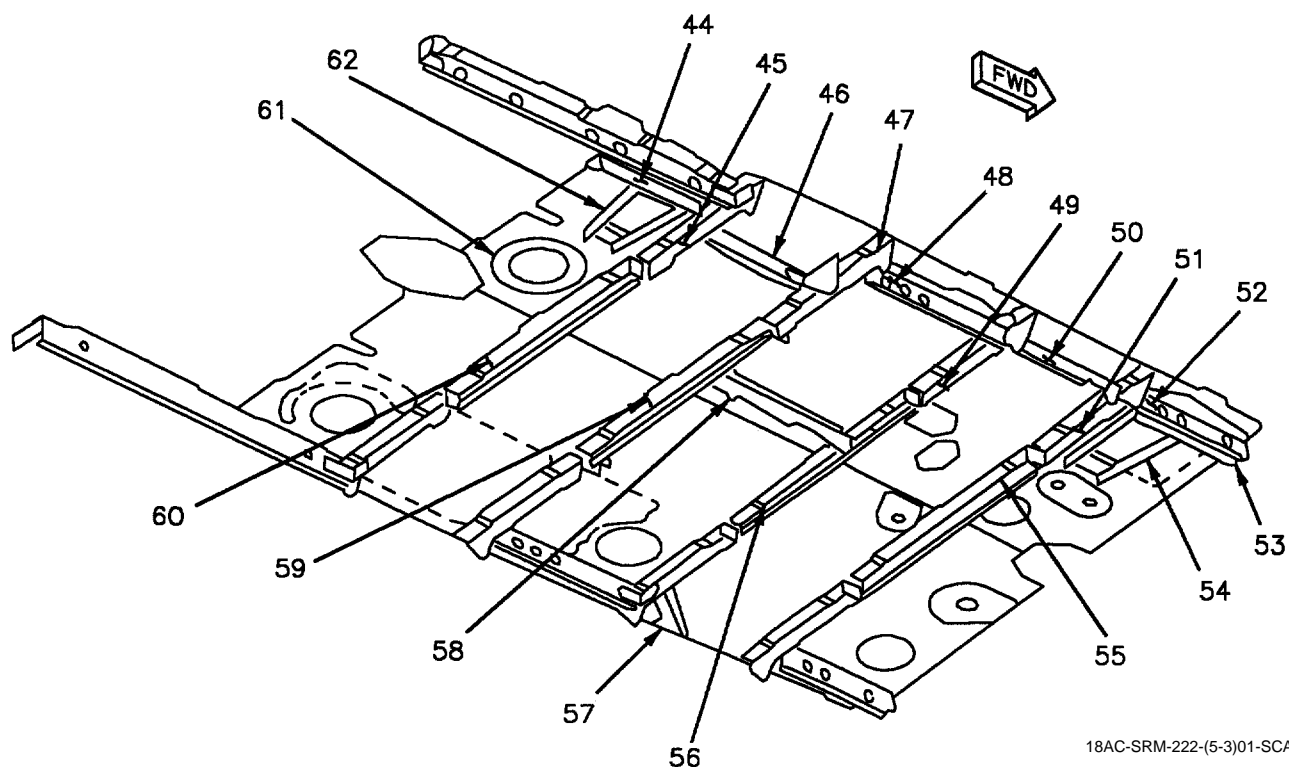
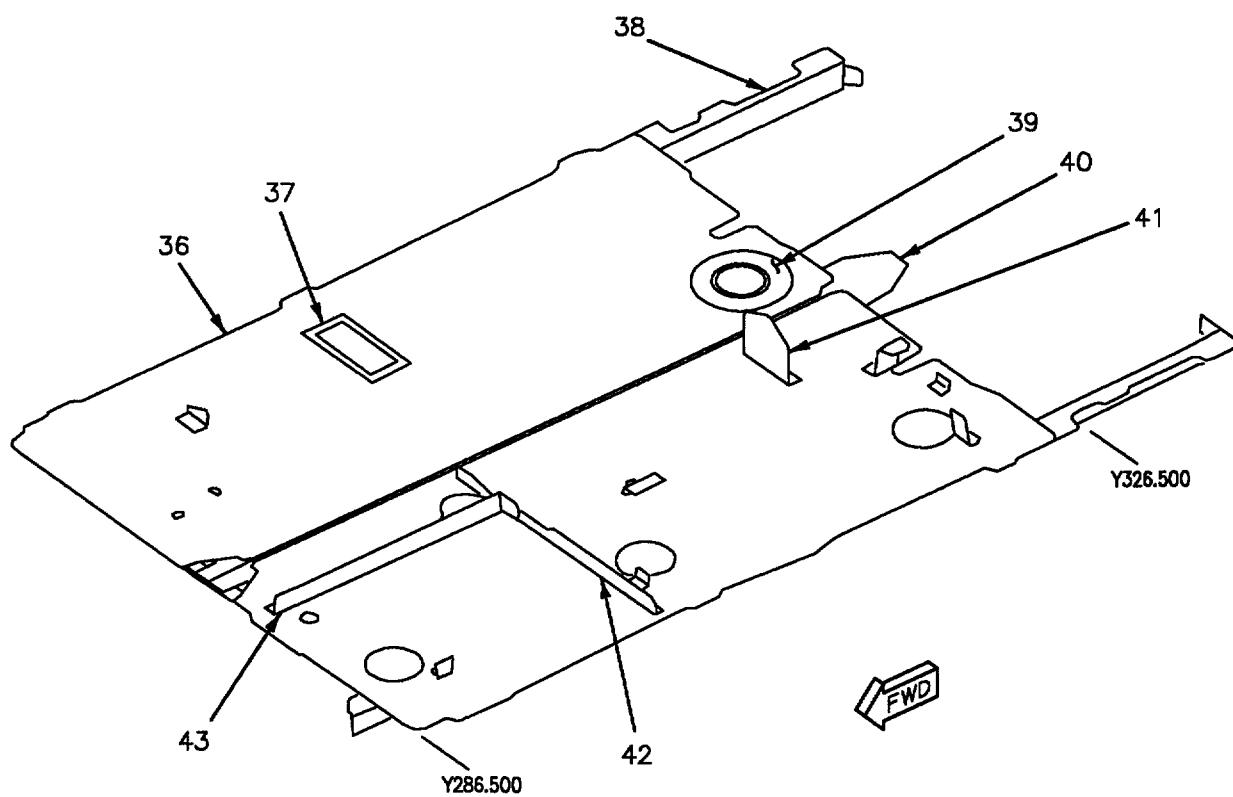


161702 AND UP



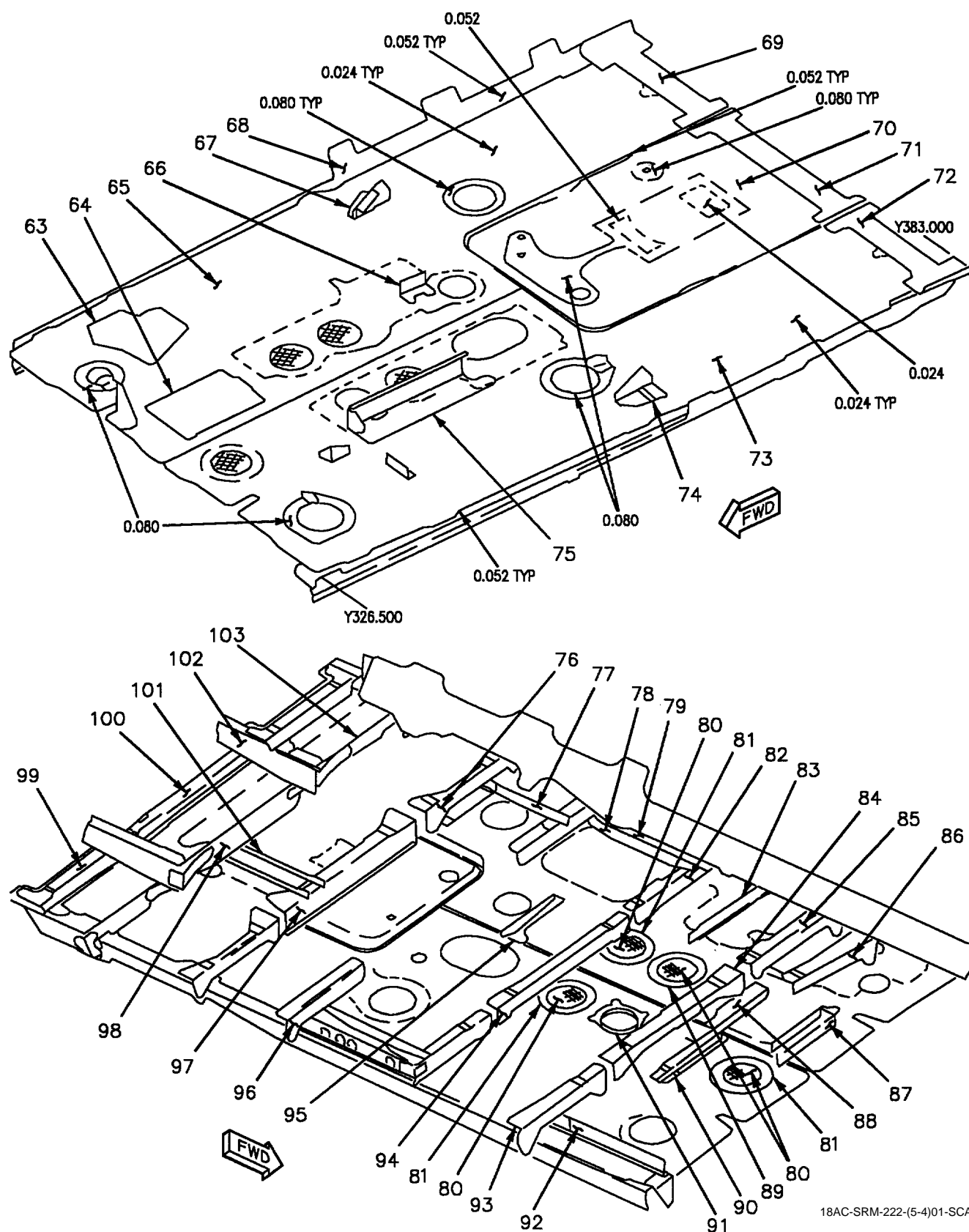
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Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 2)



18AC-SRM-222-(5-3)01-SCAN

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 3)
















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Support 74A314232-2083	0.040 Sheet	7075-T6 Alclad
2		Support 74A314232-2085	0.040 Sheet	7075-T6 Alclad
3		Bracket 74A314232-2105	1MA100D06-10044 Extr	7075-T76611 Al Aly
4		Web 74A314232-2093	0.071 Sheet	7076-T6 Alclad
5	 	Doubler 74A314232-2129 74A314232-2201	0.160 Plate	7075-T76 Al Aly
6		Web 74A314232-2123	0.071 Sheet	7075-T6 Alclad
7		Doubler 74A314232-2055	0.160 Plate	7075-T76 Al Aly
8		Support 74A314232-2087	0.040 Sheet	7075-T6 Alclad
9		Support 74A314232-2079	0.050 Sheet	7075-T6 Alclad
10	 	Support 74A314232-2089 74R310007-2057	0.040 Sheet	7075-T6 Alclad
11	 	Support 74A314236-2006, -2003 74A314236-2006, -2007	1MA160D05-10394 Extr	7075-T73511 Al Aly
12		Support 74A314420-2005	Pressing	7075-T73 Al Aly
13		Support 74A314232-2060, -2059	0.080 Sheet	7075-T6 Alclad
14		Plate 74A314227-2006, -2005	1MA160D05-10412 Extr	7075-T73511 Al Aly
15		Support 74A314232-2050, -2049	0.080 Sheet	7075-T6 Alclad
16	 	Support 74A314232-2103 74A314232-2193	1MA163D05-10009 Extr	7075-T73511 Al Aly

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 5)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
17	<div>2</div> <div>10</div> <div>11</div>	Support 74A314232-2095 74A314232-2141 74A314232-2185	1MA160D01-10242 Extr	7075-T76 Al Aly
18	<div>10</div> <div>11</div>	Support 74A314232-2045 74A314232-2181	0.050 Sheet	7075-T6 Alclad
19		Support 74A314232-2125	0.080 Sheet	7075-T6 Alclad
20	<div>13</div> <div>14</div> <div>9</div>	Support 74A314232-2005 74A314232-9105 74A314232-2187	0.080 Sheet	7075-T6 Alclad
21	<div>10</div> <div>11</div>	Support 74A314232-2043 74A314232-2179	0.063 Sheet	7075-T6 Alclad
22	<div>10</div> <div>11</div>	Support 74A314232-2047 74A314232-2183	0.063 Sheet	7075-T6 Alclad
23	<div>2</div> <div>3</div>	Support 74A314232-2099 74A314232-2161	0.080 Sheet	7075-T6 Alclad
24		Doubler 74A314232-2151	0.063 Sheet	7075-T6 Alclad
25	<div>10</div> <div>11</div>	Support 74A314232-2141 74A314232-2185	1MA160D01-10242 Extr	7075-T76 Alclad
26	<div>8</div> <div>30</div> <div>31</div>	Web 74A314232-2139 74A314232-2195 74A314232-2205	0.071 Sheet	7075-T6 Alclad
27	<div>8</div> <div>9</div>	Web 74A314232-2137 74A314232-2191	0.071 Sheet	7075-T6 Alclad
28	<div>34</div> <div>9</div>	Bracket 74R310007-2027 74A314233-2623	0.063 Sheet	7075-T6 Alclad
29	<div>32</div>	Bracket 74A314233-2617	0.063 Sheet	7075-T6 Alclad

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 6)
















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
30		Bracket 74A314232-2143	0.063 Sheet	7075-T6 Alclad
31	 	Angle 74A314233-2625 74A314233-2639	0.063 Sheet	7075-T6 Alclad
32	  	Support 74R310007-2045 74A314232-2155 74A314232-2197	0.063 Sheet	7075-T6 Alclad
33	  	Support 74R310007-2047 74A314232-2153 74A314232-2189	0.063 Sheet	7075-T6 Alclad
34	 	Doubler 74R310007-2051 74A314232-2171	0.032 Sheet	7075-T6 Alclad
35		Doubler 74A314232-2199	0.032 Sheet	7075-T6 Alclad
36		Web 74A314271-2179	0.071 Sheet	7075-T6 Alclad
37		Doubler 74A314271-2119	0.050 Sheet	7075-T6 Alclad
38		Support 74A314271-2061	0.071 Sheet	7075-T6 Alclad
39		Doubler 74A314271-2063	0.063 Sheet	7075-T6 Alclad
40		Splice 74A314271-2017	0.090 Sheet	7075-T76 Alclad
41	  	Support 74A314271-2103 74A314271-2104 74A314271-2195	0.063 Sheet	7075-T6 Alclad
42		Support 74A314271-2097	0.050 Sheet	7075-T6 Alclad
43	 	Angle 74A314271-2073 74A314271-2165	0.063 Sheet	7075-T6 Alclad
44		Angle 74A314271-2135	0.050 Sheet	7075-T6 Alclad

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
45		Support 74A314273-2021, -2054	0.071 Sheet	7075-T6 Alclad
46		Support 74A314271-2153	0.050 Sheet	7075-T6 Alclad
47		Support 74A314273-2024, -2023	0.071 Sheet	7075-T6 Alclad
48		Support 74A314271-2008, -2007	0.080 Sheet	7075-T6 Alclad
49		Support 74A314273-2026, -2025	0.071 Sheet	7075-T6 Alclad
50		Support 74A314271-2141	0.050 Sheet	7075-T6 Alclad
51		Support 74A314273-2036, -2027	0.071 Sheet	7075-T6 Alclad
52		Support 74A314271-2094, -2093	0.080 Sheet	7075-T6 Alclad
53		Angle 74A314271-2131	0.050 Sheet	7075-T6 Alclad
54		Channel 74A314271-2129	0.071 Sheet	7075-T6 Alclad
55		Support 74A314273-2051	0.080 Sheet	7075-T6 Alclad
56		Support 74A314273-2057	0.080 Sheet	7075-T6 Alclad
57		Support 74A314273-2031	0.050 Sheet	7075-T6 Alclad
58	6 15 9	Bracket 74A830900-2007 74A830900-2009 74A830900-2011	0.063 Sheet	7075-T6 Alclad
59		Support 74A314273-2059	0.080 Sheet	7075-T6 Alclad
60		Support 74A314273-2045	0.080 Sheet	7075-T6 Alclad
61	21 22	Doubler 74A314271-2063 74A314271-2193	0.063 Sheet	7075-T6 Alclad

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 8)
















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
62		Channel 74A314271-2133	0.071 Sheet	7075-T6 Alclad
63		Plate 74A314296-2109	0.080 Sheet	7075-T6 Alclad
64		Plate 74A314296-2107	0.080 Sheet	7075-T6 Alclad
65	 	Web 74A314296-2115 74A314296-2117	 Sheet	6Al-4V Ti Anl
66		Support 74A314296-2083	0.050 Sheet	7075-T6 Alclad
67		Angle 74A314296-2131	0.050 Sheet	7075-T6 Alclad
68	 	Longeron 74A314346-2005, -2006 74A314346-2007, -2008	1MA164D01-10025 Extr	7075-T76 Al Aly
69	 	Splice 74A314296-2006 74A314296-9092	0.080 Sheet	7075-T6 Alclad
70		Web 74A314608-2005	 Sheet	6Al-4V Ti Anl
71		Splice 74A314608-2003	0.080 Sheet	7075-T6 Alclad
72	 	Splice 74A314296-2005 74A314296-9091	0.080 Sheet	7075-T6 Alclad
73	 	Web 74A314296-2079 74A314296-2171	 Sheet	6Al-4V Ti Anl
74		Angle 74A314296-2021	0.050 Sheet	7075-T6 Alclad
75		Channel 74A314296-2151	0.071 Sheet	7075-T6 Alclad
76		Support 74A314322-2004, -2003	0.080 Sheet	7075-T6 Alclad
77		Support 74A314296-2069	0.063 Sheet	7075-T6 Alclad

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 9)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
78		Support 74A314296-2054, -2019	0.050 Sheet	7076-T6 Alclad
79		Support 74A314296-2008, -2007	0.071 Sheet	7075-T6 Alclad
80		Screen 74A314296-2051	8 Mesh, 0.025 Dia. Wire 3.90 x 3.90	304 Cres
81		Doubler 74A31429B-2049	0.040 Sheet	7075-T6 Alclad
82		Support 74A314298-2004, -2003	0.063 Sheet	7075-T6 Alclad
83		Angle 74A314296-2139	0.063 Sheet	7075-T6 Alclad
84		Support 74A314298-2021	0.063 Sheet	7075-T6 Alclad
85		Support 74A314414-2001	2.75 Plate	7075-T7351 Al Aly
86		Support 74A314296-2111	1MA160D05-10192 Extr	7075-T73511 Al Aly
87		Support 74A314296-2103	0.050 Sheet	7075-T6 Alclad
88		Support 74A314296-2105	0.050 Sheet	7075-T6 Alclad
89		Doubler 74A314296-2099	0.040 Sheet	7075-T6 Alclad
90		Support 74A314298-2027	1MA160D03-10157 Extr	7075-T6511 Al Aly
91		Adapter 74A314448-2005	0.040 Sheet	6061-T6 Al Aly
92		Support 74A314271-2061	0.071 Sheet	7076-T6 Alclad
93		Support 74A314298-2025	0.100 Sheet	7076-T76 Alclad
94	<div>2</div> <div>3</div>	Support 74A314298-2023 74A314298-2031	0.063 Sheet	7075-T6 Alclad

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 10)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
95		Support 74A314296-2119	0.063 Sheet	7075-T6 Alclad
96		Support 74A314298-2001, -2030	0.071 Sheet	7075-T6 Alclad
97		Support 74A314610-2001	0.050 Sheet	7075-T6 Alclad
98		Support 74A314610-2003	1MA163D05-10032 Extr	7075-T73511 Al Aly
99	23 24 26	Support 74A314710-2001 74A314710-2003 74A314710-9002, -9001	0.750 Plate 1M160D06-10525 Extr	7075-T7351 Al Aly 7075-T6511 Al Aly
100		Support 74A314711-2001	0.750 Plate	7075-T7351 Al Aly
101		Channel 74A314610-2005	0.063 Sheet	7075-T6 Alclad
102		Support 74A321140-2003, -2004	1MA160D05-10409 Extr	7075-T73511 Al Aly
103		Support 74A314421-2001, -2004	1MA160D05-10435 Extr	7075-T73511 Al Aly
LEGEND				
1	Lands are 0.052 and bays are 0.024.			
2	161353 THRU 161528.			
3	161702 AND UP.			
4	F/A-18A.			
5	F/A-18B.			
6	161353 THRU 161736.			
7	161737 AND UP.			
8	161702 THRU 161987.			
9	162394 AND UP.			
10	F/A-18A 161702 THRU 161755, 161935, 161944, 161949, 161954, 161957, 161961, 161964, 161968 AND F/A-18B 161704 THRU 161746.			
11	F/A-18A 161756 THRU 161934, 161936, THRU 161942, 161945 THRU 161948, 161950 THRU 161953, 161955, 161956, 161958 THRU 161960, 161962, 161963, 161965 THRU 161967, 161969 AND UP AND F/A-18B 161924 AND UP.			
12	161353 THRU 161987.			
13	161353 THRU 161924.			
14	161925 THRU 161987.			
15	161737 THRU 161987.			

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 11)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
16			162394 THRU 162415, 162418 THRU 162420, 162422, 162424, 162426 THRU 162428, 162430, 162432, 162434, 162436, 162438, 162440, 162442, 162443, 162445, 162447, 162449, 162451, 162452, 162454, 162456, 162457.	
17			162416, 162417, 162421, 162423, 162425, 162429, 162431, 162433, 162435, 162437, 162439, 162441, 162444, 162446, 162448, 162450, 162453, 162455, 162458 AND UP.	
18			F/A-18B 161354 THRU 161360.	
19			F/A-18B 161704 THRU 161924.	
20			F/A-18B 161932 AND UP.	
21			161353 THRU 161944, 161949, 161954, 161957, 161961, 161964, 161968, 161971, 161973, 161976, 161979, 161945 THRU 161948, 161950 THRU 161953, 161955, 161956, 161958 THRU 161960, 161962, 161963, 161965 THRU 161967, 161969, 161970, 161972, 161974, 161975, 161977, 161978, 161980 AND UP.	
22			161353 THRU 162427.	
23			162428 THRU 162831, 162874 AND UP.	
24			161353 THRU 162831, AND UP	
25			162832 THRU 162873.	
26			F/A-18A 161353 THRU 162415, 162418, 162420, 162422, 162424, 162426, 162428, 162430, 162432, 162434, 162436, 162438, 162440, 162442, 162443, 162445, 162447, 162449, 162451, 162452, 162454, 162456, 162457, 162459, 162461, 162463, 162464, 162466, 162468, 162470 AND F/A-18B 161354 THRU 162413.	
27			F/A-18A 162416, 162417, 162421, 162423, 162425, 162429, 162431, 162433, 162435, 162437, 162439, 162441, 162444, 162446, 162448, 162450, 162453, 162455, 162458, 162460, 162462, 162465, 162467, 162469, 162471 AND UP AND F/A-18B 162419 AND UP.	
28			161353 THRU 161528 BEFORE F/A-18 AFC 49.	
29			162394 THRU 163118.	
30			163119 AND UP.	
31			162394 AND UP; ALSO 161353 THRU 161987 AFTER F/A-18 AFC 48.	
32			161353 THRU 161987 BEFORE F/A-18 AFC 48.	
33			161702 THRU 161987 AFTER F/A-18 AFC 48.	
34			161353 THRU 161528 AFTER F/A-18 AFC 48.	
35			161702 THRU 161987 BEFORE F/A-18 AFC 48.	
36				

Figure 5. Lower Floor (Y233.7 - Y383.0) Material Index (Sheet 12)

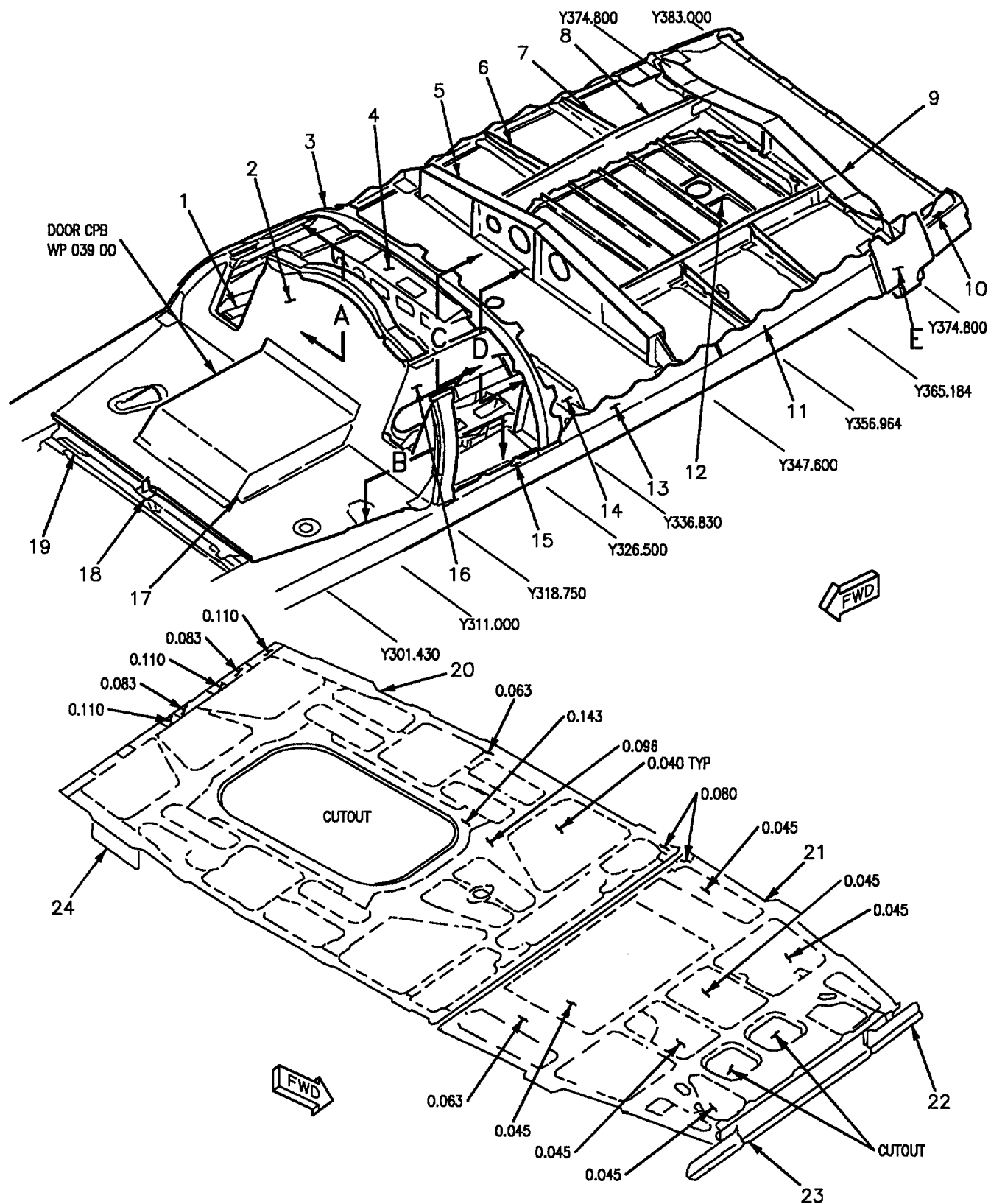
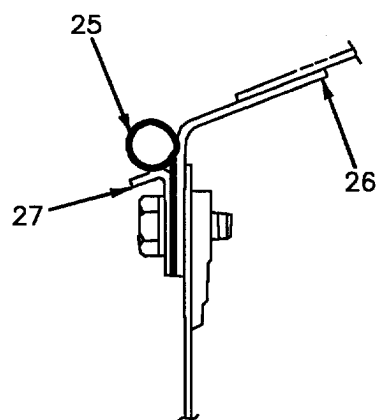
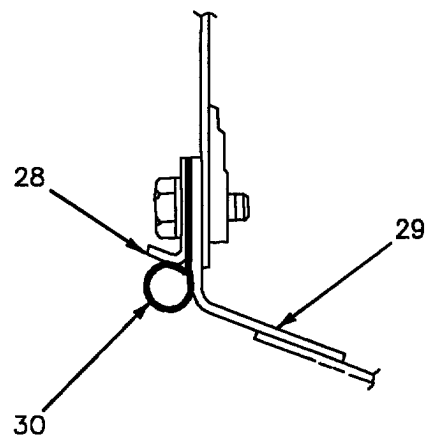


Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 1)

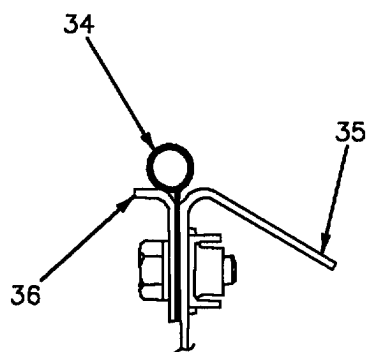
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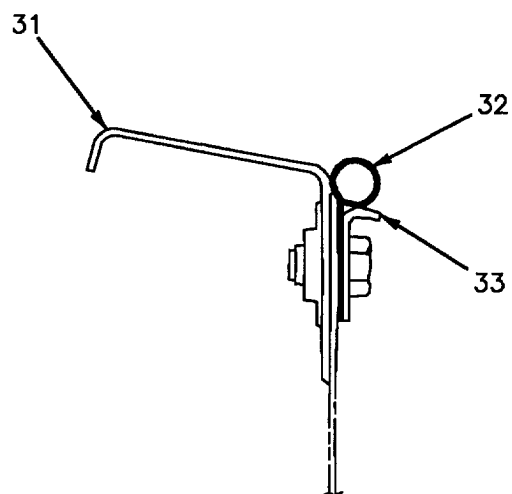
A



B



D



C

Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 2)

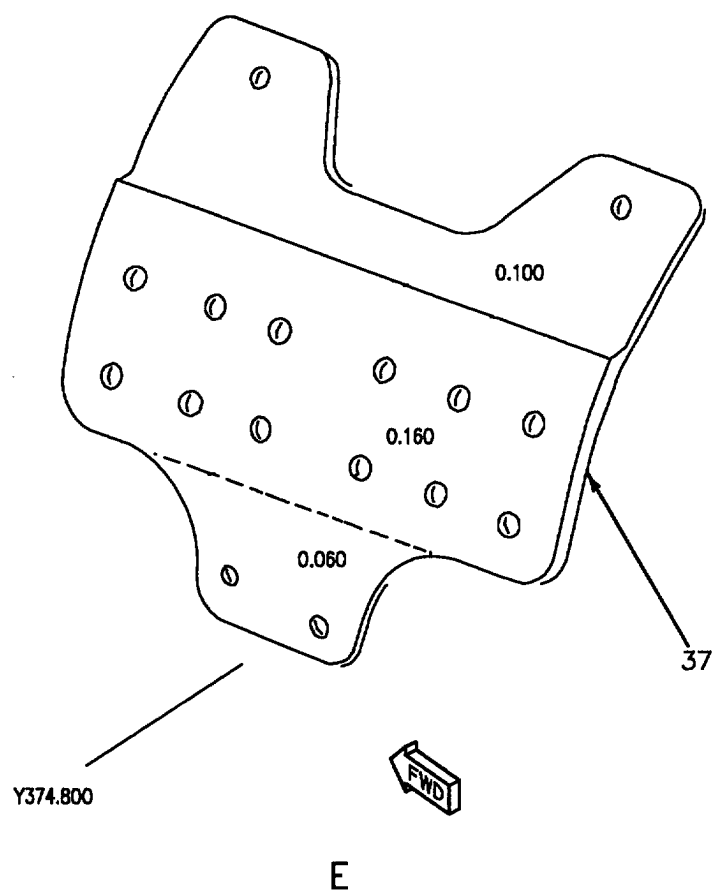


Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 3)











IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Support 74A314054-1001	1.75 Plate	7075-T7351 Al Aly
2		Bulkhead 74A314091-2005	1.50 Plate	7075-T7351 Al Aly
3	 	Bulkhead 74A314092-2007 74A314092-2009	4.00 Plate	7075-T7351 Al Aly
4		Support 74A314097-1003	0.063 Sheet	6061-T6 Al Aly
5		Support 74A314056-2009	2.25 Plate	7075-T7351 Al Aly
6		Support 74A314057-2020, -2015	0.063 Sheet	7075-T6 Alclad
7		Support 74A314057-2014, -2017	0.063 Sheet	7075-T6 Alclad
8		Intercostal 74A314087-2004, -2001	1.00 Plate	7075-T7351 Al Aly
9		Support 74A314088-2005	2.50 Plate	7075-T7351 Al Aly
10	 	Bracket 74A314093-2011, -2012 74A314093-2017, -2018	0.071 Sheet	7075-T6 Alclad
11	 	Bracket 74A314093-2005, -2006 74A314093-2015, -2016	0.063 Sheet	7075-T6 Alclad
12	 	Cover 74A314639-2005 74A314639-2007	1.00 Plate	7075-T7351 Al Aly
13	 	Bracket 74A314093-2003, -2004 74A314093-2013, -2014	0.063 Sheet	7075-T6 Alclad
14		Support 74A314096-1003	1.00 Plate	7075-T7351 Al Aly
15		Bracket 74A314093-2001, -2002	0.063 Sheet	7075-T6 Alclad
16		Closure 74A314059-2013, -2014	0.025 Sheet	6061-T6 Al Aly

Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 4)











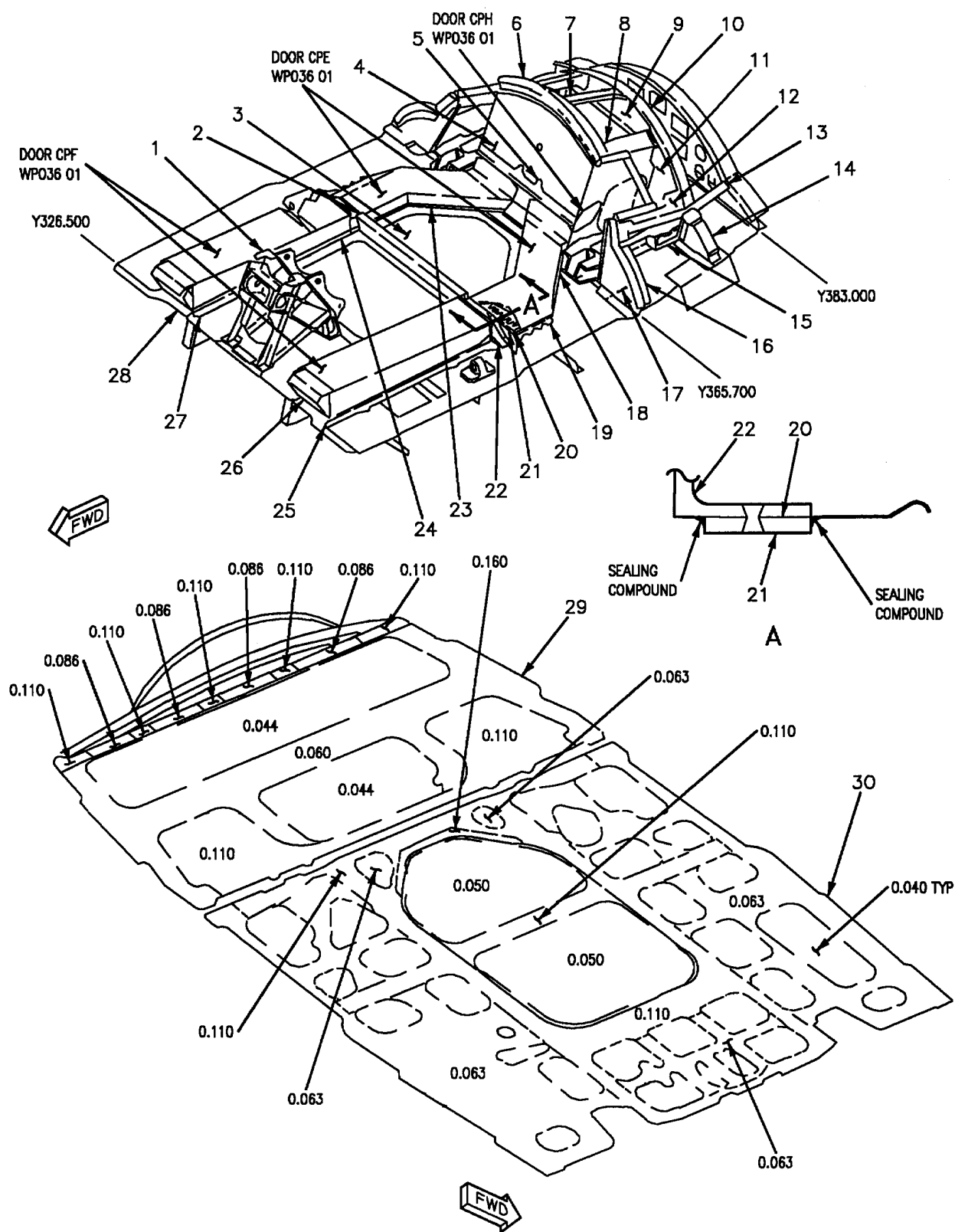
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
17	 	Support 74A314059-2003, -2004 74A314059-2057, -2004	0.050 Sheet	7075-T6 Alclad
18		Support 74A314449-2001	2.25 Plate	7075-T7351 Al Aly
19		Angle 74A314059-2045, -2046	0.040 Sheet	7075-T6 Alclad
20	 	Web 74A314060-2003 74A314060-2007	0.190 Sheet	7075-T76 Al Aly
21	 	Web 74A314059-2053 74A314060-2007	0.080 Sheet	7075-T6 Al Aly
22		Angle 74A314059-2018, -2017	0.071 Sheet	7075-T6 Alclad
23		Beam 74A314059-2035	0.050 Sheet	7075-T6 Alclad
24		Angle 74A314078-2001	0.160 Sheet	7075-T76 Alclad
25		Seal 74A314070-2015	11M932-1 Extr	Silicone Rubber
26	 	Angle 74A314070-2019, -2018 74A314070-2019, -2030	0.050 Sheet	7075-T6 Alclad
27		Retainer 74A314070-2009	0.032 Sheet	7075-T6 Alclad
28		Retainer 74A314070-2003, -2004	0.032 Sheet	7075-T6 Alclad
29	 	Intercostal 74A314070-2017 74A314070-2029	0.050 Sheet	7075-T6 Alclad
30		Seal 74A314070-2013, -2014	11M932-1 Extr	Silicone Rubber
31		Intercostal 74A314089-2013, -2014	0.050 Sheet	7075-T6 Alclad
32		Seal 74A314089-2005, -2006	11M932-1 Extr	Silicone Rubber

Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 5)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
33		Retainer 74A314089-2007, -2008	0.032 Sheet	7075-T6 Alclad
34		Seal 74A314089-2011, -2012	11M932-1 Extr	Silicone Rubber
35		Support 74A314089-2015, -2016	0.040 Sheet	7075-T6 Alclad
36		Retainer 74A314089-2019	0.032 Sheet	7075-T6 Alclad
37		Bracket 74A314701-2005, -2006	0.160 Sheet	7075-T76 Al Aly
<p style="text-align: center;">LEGEND</p> <p> 1 F/A-18A 161353 THRU 161519. 2 F/A-18A 161520 AND UP. 3 F/A-18A 161353 THRU 161761. 4 F/A-18A 161925 AND UP. 5 F/A-18A 161353 THRU 161722. 6 F/A-18A 161724 AND UP. 7 F/A-18A 161353 THRU 162909. 8 F/A-18A 163092 AND UP. </p>				

Figure 6. Canopy Deck Material Index, F/A-18A (Sheet 6)



IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>1</div> <div>2</div> <div>3</div>	Support 74A314838-2004, -2003	2.25 Plate	7075-T7351 Al Aly
2		Support 74A314904-2001	1.75 Plate	7075-T7351 Al Aly
3		Cover 74A314847-2003 74A314847-2109 74A314847-2111	0.125 Sheet	7075-T76 Alclad
4		Web 74A314852-2041	0.040 Sheet	7075-T6 Alclad
5		Angle 74A314852-2033	0.040 Sheet	7075-T6 Alclad
6		Cap 74A314852-2005	0.040 Sheet	7075-T6 Alclad
7		Intercostal 74A314842-2047	0.063 Sheet	7075-T6 Alclad
8		Intercostal 74A314842-2031, -2032	0.063 Sheet	7075-T6 Alclad
9		Web 74A314851-2005	0.040 Sheet	7075-T76 Alclad
10		Cap 74A314851-2001	1MA160D01-10227 Extr	7075-T76 Al Aly
11		Web 74A314851-2037, -2038	0.040 Sheet	7075-T76 Alclad
12		Intercostal 74A314842-2051, -2052	0.063 Sheet	7075-T6 Alclad
13		Intercostal 74A314842-2057, -2058	0.063 Sheet	7075-T6 Alclad
14		Cap 74A314851-2003, -2004	1MA160D01-10227 Extr	7075-T76 Al Aly
15		Support 74A314839-2001	1.75 Plate	6Al-4V Ti Aly
16		Cap 74A314852-2043, -2044	0.040 Sheet	7075-T6 Alclad
17		Web 74A314852-2029, -2030	0.050 Sheet	7075-T6 Alclad

Figure 7. Canopy Deck Material Index, F/A-18B (Sheet 2)










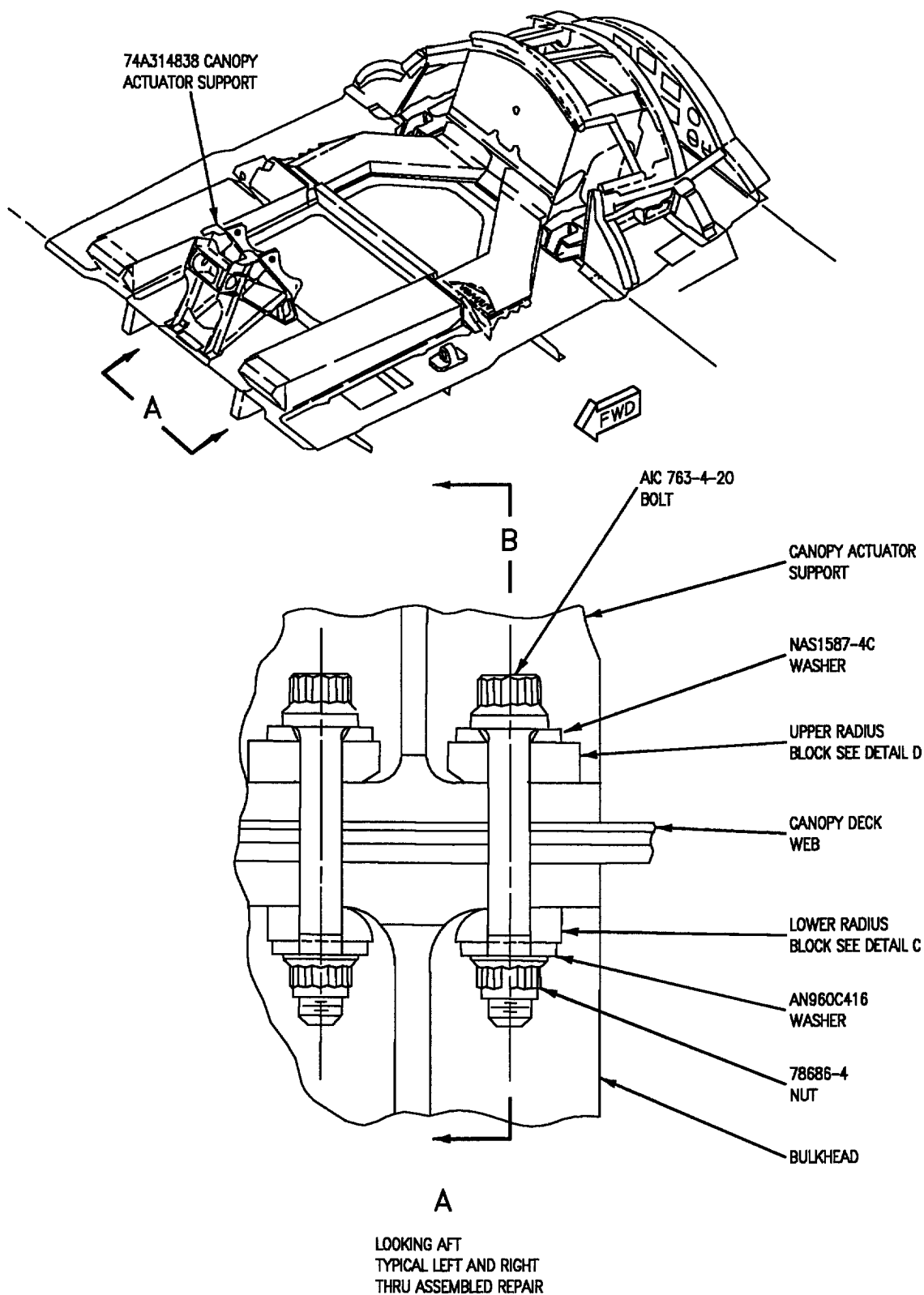
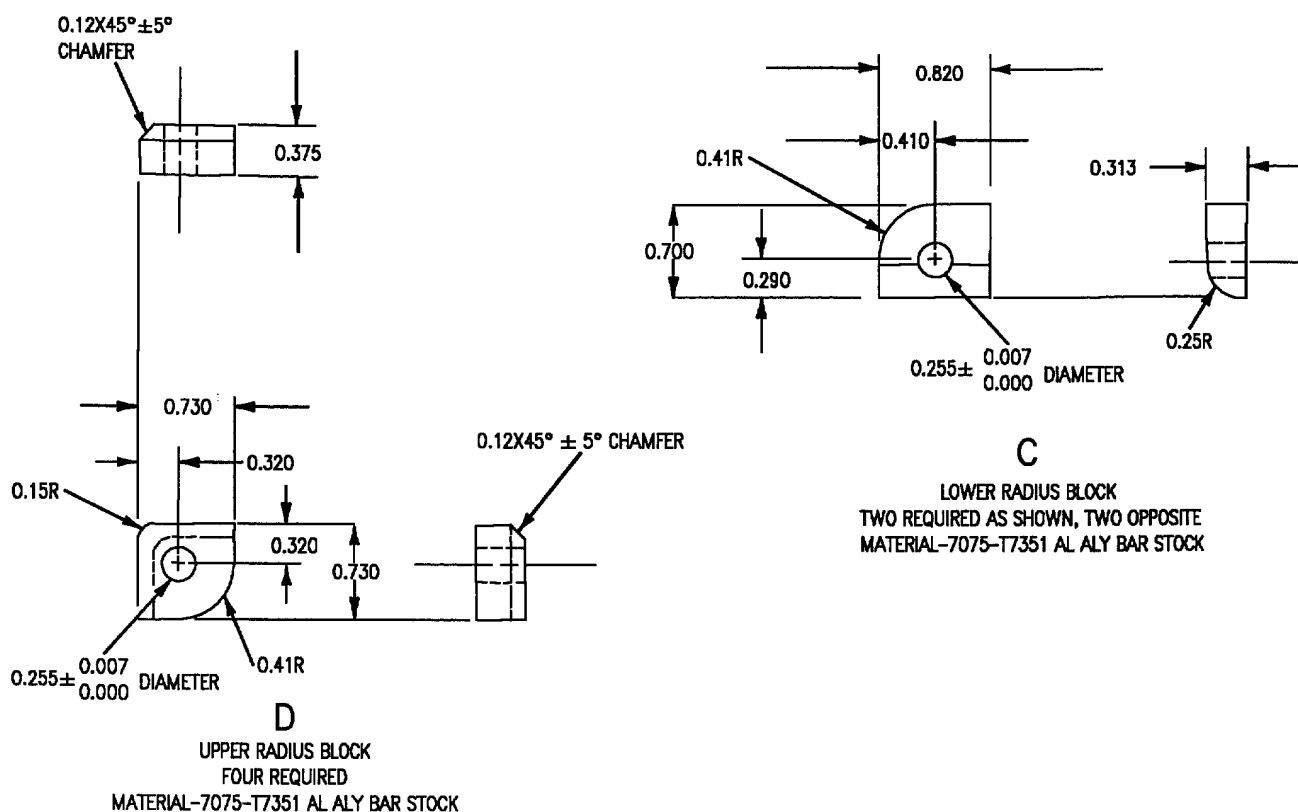
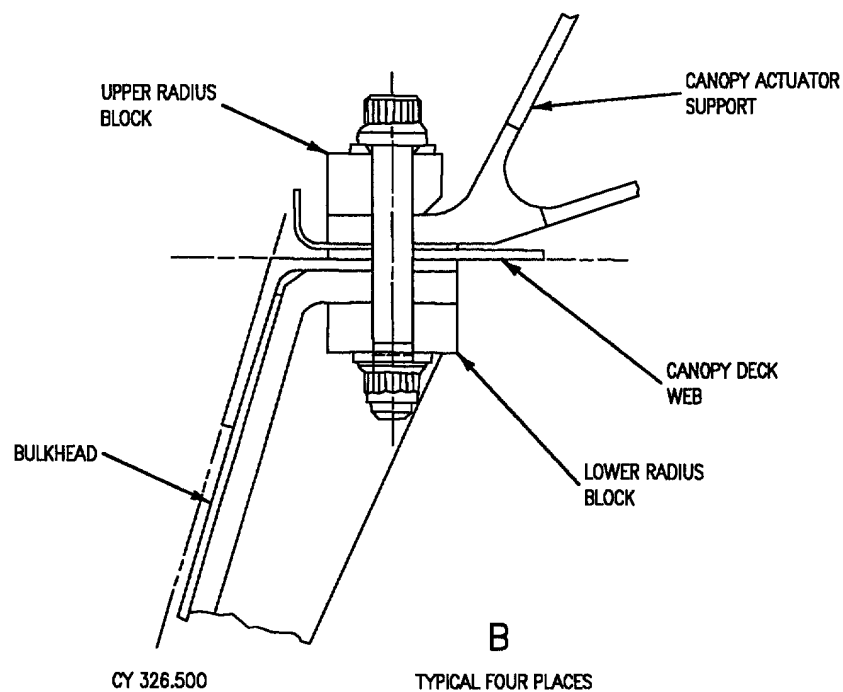
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
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19		Angle 74A314847-2009, -2010	0.040 Sheet	7075-T6 Alclad
20		 Seal 74A314923-2001, -2002	ST9M622-4-430	Beryllium Copper
21		Retainer 74A314923-2003, -2004	0.063 Sheet	7075-T6 Alclad
22		Support 74A314903-2003, -2004	Machining	7075-T7351 Al Aly
23		Support 74A314847-2113	0.040 Sheet	7075-T6 Alclad
R		74A314847-2100		
R		74A314847-2099		
L				
24		Support 74A314847-2102, -2101	0.063 Sheet	7075-T6 Alclad
25		Angle 74A314847-2105, -2106	0.063 Sheet	7076-T6 Alclad
26		Cover 74A314847-2097, -2098 74A314847-2107, -2108	0.063 Sheet	7075-T6 Alclad
27		Angle 74A314847-2034, -2033	0.063 Sheet	7075-T6 Alclad
28		Angle 74A314847-2037	0.032 Sheet	7075-T6 Alclad
29		Web 74A314846-2013	0.160 Sheet	7075-T76 Al Aly
30		Web 74A314847-2095	0.160 Sheet	7075-T76 Alclad
LEGEND				
 F/A-18B 161354 THRU 161360.  F/A-18B 161704 THRU 162885.  F/A-18B 163104 AND UP.  F/A-18B 161354 THRU 162850.  F/A-18B 162857 AND UP.  EMI Electrical bonding strip.				

Figure 7. Canopy Deck Material Index, F/A-18B (Sheet 3)



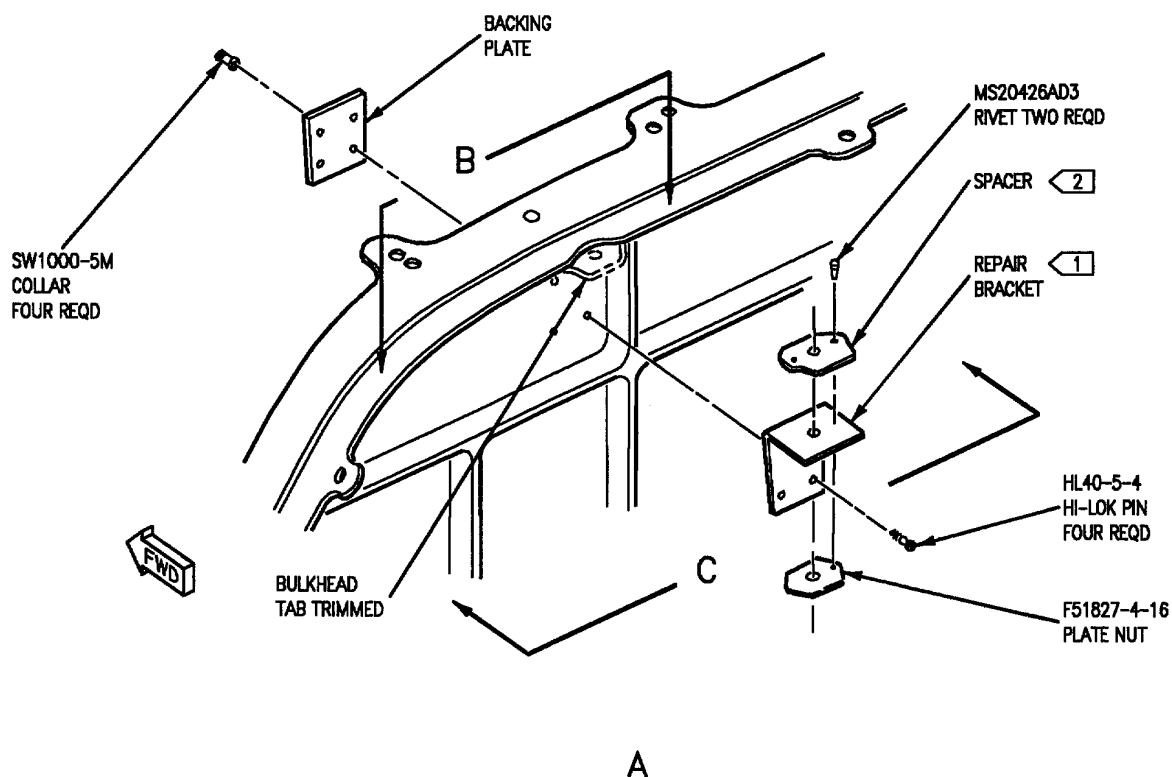
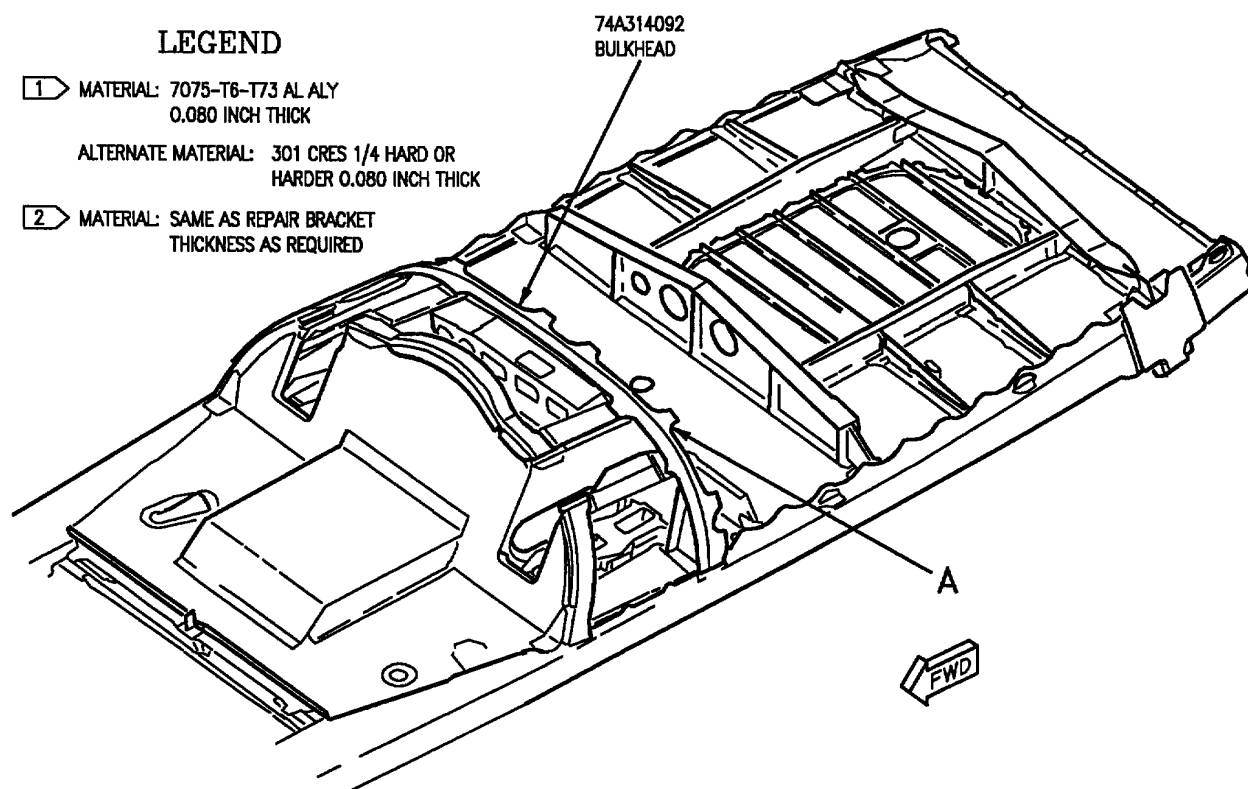
18AC-SRM-222-(8-1)01-SCAN

Figure 8. Canopy Actuator Support, Fastener Repair (Sheet 1)



18AC-SRM-222-(8-2)01-SCAN

Figure 8. Canopy Actuator Support, Fastener Repair (Sheet 2)



18AC-SRM-222-(9-1)01-SCAN

Figure 9. Bulkhead, Broken Tab Repair (Sheet 1)

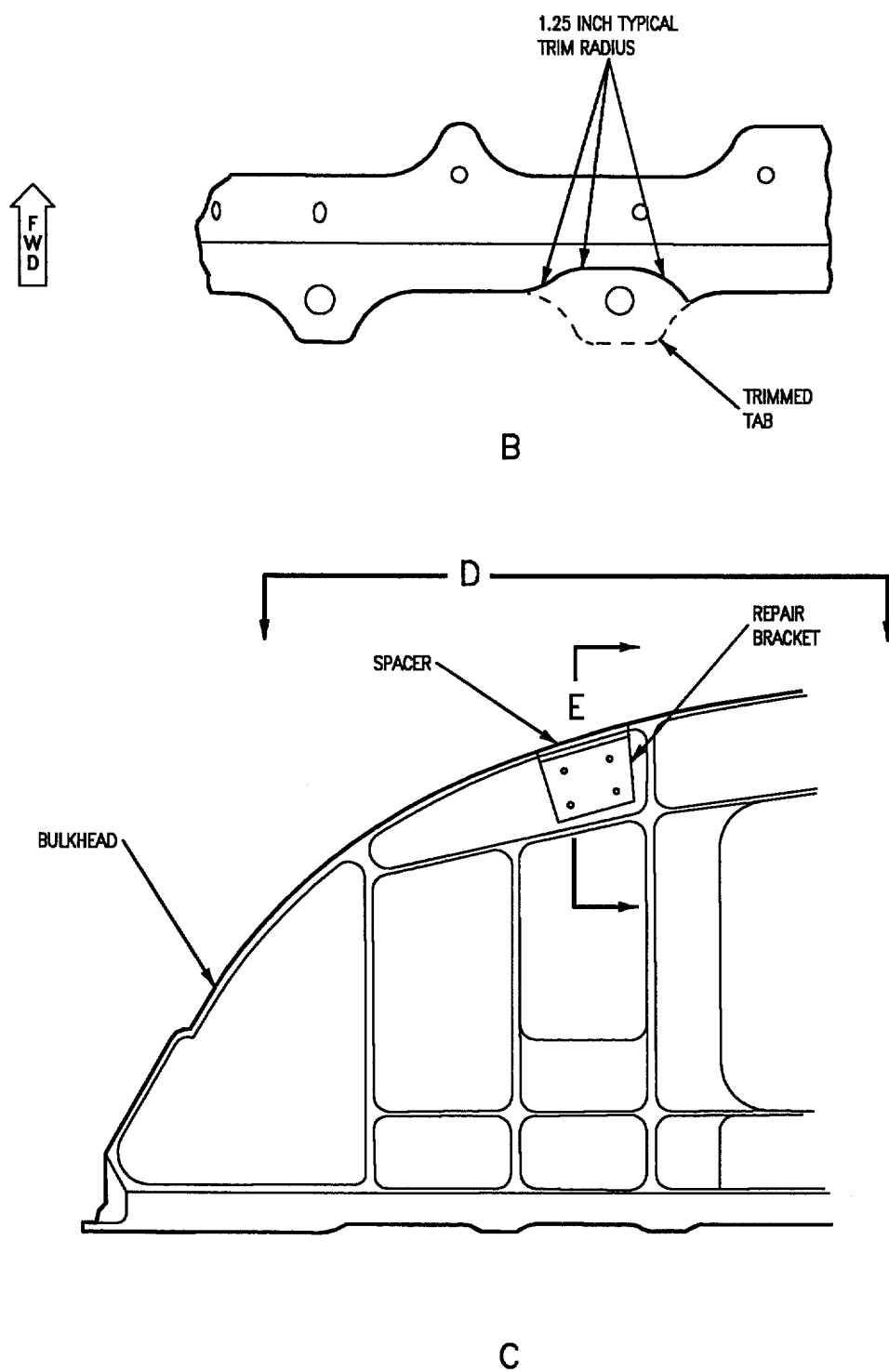
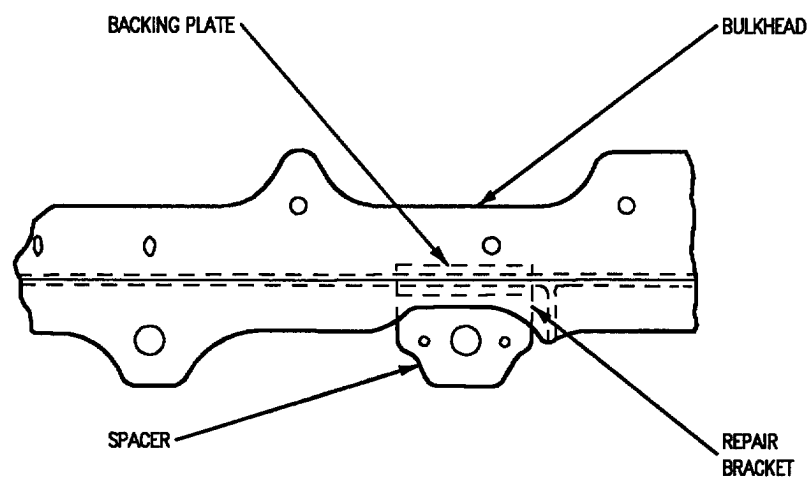
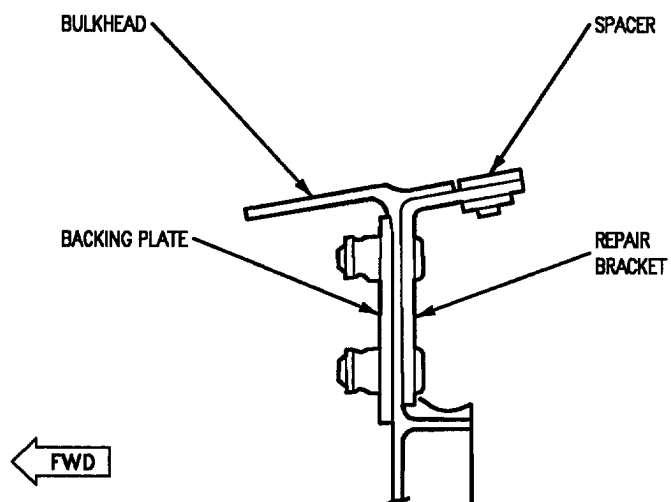


Figure 9. Bulkhead, Broken Tab Repair (Sheet 2)



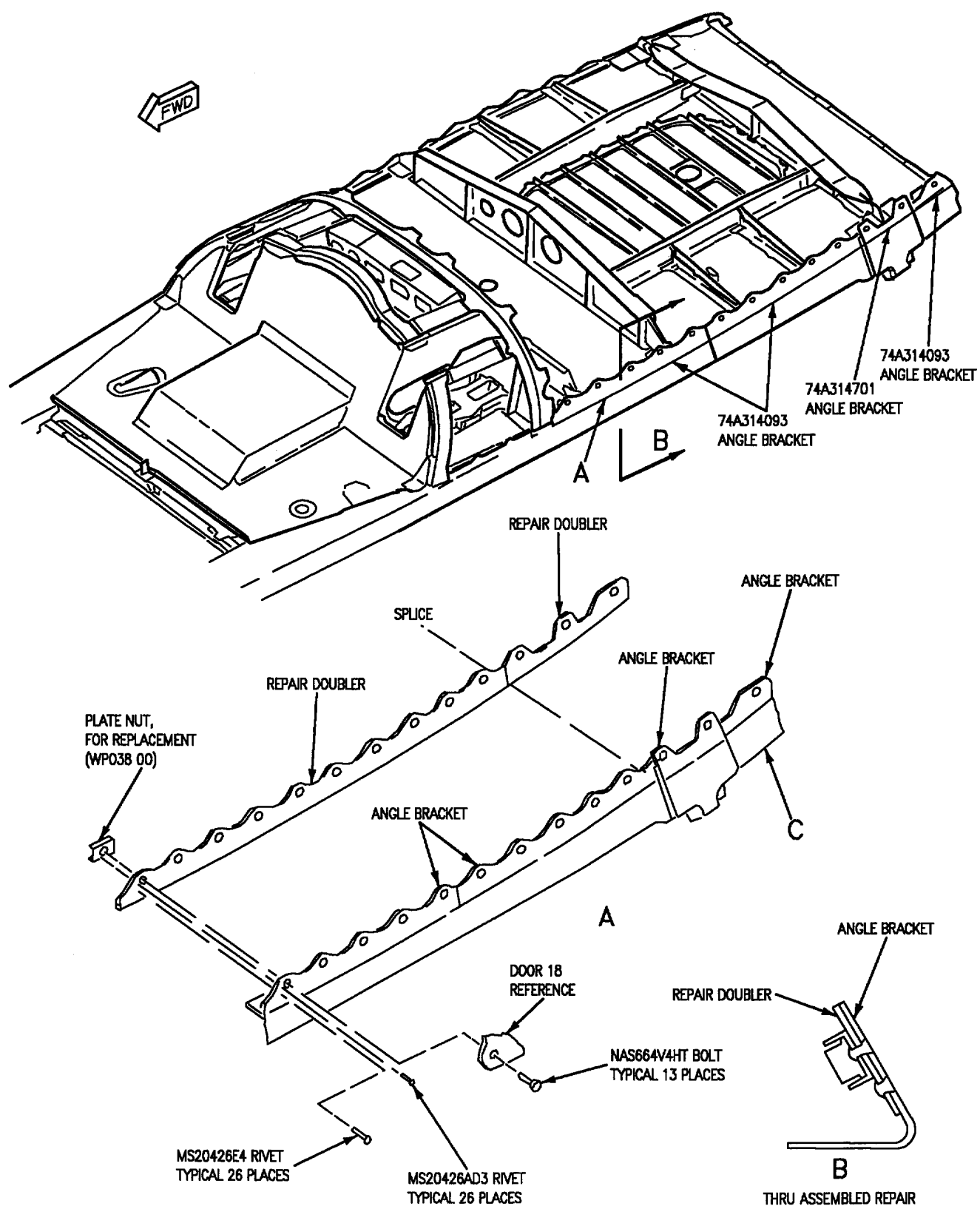
D



E

THRU ASSEMBLED REPAIR

Figure 9. Bulkhead, Broken Tab Repair (Sheet 3)



18AC-SRM-222-(10-1)01-SCAN

Figure 10. Angle Bracket Repair (Sheet 1)

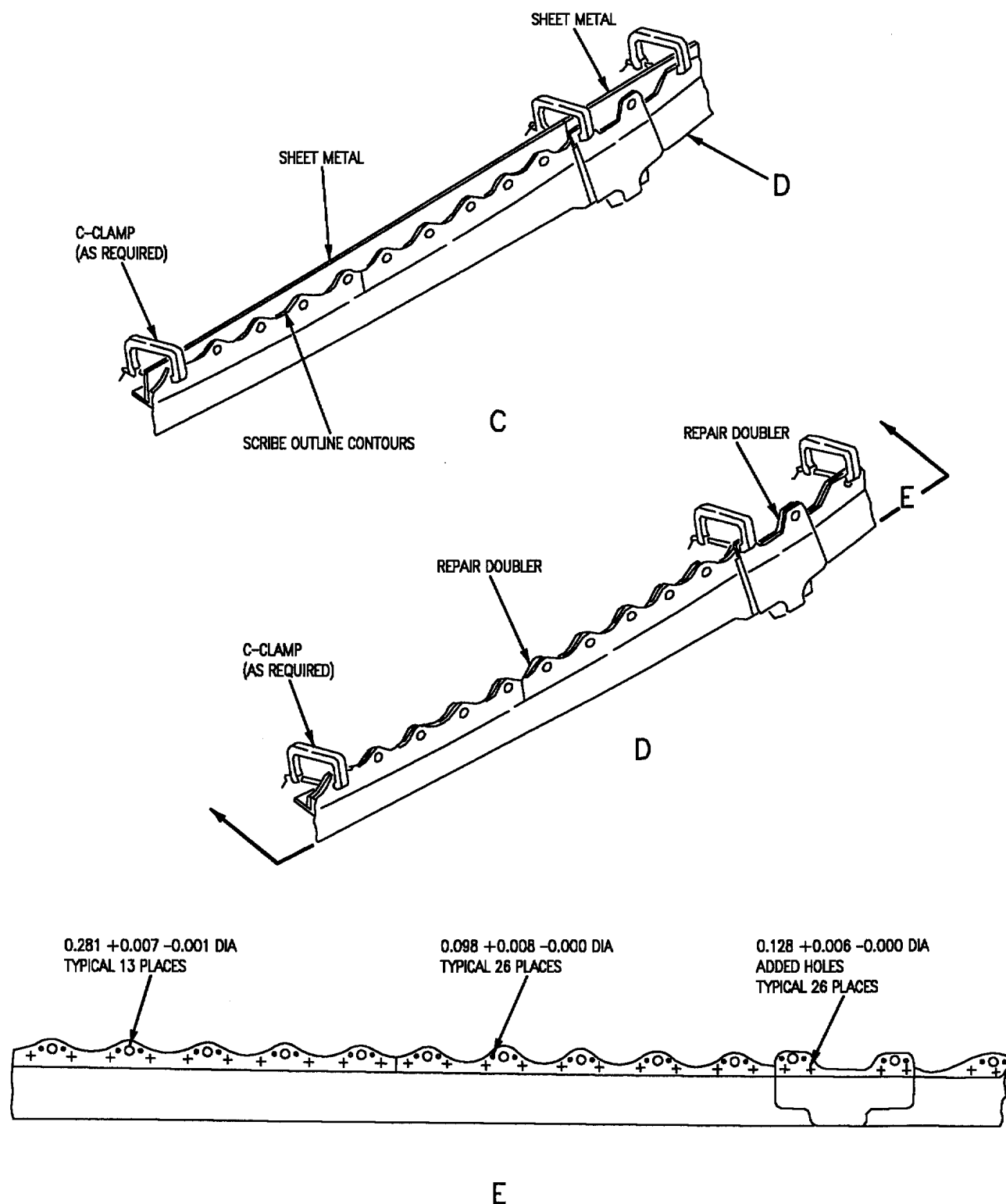


Figure 10. Angle Bracket Repair (Sheet 2)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

MAIN INSTRUMENT PANEL AND CONSOLES, COCKPIT

Reference Material

Aircraft Corrosion Control	A1-F18AC-SRM-500
Stripping	WP007 00
Chemical Treatment	WP008 00
Priming Procedures	WP011 00
Finish System	WP012 00
Windshield, Canopy, and Cockpit Finish System	WP021 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Multipurpose Display Group	A1-F18AC-745-300
Lower LH Instrument Panel Assy	WP019 00
Nondestructive Inspection	A1-F18AC-SRM-300
Penetrant Method	WP004 00
Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Structure Installation - Main Instrument and Console Panel (Cockpit)	FIG 014 00
Structure Repair, General Information	A1-F18AC-SRM-200
General Information	WP002 00
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Aluminum Sheet Edge Repair	WP034 00
Aluminum Sheet Repairs, Across Structure and Lands	WP036 00
Blending	WP038 00

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Negligible Damage	13
Repairable Damage	13
Repairs	13
Permanent Repairs	13
Cracks	13
Dents	14
Edge	14
Holes	14
Scratches, Nicks, Gouges, or Corrosion	13
Replacement	15
Main Instrument and Console	13
Plate, (74A800763-2005)	13
Tee, (74A800763-2003)	13
Main Instrument Panel	2
Damage Evaluation	2

Alphabetical Index (cont.)

Subject	Page No.
Negligible Damage	2
Repairable Damage	2
Repairs	2
Replacement	3

Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

None

1. MAIN INSTRUMENT PANEL.

2. **DAMAGE EVALUATION.** See figures 1 and 2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figure 1. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Damage not listed or exceeding the following limits require depot engineering disposition.

3. **Negligible Damage.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

4. **Repairable Damage.** Repairable damage is damage that can be permanently repaired with no adverse affect on structural integrity, flight characteristics, or safety of the aircraft. Minor damage types and limits are listed below and in table 2. The figure and index numbers in table 2 coincide with the figure and index in the material index. Area limit applies after blending.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and lands must have edge of cleanup hole at least eight repair fastener diameters from any land, internal structure or existing row of fasteners.

(2) Damage to lands, over structure, only one repair per land.

e. Dents exceeding the limits in table 1 must be repaired.

5. REPAIRS.

5A. **ECM Panel (74A800832).** Weld cracks that form at the top and/or the top left side (pilot's perspective) as follows:

a. Remove panel from acft.

b. Chemically strip paint in weld area (A1-F18AC-SRM-500, WP007 00).

c. Straighten flanges as necessary. Clamp flange to rigid surface to minimize warpage.

d. Gas tungsten arc weld crack(s) as required.

e. Blend weld(s) smooth to surface.

f. Liquid penetrant inspect new weld(s)
(A1-F18AC-SRM-300, WP004 00).

g. Apply chemical conversion to weld area
(A1-F18AC-SRM-500, WP008 00).

h. Apply 1 coat of primer to weld area
(A1-F18AC-SRM-500, WP011 00).

i. Apply 2 coats of topcoat to weld area
(A1-F18AC-SRM-500, WP012 00).

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definitions are in structure repair terms (A1-F18AC-SRM-200, WP002 00). Blend scratches, nicks, gouges or corrosion (A1-F18AC-SRM-250, WP038 00). If after blending, the damage limits of table 2 are exceeded, repair will require a depot engineering disposition. Re-finish blended areas (A1-F18AC-SRM-500, WP021 00).

7. **ECM Panel, (74A800832).** Reweld cracks that form at the top and/or the top left side (pilot's per-

spective) as follows. Chemically strip paint in reweld area per A1-F18AC-SRM-500, WP007 00. Straighten flanges as necessary. Clamp flange to rigid surface to minimize warpage. Gas tungsten arc weld cracks as required. Liquid penetrant inspect new weld(s) per A1-F18AC-SRM-300, WP004 00. Blend welds smooth to surface. Apply chemical conversion to weld area per A1-F18AC-SRM-500, WP008 00. Apply 1 coat of primer to reweld area per A1-F18AC-SRM-500, WP011 00. Apply 2 coats of topcoat to reweld area per A1-F18AC-SRM-500, WP012 00.

8. REPLACEMENT.

9. **Lower LH Instrument Panel.** See figure 3. Fastener attaching hardware is shown on figure. For fasteners (A1-F18AC-745-300, WP019 00).

10. **Lower RH Instrument Panel.** See figure 4. Fastener attaching hardware is shown on figure.

Table 1. Negligible Damage Limits






Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Support Zone A2	0.070	0.002	0.002	100%		N/A
Fig 1 (2)	Base Zone D2	0.080	0.0006	0.0006	100%		N/A
Fig 1 (3)	Panel Zone A2	0.070	0.002	0.002	100%		N/A
Fig 1 (5)	Support Zone B2	0.063	0.0006	0.0006	100%	0.031	N/A
Fig 1 (6)	Panel Zone A2	0.060	0.002	0.002	100%	0.030	N/A
Fig 1 (7)	Panel Zone C2	0.070	0.0006	0.0006	100%		N/A
NOTE							
 None allowed.							

Table 2. Repairable Damage Limits After Blending

Fig No Idx No	Nomen/ Repair Zone	Thickness	Edge Nicks Depth	Scratch Depth	Nicks Gouges		Corrosion	
					Depth	Area	Depth	Area
Fig 1 (1)	Support Zone A2	0.070	0.05	0.014	0.014	15%	0.014	15%
Fig 1 (2)	Base Zone D2	0.080	0.05	0.016	0.016	5%	0.016	5%
Fig 1 (3)	Panel Zone A2	0.070	0.05	0.014	0.014	15%	0.014	15%
Fig 1 (5)	Support Zone B2	0.063	0.05	0.012	0.012	10%	0.012	10%
Fig 1 (6)	Panel Zone A2	0.060	0.05	0.012	0.010	15%	0.010	15%
Fig 1 (7)	Panel Zone C2	0.070	0.05	0.014	0.014	5%	0.014	5%

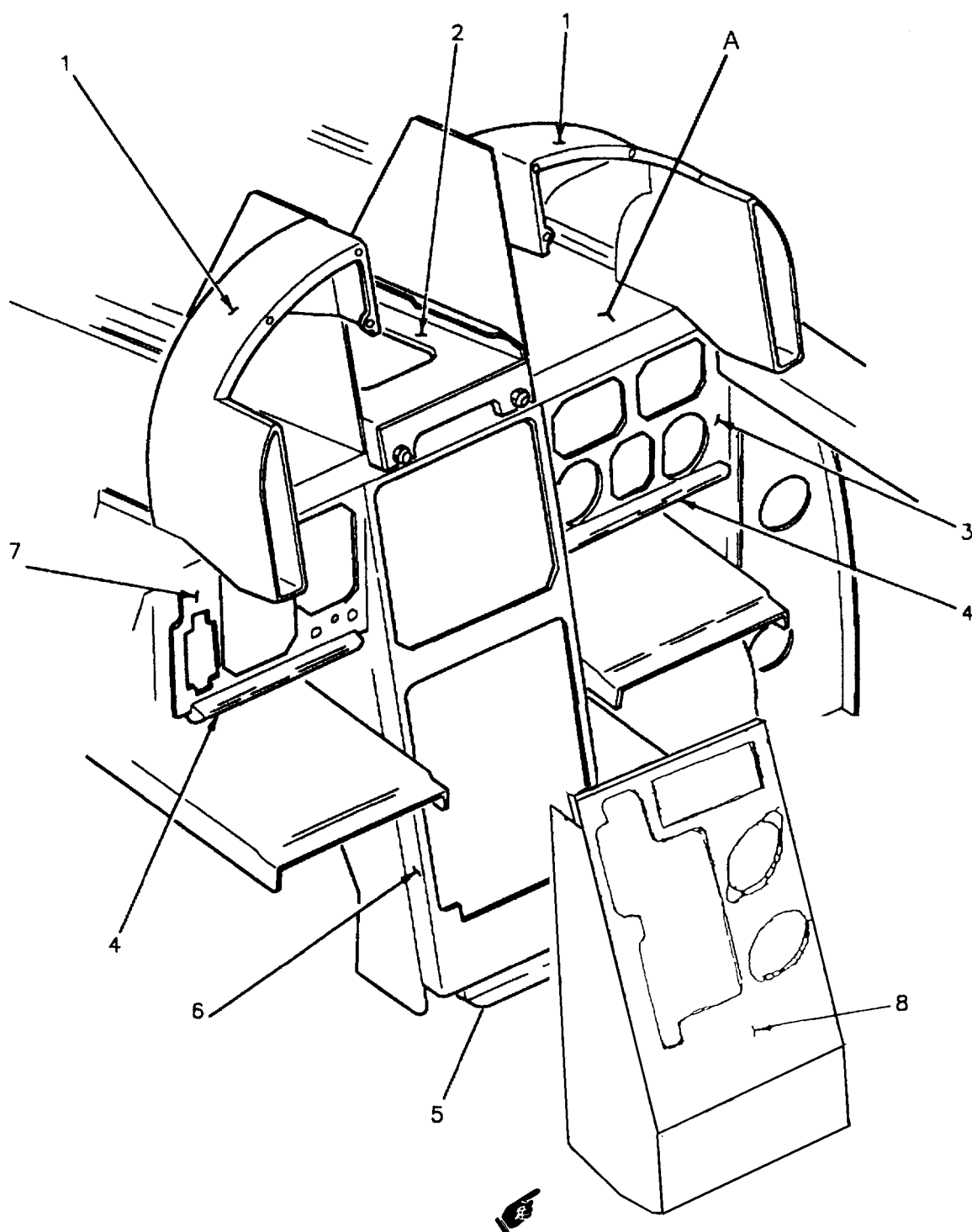
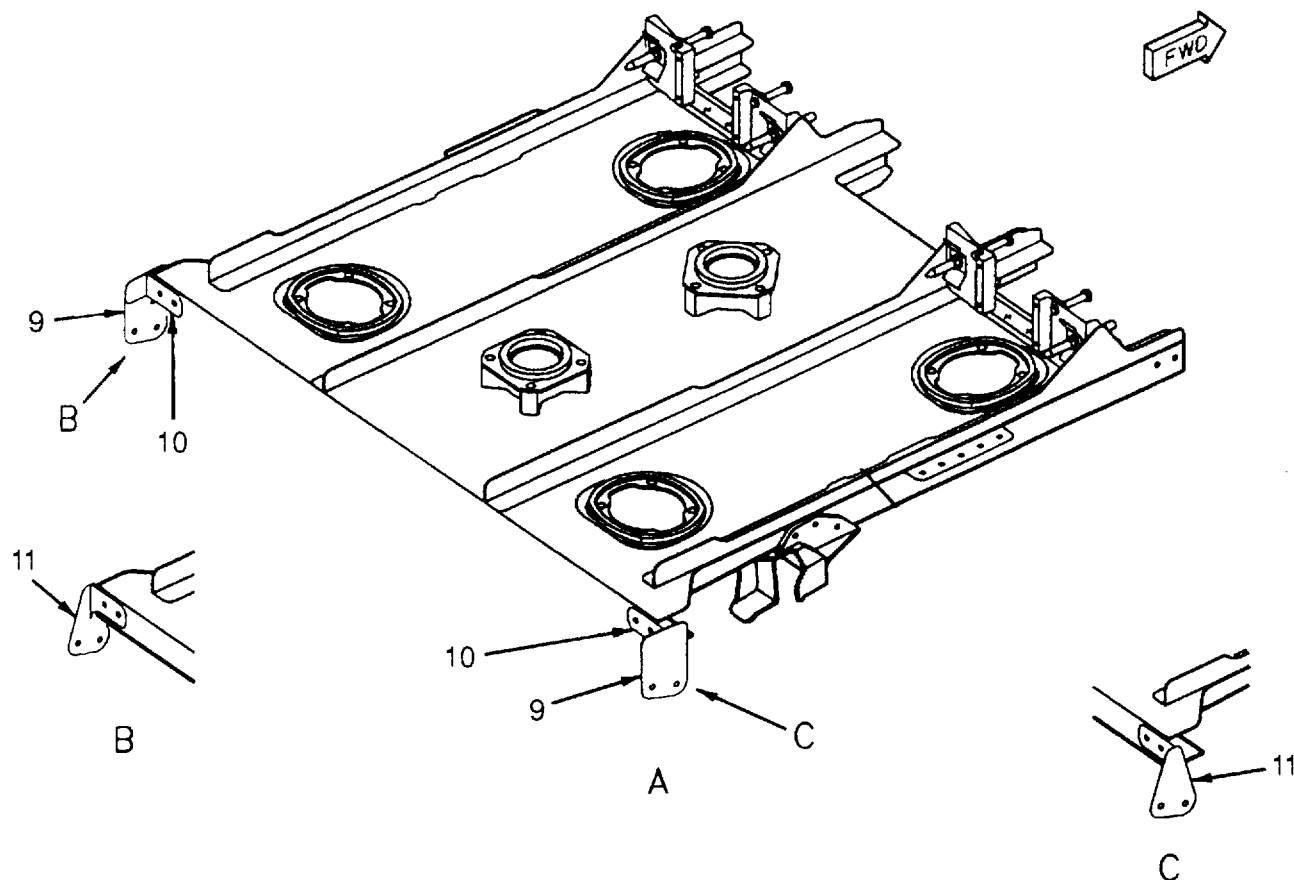


Figure 1. Main Instrument Panel Material Index (Sheet 1)



02600102

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>7</div> <div>10</div> <div>9</div> <div>11</div>	Support 74A800606-2013, -2016 74A800606-9001, -9002 74A800606-2025, -2026 74A800606-9001, -2026	Casting	A356-T61 Al Aly
2	<div>3</div> <div>4</div>	Mounting Base 74A800682-9001 74A800682-2009	Casting	A356-T61 Al Aly
3	<div>3</div> <div>4</div>	Panel 74A800609-2009 74A800609-2013	Casting	A356-T61 Al Aly

Figure 1. Main Instrument Panel Material Index (Sheet 2)



























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
4		Guard 74A800633-2007	11M962-1 Extr	Silcone Rubber
5	 	Support 74A314640-2001 74A314640-2003	1MA160D05-10157 Extr	7075-T73511 Al Aly
6	 	Panel 74A800683-2009 74A800683-2011	1.75 Plate	707.5-T7351 Al Aly
7	    	Panel 74A800608-2009 74A800608-2011 74A800608-9011 74A800608-9013 74A800608-2013	Casting	A356-T61 Al Aly
8	 	ECM Panel 74A800832-2003 74A800832-2011	Casting	A356-T61 Al Aly
9		Plate 74A800763-2005	1MA160D05-10482 EXTR	7075-T73511 Al Aly
10		Tee 74A800763-2003	0.032 Sheet	7075-T6 Alclad
11		Tee Clip 74A800763-2001, 2002	1MA160D05-10482 EXTR	7075-T73511 Al Aly
LEGEND				
	F/A-18A.			
	F/A-18B.			
	161353 THRU 161528.			
	161702 AND UP.			
	161353 THRU 161707.			
	161708 THRU 161715.			
	161353 THRU 161715.			
	162394 THRU 162472.			
	161925 AND UP.			
	161716 THRU 161755.			
	161756 THRU 161924.			
	161716 THRU 161987.			
	162473 THRU 163175.			
	F/A-18A 161353 THRU 163162 AND F/A-18B 161354 AND UP			
	F/A-18A 163163 AND UP			

Figure 1. Main Instrument Panel Material Index (Sheet 3)

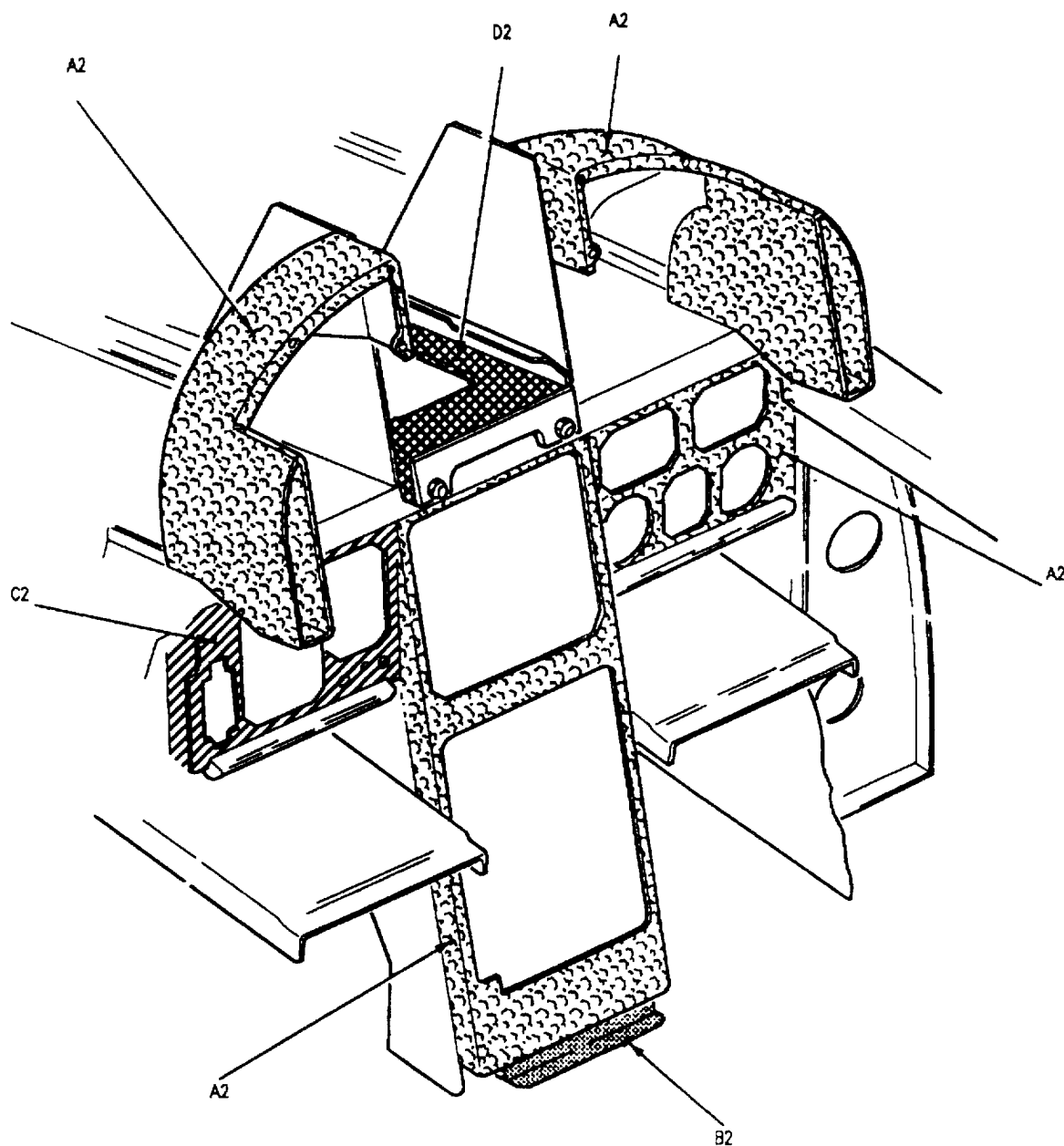
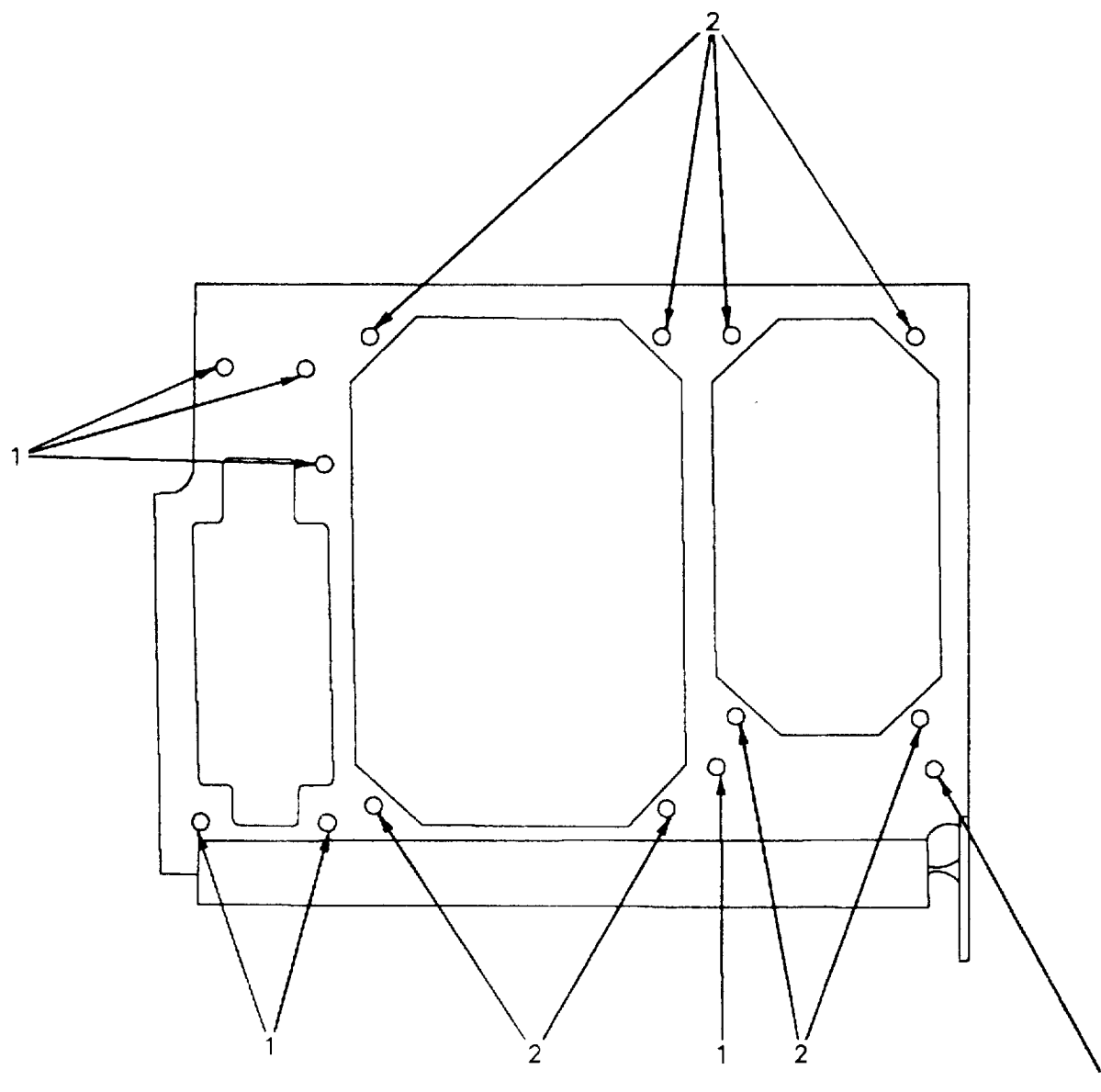


Figure 2. Main Instrument Panel Material Index (Sheet 1)



18AC-SRM-222-(13-1)01-CATI





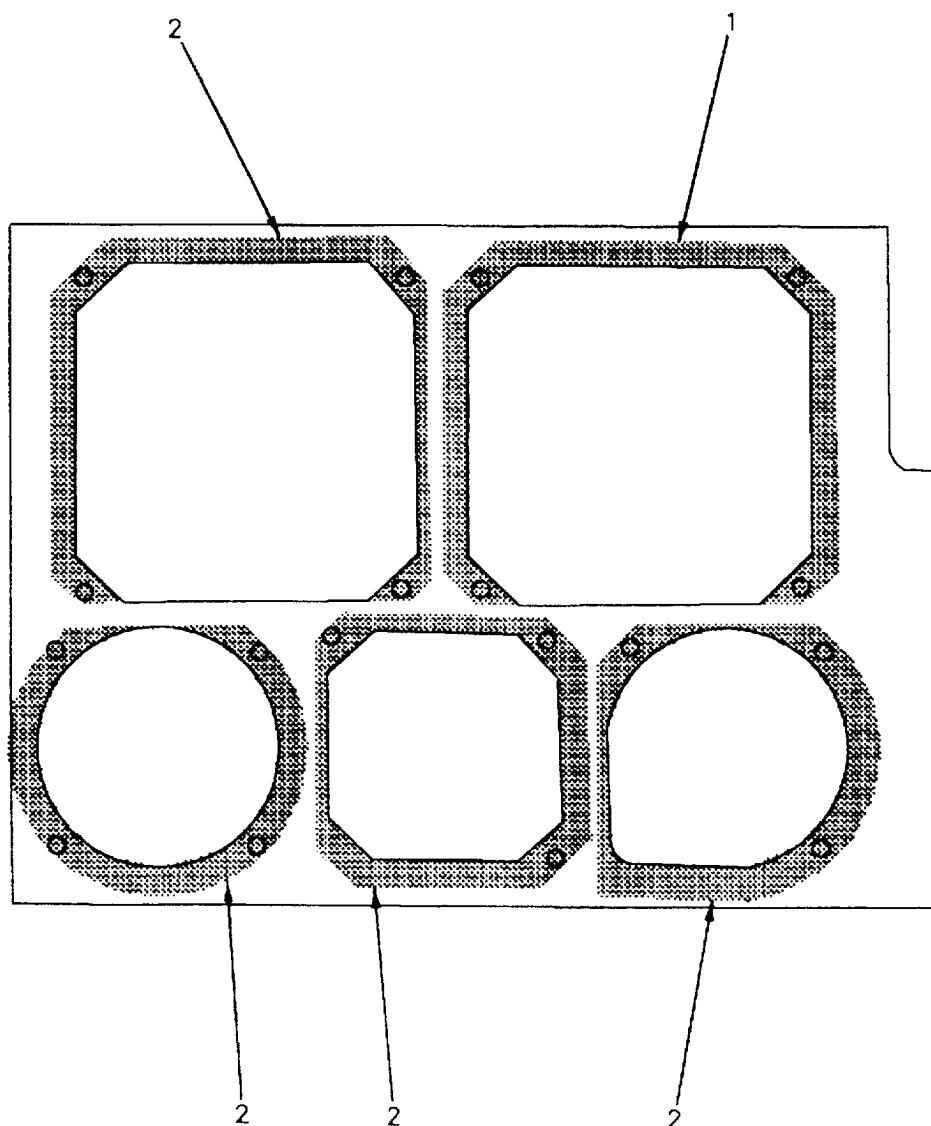
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21075L06
2			Plate Nut	MS21075L08
LEGEND				
 Hole diameter is 0.166 +0.006 -0.000.				
 Hole diameter is 0.169 +0.006 -0.000.				

Figure 3. Lower LH Instrument Panel Replacement (Sheet 1)



18AC-SRM-222-(14-1)01-CATI

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1	<div>2</div> <div>3</div>	<div>1</div> <div>1</div>	Spring Nut Spring Nut	NAS487-13 NAS487-16
2		<div>1</div>	Spring Nut	NAS487-16
LEGEND				
<div>1</div> Hole diameter is 0.166 +0.006 -0.000.				
<div>2</div> 161353 THRU 161528.				
<div>3</div> 161702 AND UP.				

Figure 4. Lower RH Instrument Panel Replacement

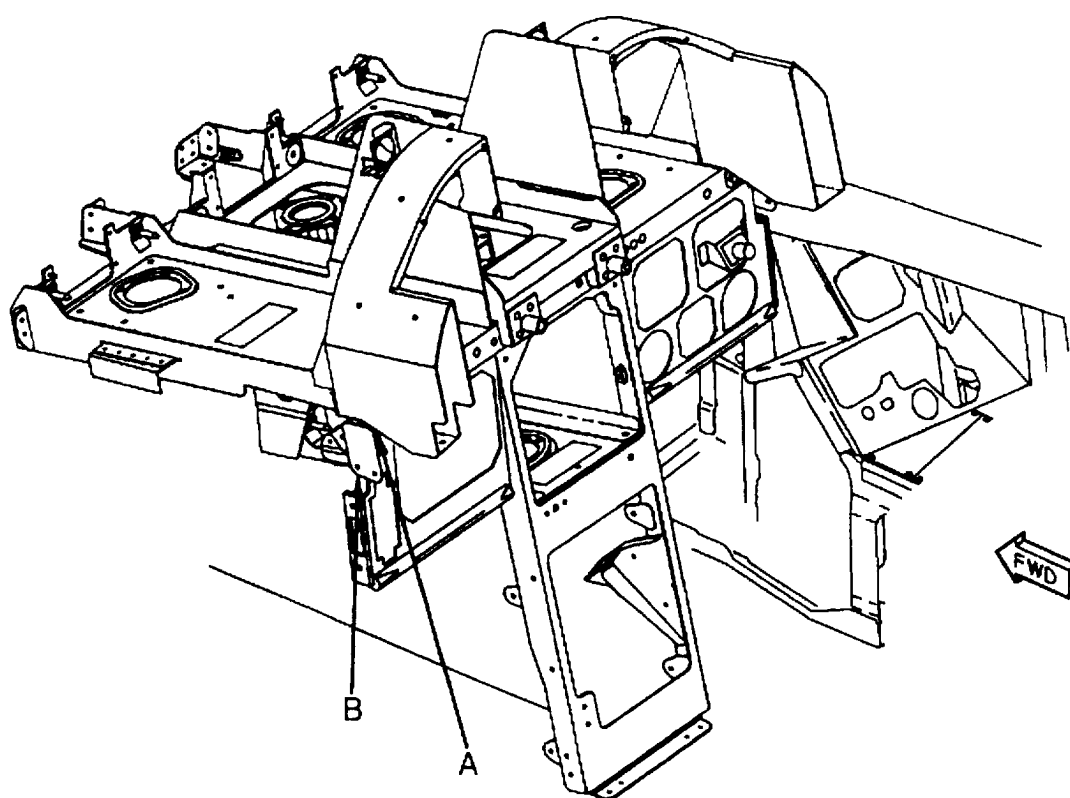


Figure 5. Main Instrument and Console, Replacement (Sheet 1)

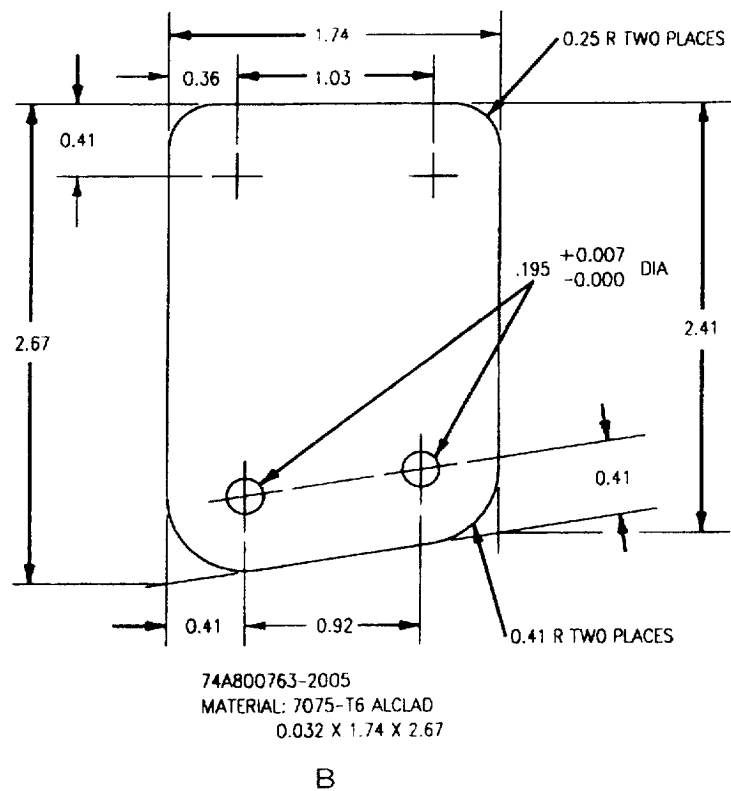
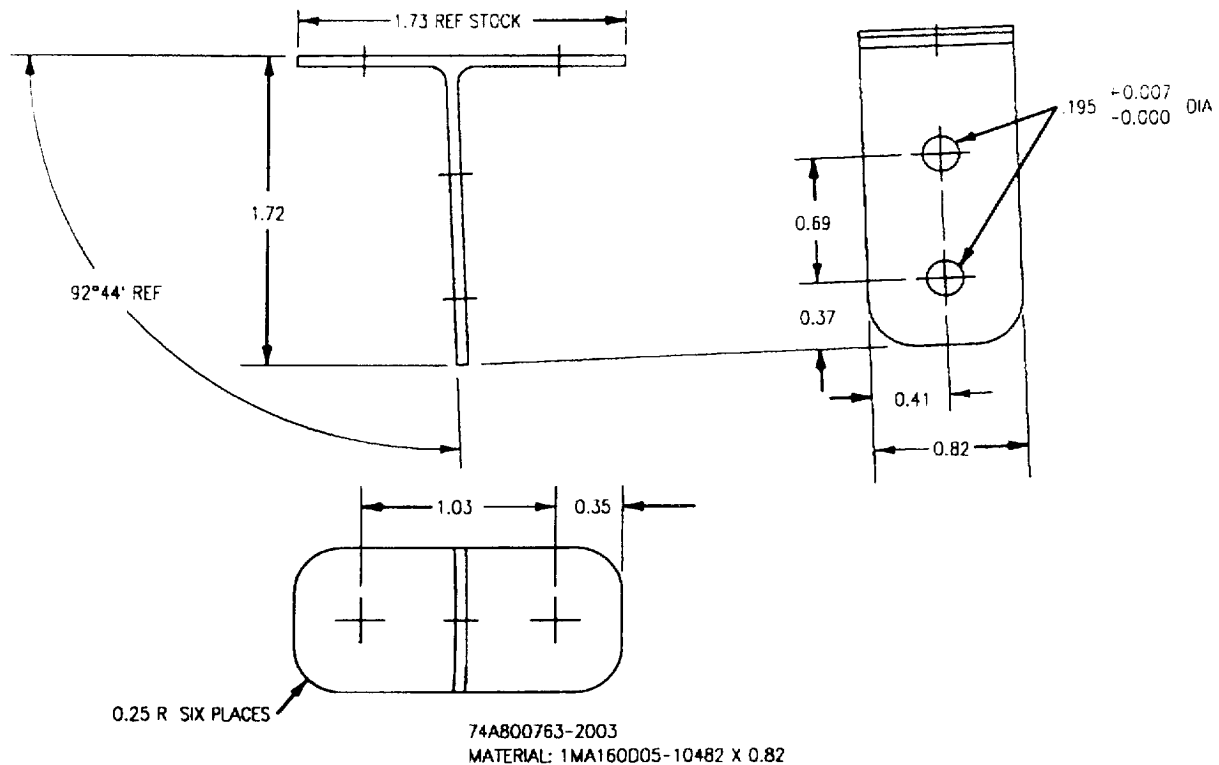


Figure 5. Main Instrument and Console, Replacement (Sheet 2)

11. MAIN INSTRUMENT AND CONSOLE, INTERMEDIATE MAINTENANCE.

a. Tee, (74A800763-2003). Fabrication and installation are shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 014 00). Apply finish as required (A1-F18AC-SRM-500, WP021 00).

b. Plate, (74A800763-2005). Fabrication and installation are shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 014 00). Apply finish as required (A1-F18AC-SRM-500, WP021 00).

12. CONSOLES.

13. **DAMAGE EVALUATION.** See figures 6 and 7. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figure 6. Repair zones are shown on figure 7. Allowable damage limits within repair zones are listed in tables 3 and 4. Damage not listed or exceeding the following limits require depot engineering disposition.

14. **Negligible Damage.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 3. The figure and index numbers in table 3 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

15. **Repairable Damage.** Repairable damage is damage that can be permanently repaired with no adverse affect on structural integrity, flight characteristics, or safety of the aircraft. Minor damage types and limits are listed below and in table 4. The figure and index numbers in table 4 coincide with the figure and index in the material index. Area limit applies after blending.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and lands must have edge of cleanup hole at least eight repair fastener diameters from any land, internal structure or existing row of fasteners.

(2) Damage to lands, over structure, only one repair per land.

e. Dents exceeding the limits in table 4 must be repaired.

16. **REPAIRS.** Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definitions are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

17. Permanent Repairs.

18. **Scratches, Nicks, Gouges, or Corrosion.** Blend scratches, nicks, gouges or corrosion (A1-F18AC-SRM-250, WP038 00). If after blending, the damage limits of table 4 are exceeded, repair aluminum as below. Refinish blended areas (A1-F18AC-SRM-500, WP021 00).

a. Scratches - make crack or edge repair.

b. Nicks, gouges, or corrosion - make hole or edge repair.

19. Cracks.

a. In repair zone A2, repair cracks free of structure or land areas in aluminum (A1-F18AC-SRM-250, WP031 00).

(1) Stop drill ends of crack in zone A2.

(2) In repair zone A2, install a lap patch for cracks.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone A2, repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zone A2, make repairs.

(a) Damage to Bay Requiring Repair
Across Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
Across Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay,
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

c. In repair zone A2, repair cracks to aluminum
formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zone A2, install repair one through
six. Select the repair that can be adapted to the damaged
part.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

20. Holes.

a. In repair zone A2, repair holes free of structure
or land areas in aluminum sheet (A1-F18AC-SRM-250,
WP031 00).

(1) Cut out damage.

(2) In repair zone A2, install a type one flush or
lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

b. In repair zone A2, repair holes across structure
or land areas in aluminum sheet (A1-F18AC-SRM-250,
WP036 00).

(1) Cut out damage.

(2) In repair zone A2, make repairs.

(a) Damage to Bay Requiring Repair
Across Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
Across Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay,
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

c. In repair zone A2, repair holes to aluminum
formed structure (A1-F18AC-SRM-250, WP033 00) as
below:

(1) Cut out damage.

(2) In repair zone A2, install repair one through
six. Select the repair that can be adapted to the damaged
part.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

21. Edge. In repair zone A2, repair edge damage in
aluminum sheet (A1-F18AC-SRM-250, WP034 00).

a. Cut out damage.

b. Select and install repair patch.

(1) Corner Damage to Lands.

(2) Corner Damage to Lands and Bays.

(3) Edge Damage to Lands.

(4) Edge Damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

22. Dents.

a. In repair zone A2, repair dents free of structure
or land areas in aluminum sheet (A1-F18AC-SRM-250,
WP031 00).

(1) Cut out damage.

(2) In repair zone A2, install a type one flush or
lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

b. In repair zone A2, repair dents across structure
or land areas in aluminum sheet (A1-F18AC-SRM-250,
WP036 00) as below:

(1) Cut out damage.

(2) In repair zone A2, make repairs.

(a) Damage to Bay Requiring Repair
A cross Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay,
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

c. In repair zone A2, repair dents to aluminum
formed structure (A1-F18AC-SRM-250, WP033 00) as
below:

(1) Cut out damage.

(2) In repair zone A2, install repair one through
six. Select the repair that can be adapted to the damaged
part.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP021 00).

23. REPLACEMENT.

24. **Consoles.** See figure 8. Fastener attaching parts
are shown on figure. For fasteners (A1-F18AC-
SRM-420, FIG 014 00).

Table 3. Negligible Damage Limits

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 5 (1)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (2)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
		0.160	0.006	0.0006	100%	0.030	N/A
Fig 5 (3)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (4)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (5)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (6)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (7)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (8)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (10)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (11)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A

Table 3. Negligible Damage Limits (Continued)

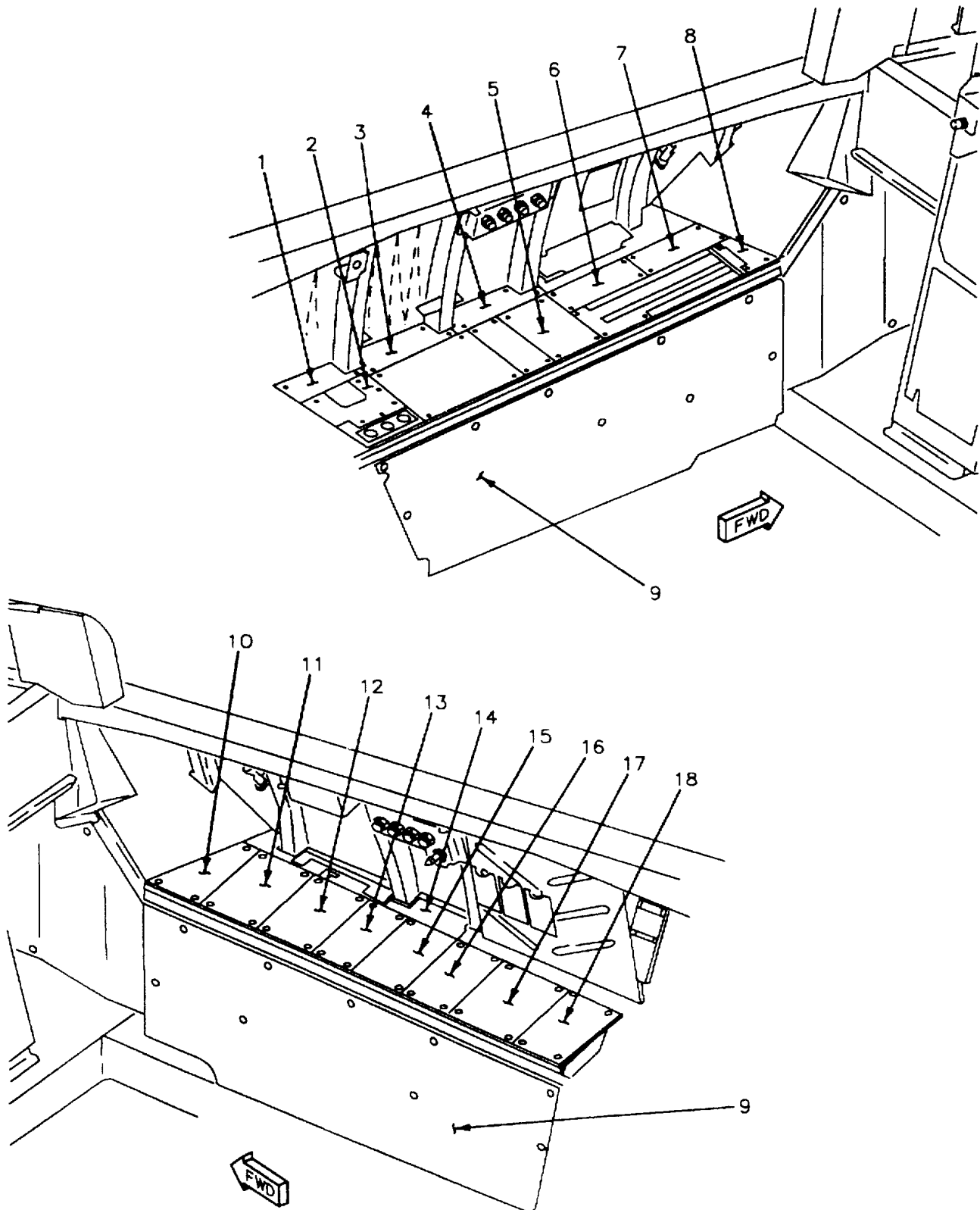
Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 5 (12)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (13)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (14)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (15)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (16)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (17)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A
Fig 5 (18)	Plate Zone A2	0.063	0.006	0.0006	100%	0.030	N/A

Table 4. Repairable Damage Limits After Blending

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 5 (1)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (2)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
		0.160	0.012	0.012	15%	0.012	15%
Fig 5 (3)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (4)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (5)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (6)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%

Table 4. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 5 (7)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (8)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (10)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (11)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (12)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (13)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (14)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (15)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (16)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (17)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%
Fig 5 (18)	Plate Zone A2	0.063	0.012	0.012	15%	0.012	15%



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Figure 6. Consoles Material Index (Sheet 1)








IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Plate 74A800696-2011	0.063 Sheet	7075-T6 Alclad
2		Plate 74A800843-9003 74A800843-2003	0.160 Sheet	7075-T76 Alclad
3		Plate 74A800698-2001	0.063 Sheet	7075-T6 Alclad
4		Plate 74A800703-2013	0.063 Sheet	7075-T6 Alclad
5		Plate 74A800799-2005 74A800799-9001 74A800799-2007	0.063 Sheet	7075-T6 Alclad
6		Plate 74A800637-2009 74A800637-2013	0.063 Sheet	7075-T6 Alclad
7		Plate 74A800705-2011 74A800705-2019 74A800705-2023	0.063 Sheet	7075-T6 Alclad
8		Plate 74A800765-2013 74A800765-2017	0.063 Sheet	7075-T6 Alclad
9		Cover (Door CPP) 74A800739-2039, -2045 74A800739-2039, -2061 74A800739-9029, -9027	0.030 Sheet	Thermoplastic
10		Plate 74A800645-2005 74A800645-2009	0.063 Sheet	7075-T6 Alclad
11		Plate 74A800646-2017	0.063 Sheet	7075-T6 Alclad
12		Plate 74A800651-2019	0.063 Sheet	7075-T6 Alclad
13		Plate 74A800735-2015	0.063 Sheet	7075-T6 Alclad
14		Plate 74A800709-2009	0.063 Sheet	7075-T6 Alclad

Figure 6. Consoles Material Index (Sheet 2)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
15		Plate 74A800830-2001	0.063 Sheet	7075-T6 Alclad
16		Plate 74A800790-2001	0.063 Sheet	7076-T6 Alclad
17		Plate 74A800831-2001	0.063 Sheet	7075-T6 Alclad
18		Plate 74A800707-2001	0.063 Sheet	7075-T6 Alclad
LEGEND				
<div>1</div> 161353 THRU 161361.				
<div>2</div> 161362 AND UP.				
<div>3</div> 161353 THRU 161528.				
<div>4</div> 161702 AND UP.				
<div>5</div> 161353 THRU 161359 AND 161520 THRU 161528.				
<div>6</div> 161360 THRU 161519.				
<div>7</div> 161702 THRU 161987.				
<div>8</div> 161353 THRU 161924.				
<div>9</div> 161925 THRU 162477 AND 162882 AND UP.				
<div>10</div> 162394 AND UP.				
<div>11</div> 162826 THRU 162881.				

Figure 6. Consoles Material Index (Sheet 3)

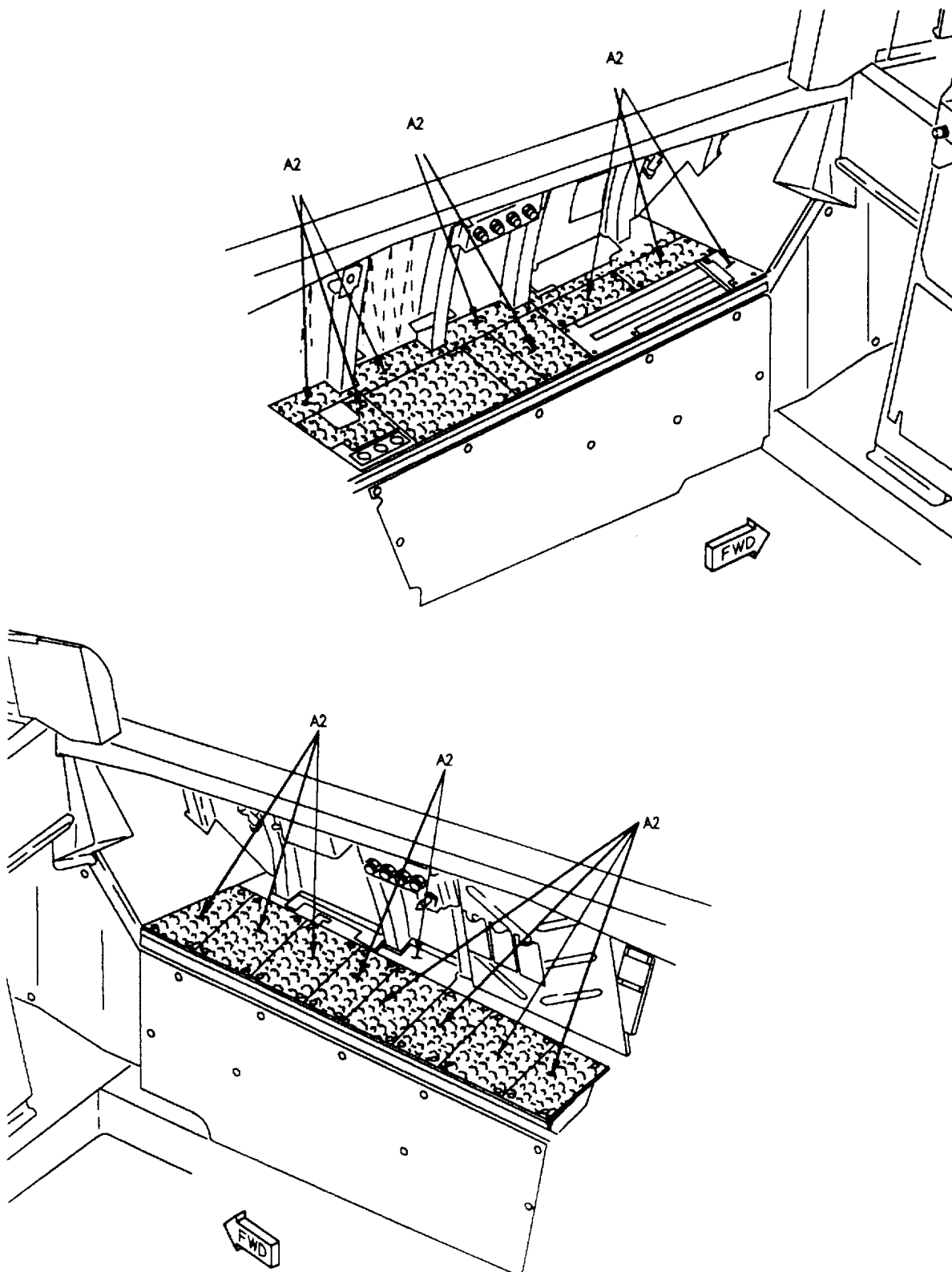


Figure 6. Consoles Material Index (Sheet 1)

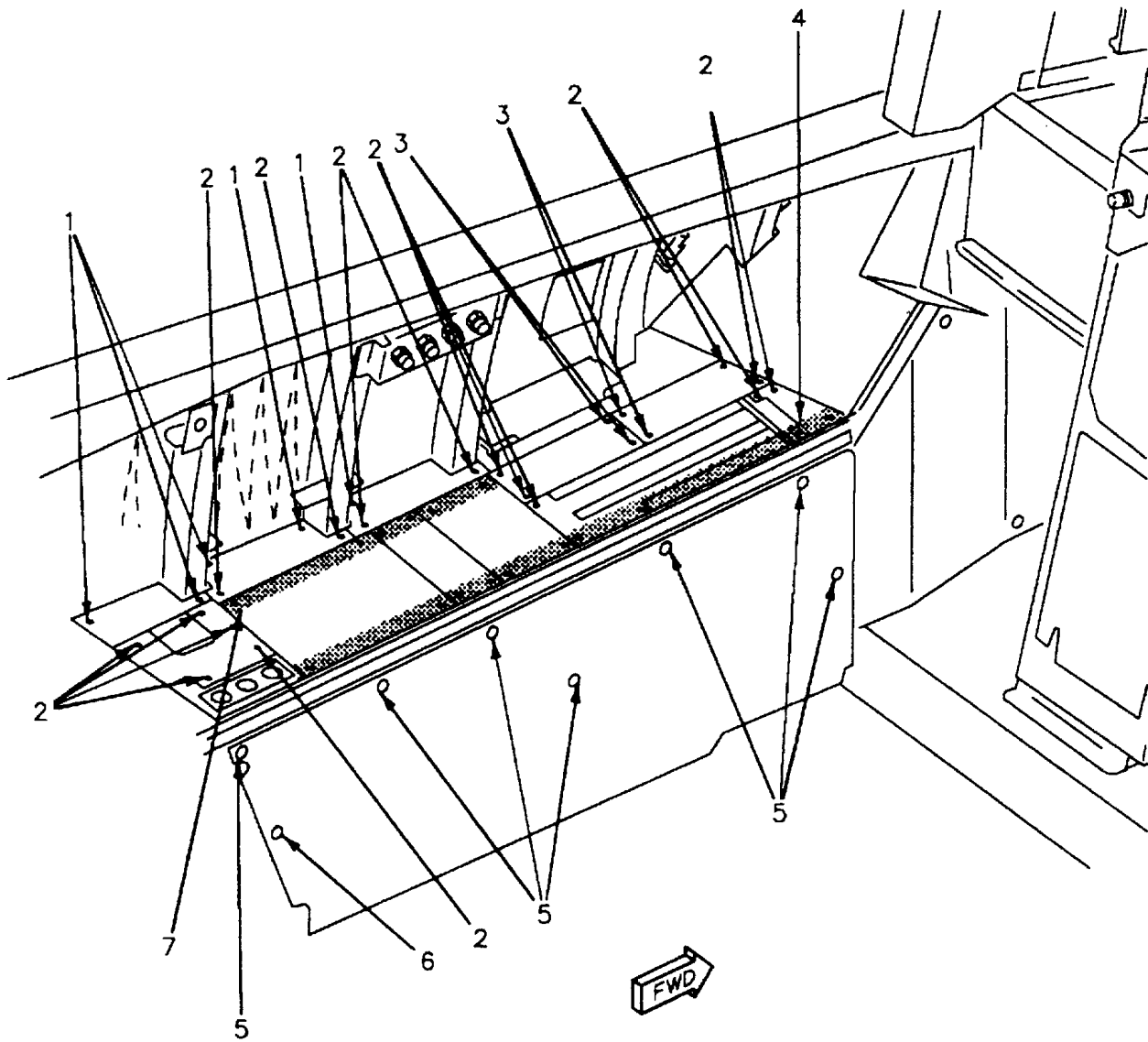


Figure 8. Consoles Replacement (Sheet 1)

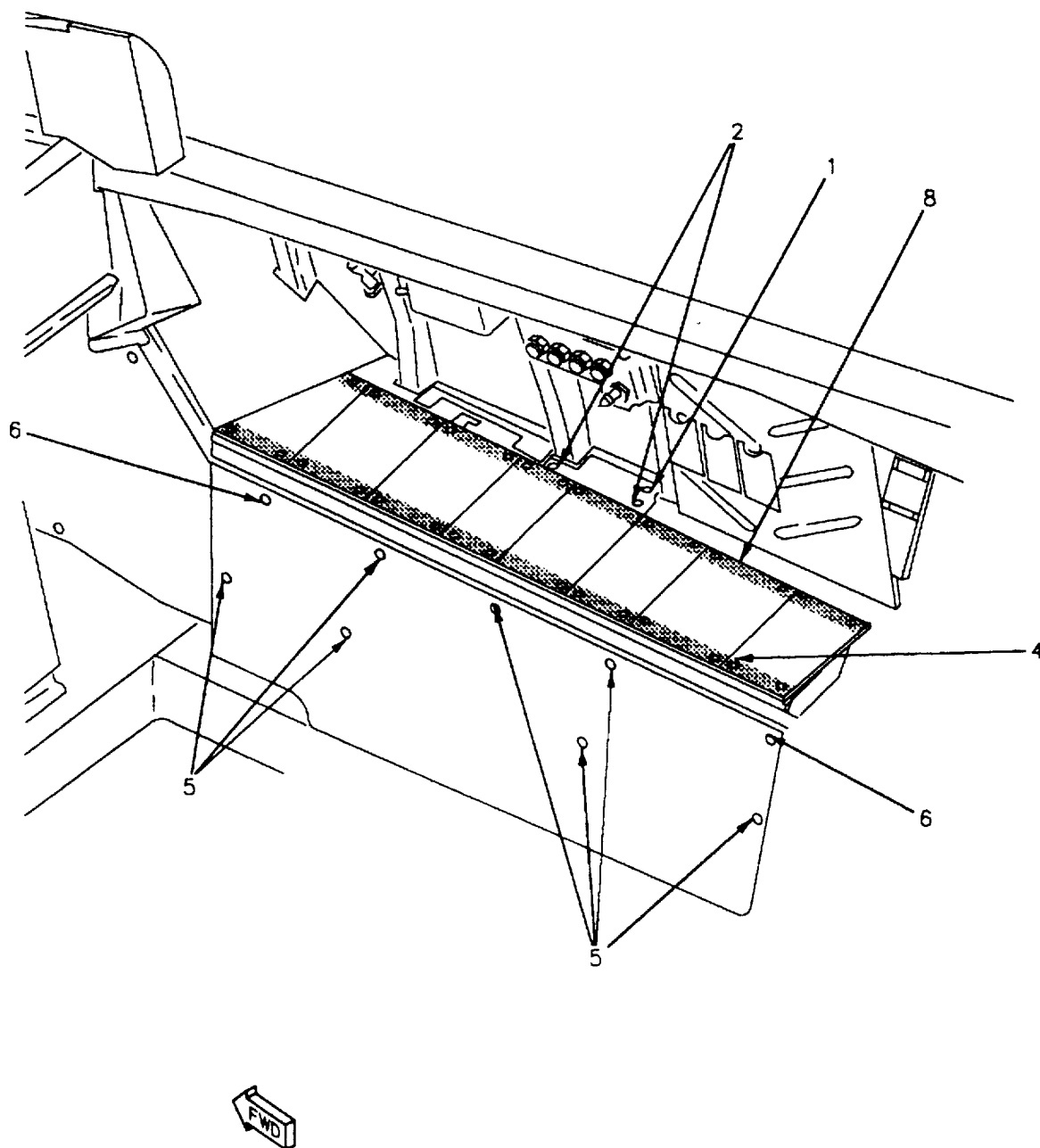


Figure 8. Consoles Replacement (Sheet 2)












IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Receptacle	PRG3-1-2
2			Receptacle	9M856F1
3			Receptacle	9M841F2
4			Receptacle	ST9M571-86
5			Plate Nut	MS21060L3
6			Plate Nut	MS21062L3
7			Receptacle Strip	9M841F32
8			Receptacle Strip	9M841F74
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.250 +0.006 -0.000.</p> <p> Hole diameter is 0.242 +0.006 -0.000.</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p>				

Figure 8. Consoles Replacement (Sheet 3)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

REAR COCKPIT MAIN INSTRUMENT PANEL AND CONSOLES

Reference Material

None

Alphabetical Index

Subject	Page No.
Consoles	1
Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1
Rear Cockpit Main Instrument Panel	1
Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1

Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

None

1. REAR COCKPIT MAIN INSTRUMENT PANEL.

2. **DAMAGE EVALUATION.** See figure 1. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The figure identifies types of material used.

3. **Negligible Damage.** Damage requires depot engineering disposition.

4. **Repairable Damage.** Damage requires depot engineering disposition.

5. **REPAIRS.** Repairs require depot engineering disposition.

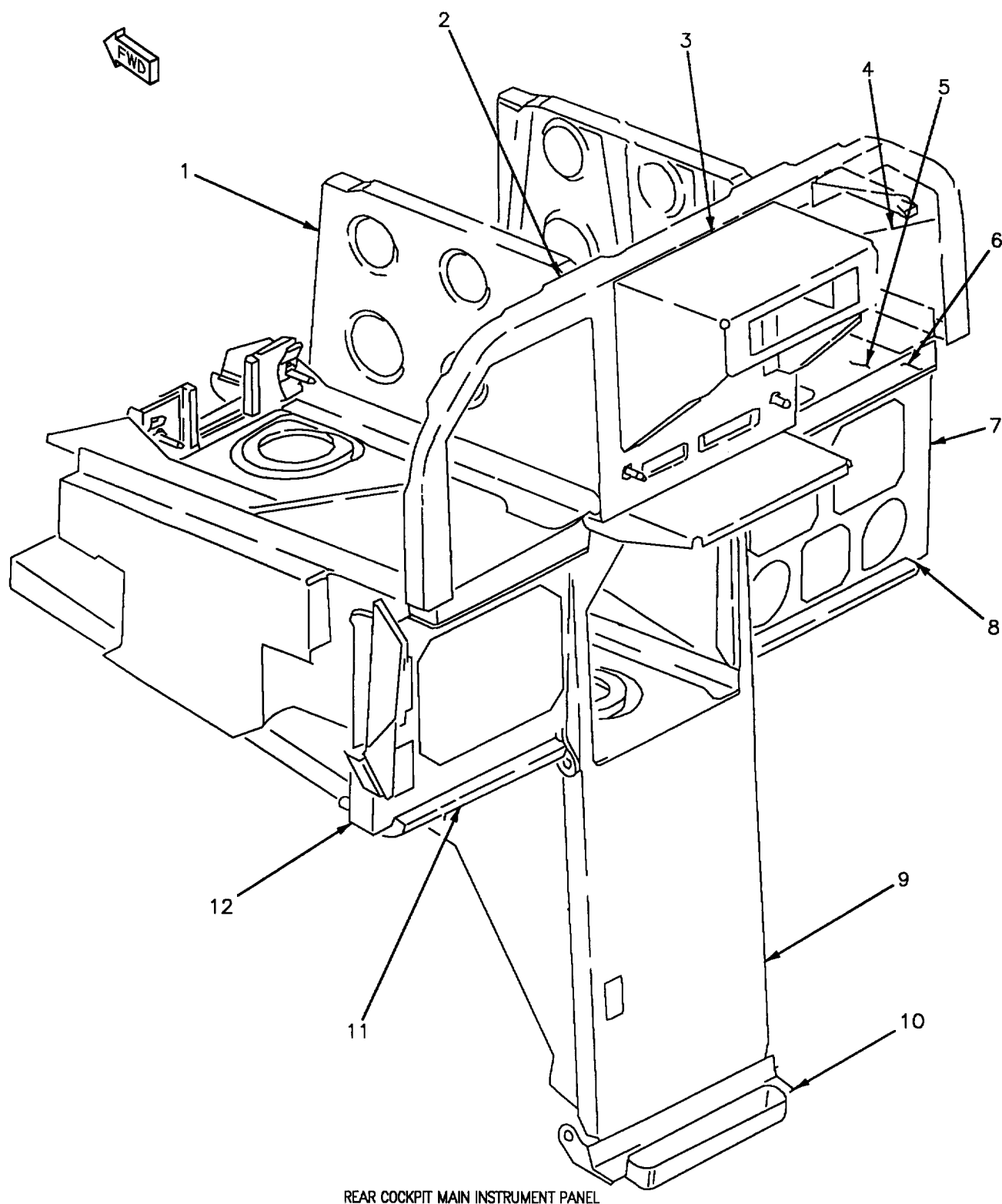
6. CONSOLES.

7. **DAMAGE EVALUATION.** See figure 2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The figure identifies types of material used.

8. **Negligible Damage.** Damage requires depot engineering disposition.

9. **Repairable Damage.** Damage requires depot engineering disposition.

10. **REPAIRS.** Repairs require depot engineering disposition.



18AC-SRM-222-(18-1)01-SCAN

Figure 1. Material Index (Sheet 1)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	 	Gusset 74A802601-2017, -2018 74A802601-2067, -2068	0.050 Sheet	7075-T6 Alclad
2	 	Panel 74A802601-2047 74A802601-2061	0.080 Sheet	7075-T6 Alclad
3		Bracket 74A802601-2015	0.063 Sheet	7075-T6 Alclad
4		Gusset 74A802601-2039, -2040	0.050 Sheet	7075-T6 Alclad
5		Web 74A802077-2049	0.050 Sheet	7075-T6 Alclad
6	 	Channel 74A802077-2051 74A802077-2065	1MA120D05-10073 Extr	7075-T73511 Al Aly
7		Panel 74A802605-2005	2.75 Plate	7075-T7351 Al Aly
8		Guard 74A802083-2003	11M962-1 Extr	Silicone Rubber
9	 	Panel 74A802600-2013 74A802600-2015	1.75 Plate	7075-T7351 Al Aly
10		Support 74A314864-2001	2.25 Plate	7075-T7351 Al Aly
11	 	Guard 74A802083-2003 74A802083-2005	11M962-1 Extr	Silicone Rubber
12	 	Panel 74A802604-2005 74A802604-2007	2.75 Plate	7075-T7351 Al Aly
LEGEND				
 F/A-18B 161354 THRU 161360.  F/A-18B 161704 AND UP.  F/A-18B 161354 THRU 161740.  F/A-18B 161746 AND UP.  F/A-18B 161354 THRU 161714.  F/A-18B 161719 AND UP.				

Figure 1. Material Index (Sheet 2)

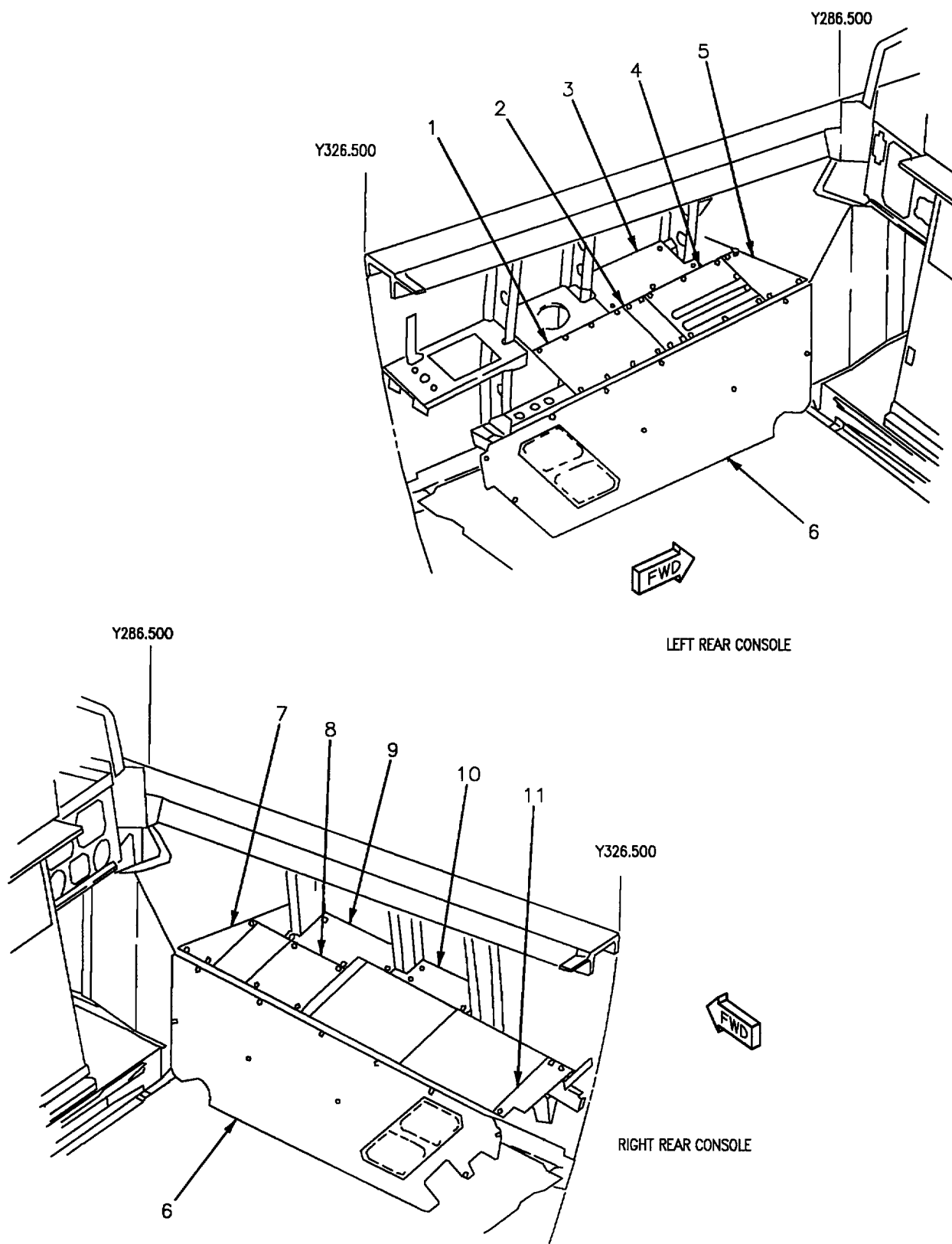


Figure 2. Material Index (Sheet 1)













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3		Plate 74A802633-2005	0.063 Sheet	7075-T6 Alclad
4	 	Panel 74A802639-2003 74A802639-2009	0.063 Sheet	7075-T6 Alclad
5	 	Panel 74A802636-2009 74A802636-2021	0.063 Sheet	7075-T6 Alclad
6	 	Cover 74A802646-2005, -2006 74A802646-2011, -2006	0.030 Sheet	Thermoplastic Polycarbonate
7		Panel 74A802636-2003	0.063 Sheet	7075-T6 Alclad
8		Panel 9M381B12	0.063 Sheet	2024-T3 Al Aly
9		Panel 74A802636-2017	0.063 Sheet	7075-T6 Alclad
10		Plate 74A802619-2017	0.063 Sheet	7075-T6 Alclad
11	 	Panel 74A802636-2007 74A802636-2019	0.063 Sheet	7075-T6 Alclad
LEGEND				
 F/A-18B 161354 THRU 161360.				
 F/A-18B 161704 AND UP.				
 F/A-18B 161354 THRU 161707.				
 F/A-18B 161711 AND UP.				

Figure 2. Material Index (Sheet 2)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

MAP AND DATA STOWAGE CASE

Reference Material

Structure Illustrated Parts Breakdown Forward Fuselage	A1-F18AC-SRM-420
Case - Stowage, Map and Data	FIG 016 00
Crew Station Furnishing, Rear Cockpit - Instl of, F/A-18B	FIG 019 00

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Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1
Replacement	1
Map and Data Stowage Case, Cockpit	1
Map and Data Stowage Case, Rear Cockpit	1
Compass Card Holder	2

Record of Applicable Technical Directives

None

Support Equipment Required

Part Number or Type Designation	Nomenclature
GGG-M-125/6	Respirator
MIL-G-12223, TYPE 2	Gloves, Toxicological
ZZ-B-530	Rubber Boots
ZZ-A-605	Rubber Apron
L-F-336	Faceshield

1. **DAMAGE EVALUATION.** See figures 1 and 2.
2. The figure identifies types of material used. The data shown can be used to analyze the damage.
3. **NEGLIGIBLE DAMAGE.** Damage requires depot engineering disposition.
4. **REPAIRABLE DAMAGE.** Damage requires depot engineering disposition.
5. **REPAIRS.**
6. Repairs require depot engineering disposition.
7. **REPLACEMENT.**

Materials Required

Specification or or Part Number	Nomenclature
GG-D-226, TYPE 1	Depressor, Tongue
A-A-1047, GRIT 180x9x11	Paper, Abrasive
D 1153	Methyl Isobutyl Ketone
URALANE 5774 A/B	Adhesive
CCC-C-46	Cleaning Cloth
TYPE 1, CLASS 1	

8. **Map and Data Stowage Case, Cockpit.** Case is interchangeable. Fastener attaching parts are shown on figure 3. For fasteners (A1-F18AC-SRM-420, FIG 016 00).
9. **Map and Data Stowage Case, Rear Cockpit.** Case is interchangeable. Fastener attaching parts are shown on figure 4. For fasteners (A1-F18AC-SRM-420, FIG 019 00).

10. Compass Card Holder(s)

a. Remove map and data stowage case and set on horizontal surface away from aircraft.

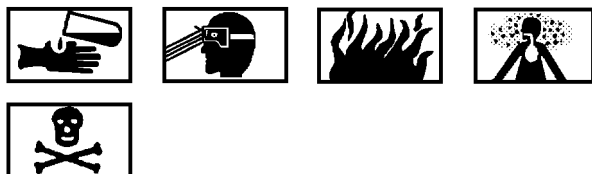
NOTE

It is not necessary to abrade through existing adhesive material to bare surface of map and data stowage case or detached card holder(s).

b. If required, obtain replacement compass card holder(s) (P/N ST9M564-1). Abrade mating surfaces of map and data stowage case and compass card holder(s) using 180 grit abrasive paper.

c. Clean abraded surfaces (A1-F18AC-SRM-500, WP006 00).

d. Preparation of URALANE 5774 A/B adhesive.



Adhesive, URALANE 5774 A/B

8

NOTE

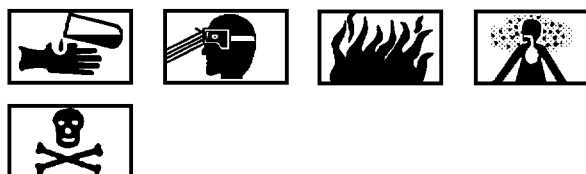
Mix only amount of materials to be used in 15 minutes at room temperature (77 °F).

(1) In container, combine by weight 100 parts of part A with 55 parts of part B.

(2) Mix components thoroughly for 2 to 3 minutes. URALANE 5774 A/B adhesive will be uniform in color when mixed.

(3) Allow URALANE 5774 A/B adhesive to set 3 minutes for air bubble removal before application.

e. Apply URALANE 5774 A/B adhesive to mating surfaces of map and data stowage case and compass card holder.



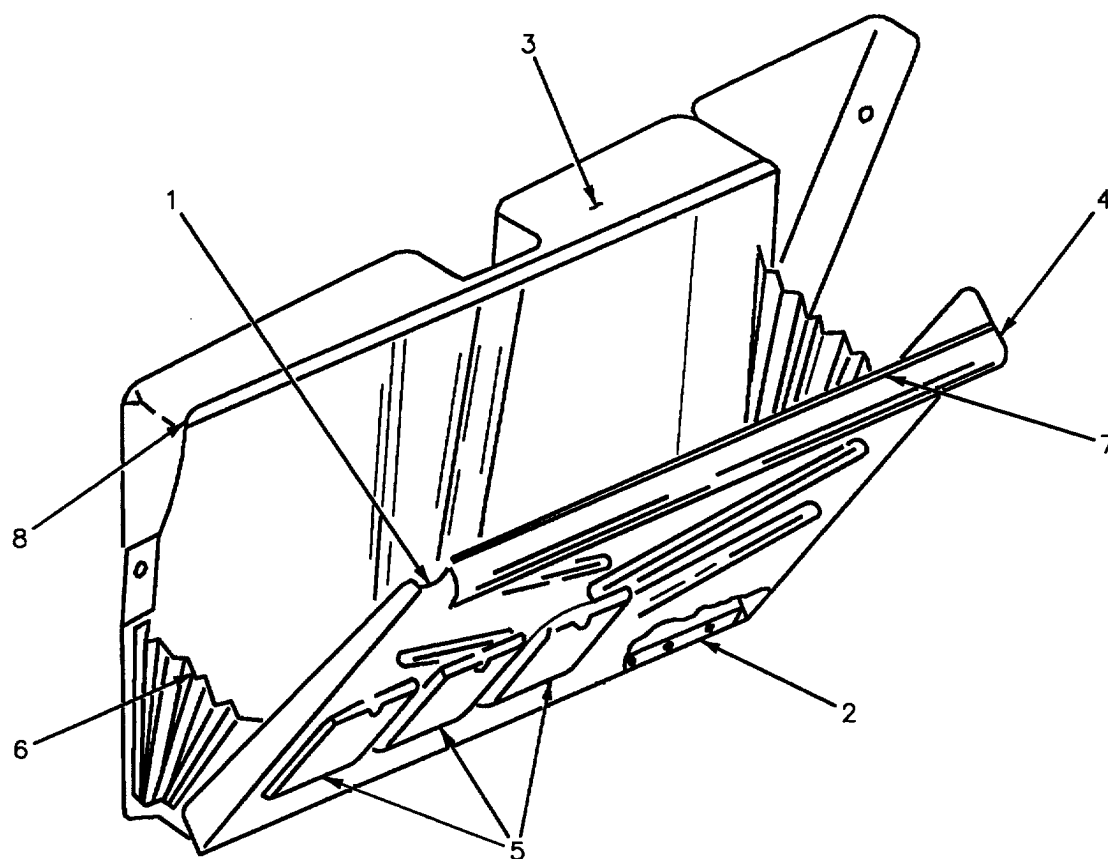
Methyl Isobutyl Ketone D 1153

9

f. Position and lightly press into place compass card holder(s) onto mating surface of map and data stowage case. Remove squeeze out with cleaning cloth, moistened with methyl isobutyl ketone.

g. Allow to cure at room temperature, (77 °F) for 24 hours.

h. Reinstall map and data stowage case.



18AC-SRM-222-(20-1)01-SCAN

Figure 1. Material Index, Map and Data Stowage Case, Cockpit (Sheet 1)











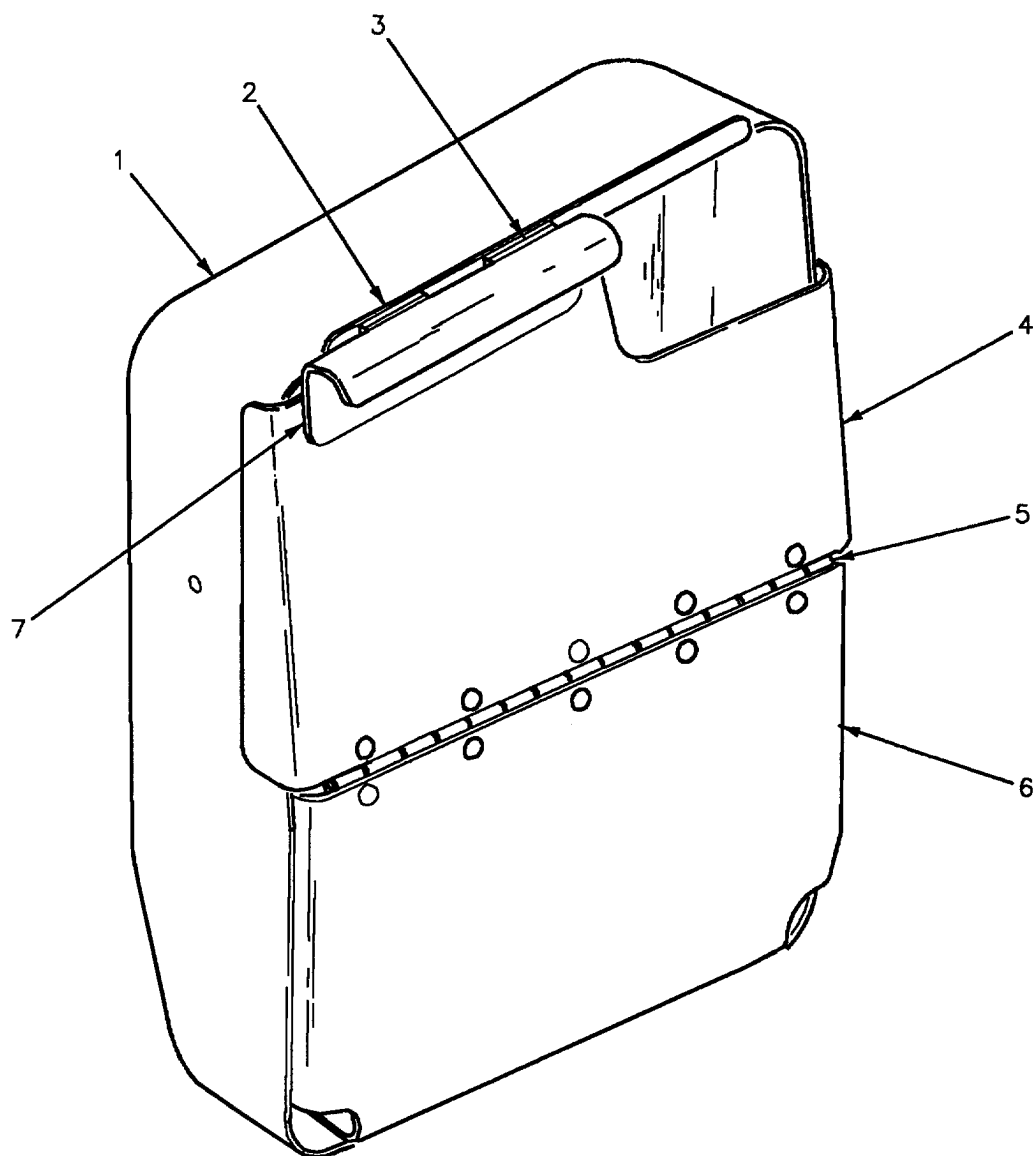
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Cover 74A800654-2019	Sheet	Thermoplastic
2		Hinge MS20257HP1-1068	0.032 Sheet	Al Aly
3		Case 74A800654-2025	Sheet	Thermoplastic
4		Cap 74A800654-2023	Sheet	Thermoplastic
5		Holder ST9M564-1	0.040 Sheet	
6		Bellows 74A800655-2005		Nylon
7	 	Tape 74A800654-2015 74A800654-2029	0.75 Wide	Nylon-Velcro
8	 	Tape 74A800654-2013 74A800654-2027	0.75 Wide	Nylon-Velcro
<p align="center">LEGEND</p> <p> Case, aluminum; Cover, clear vinyl copolymer plastic.</p> <p> 16-18 ounce/square yard, Neoprene coated.</p> <p> 161353 THRU 162852.</p> <p> 162853 AND UP.</p>				

Figure 1. Material Index, Map and Data Stowage Case, Cockpit (Sheet 2)

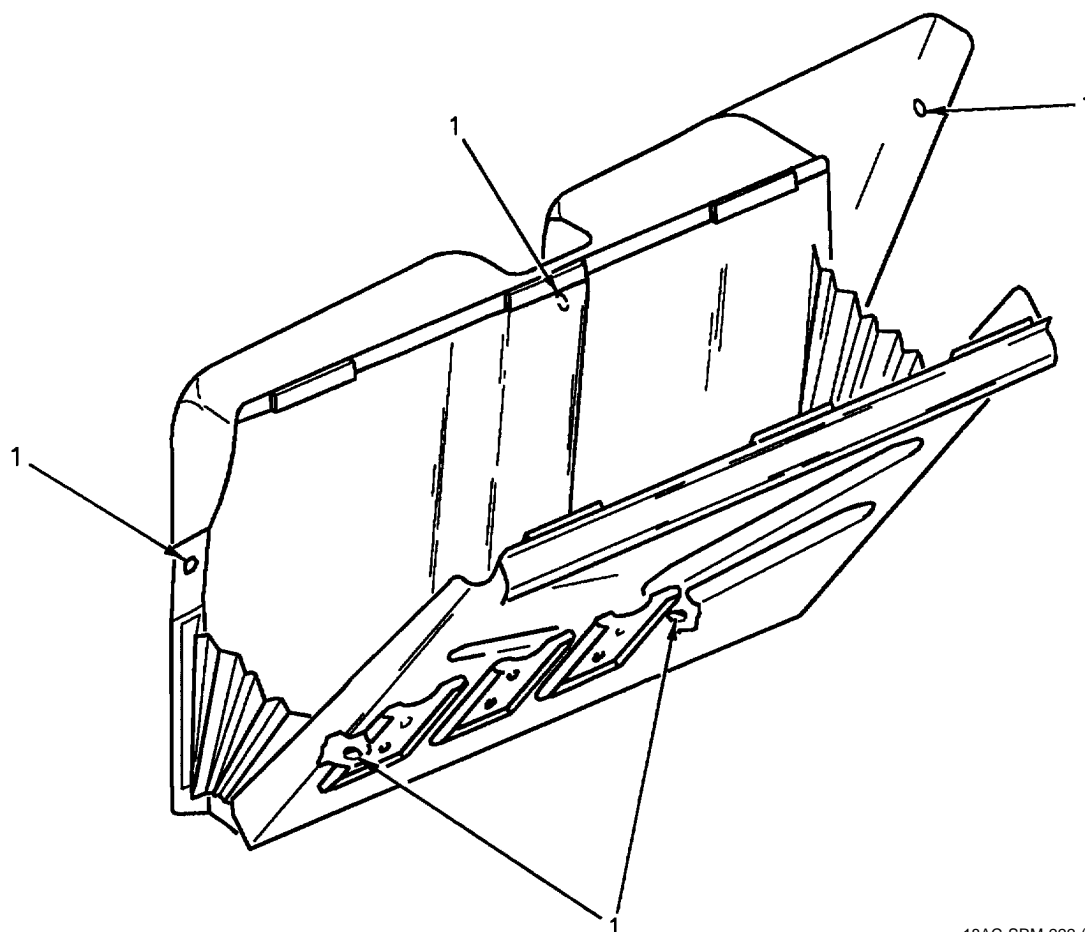


18AC-SRM-222-(21-1)01-SCAN

Figure 2. Material Index, Map and Data Stowage Case, Rear Cockpit (Sheet 1)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>1</div> <div>2</div>	Case 74A802620-2001 74A802620-2017	Sheet	Thermoplastic
2		Tape 74A802620-2011	0.75 Wide	Nylon-Velcro
3		Tape 74A802620-2009	0.75 Wide	Nylon-Velcro
4		Cover 74A800654-2023	Sheet	Thermoplastic
5		Hinge MS20257HP2-750	0.040 Sheet	Al Aly
6		Closure 74A802620-2003	Sheet	Thermoplastic
7		Handle 74A802620-2015	Sheet	Thermoplastic
LEGEND				
<div>1</div> F/A-18B 161354 THRU 161360.				
<div>2</div> F/A-18B 161704 AND UP.				

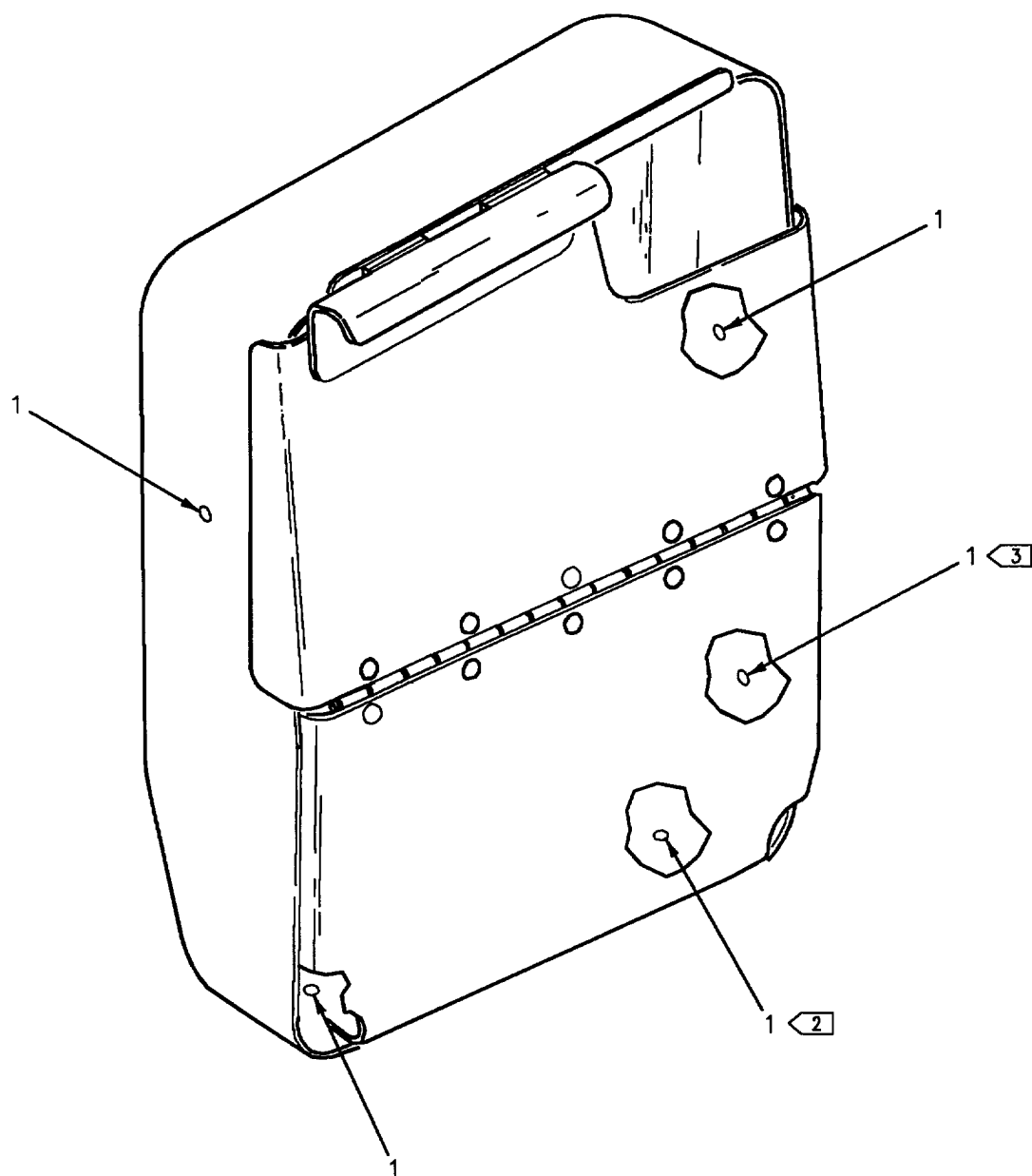
Figure 2. Material Index, Map and Data Stowage Case, Rear Cockpit (Sheet 2)



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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21060L3
LEGEND				
Hole diameter is 0.205 +0.006 - 0.000.				

Figure 3. Map and Data Stowage Case, Cockpit, Replacement



18AC-SRM-222-(23-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21060L3
LEGEND				
Hole diameter is 0.195 +0.007 -0.000.				
F/A-18B 161354 THRU 161360.				
F/A-18B 161704 AND UP.				

Figure 4. Map and Data Stowage Case, Rear Cockpit, Replacement

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

COCKPIT LINERS AND INSULATION BLANKETS

Reference Material

Aircraft Corrosion Control	A1-F18AC-SRM-500
Priming Procedures	WP011 00

Alphabetical Index

Subject	Page No.
Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1
74A800664 Blanket	1
Replacement	2
74A800664 Blanket	2

Record of Applicable Technical Directives

None

1. **DAMAGE EVALUATION.** See figure 1.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of material used are shown on figure 1. Damage not listed or exceeding the following limits requires depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage may be allowed to exist as is. The type and limits for 74A800664 blankets are:

a. Damage less than 0.50 inch in length.

b. Damage less than 0.50 inch in diameter.

4. **REPAIRABLE DAMAGE.** Repairable damage is damage that can be permanently repaired with no ad-

verse affect on structural integrity, flight characteristics, or safety of the aircraft. Damages are unlimited in size or number for 74A800664 blankets.

5. **REPAIRS.**6. **74A800664 BLANKET.**

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
K-836	Blanket, Thermal

Materials Required (Continued)

Specification or Part Number	Nomenclature
H-B-695 TYPE 1 GRADE A SIZE 1	Brush, Varnish
RTV-732, CLEAR	Adhesive
TT-M-261	Methyl Ethyl Ketone



Methyl Ethyl Ketone, TT-M-261 10

a. Wipe area to be repaired with clean cheesecloth moistened with methyl ethyl ketone.

b. Fabricate patch 1 inch larger than damaged area using K-836 thermal blanket material.



Adhesive, RTV-732 11

NOTE

It is not necessary to apply adhesive to both surfaces being bonded.

c. Brush apply a thin coat of adhesive to one of the bonding surfaces.

d. Install patch over damaged area.

e. Work out trapped air between blanket and repair patch.

f. Allow to air dry for 24 hours.

7. REPLACEMENT.

8. **74A800664 BLANKET.** See figure 2.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1 63210	Cheesecloth Blanket, Thermal Scraper
H-B-695 TYPE 1 GRADE A, SIZE 1	Brush, Varnish
RTV-732, CLEAR 1200 RTV Prime Coat-Clear	Adhesive Primer, Adhesive
TT-M-261	Methyl Ethyl Ketone
B-4, B-6, E-12, E-18, Owens-Corning	Thread, Fiberglass

a. Remove blanket and any residual adhesive and/or remnants of blanket from structure using plastic scraper.



Methyl Ethyl Ketone, TT-M-261 10

b. Wipe exposed structure where blanket was removed with clean cheesecloth moistened with methyl ethyl ketone.

c. Apply priming procedures as required to structure (A1-F18AC-SRM-500, WP011 00).

NOTE

Insulation blanket may be fabricated with round or square corners.

- d. Make a pattern of area requiring blanket.
- e. Lay out blanket 1 inch larger than pattern.

NOTE

Fastener and spacer holes shall be punched or cut out on installation.

- f. Cut out blanket.

NOTE

Gray side of blanket is inner facing.

- g. Remove 0.75 inch of batting and facing from outer surface of blanket. See detail A.

NOTE

Stitching shall meet the requirements of federal specification STD-751, Type 301, using five to eight stitches per inch.

- h. Fold inner facing over outer facing and stitch a minimum of 0.50 inch from edge using fiberglass thread. See detail B.

- i. Cutouts and slots are fabricated per procedures below:

(1) Cutouts and slots 0.50 to 1.50 inch diameter are backstitched 0.50 inch from edge. See detail C.

(2) Cutouts and slots exceeding 1.50 inch diameter have fabricated edges per steps g and h. See detail D.



Primer, Adhesive, 1200 RTV

12

- j. Apply a light coat of adhesive primer to structure using clean cheesecloth.

- k. Allow adhesive primer to air dry a minimum of 45 minutes before application of adhesive.



Adhesive, RTV-732

11

NOTE

It is necessary to apply adhesive to both surfaces being bonded.

- l. Brush apply a thin coat of adhesive to one of the bonding surfaces.

NOTE

Electrical wiring and clamps shall be left exposed when cementing insulation blanket to structure.

- m. Install blankets to fit snug against structure. See detail E.

- n. Work out trapped air between blanket and structure.

- o. Allow to air dry for 24 hours.

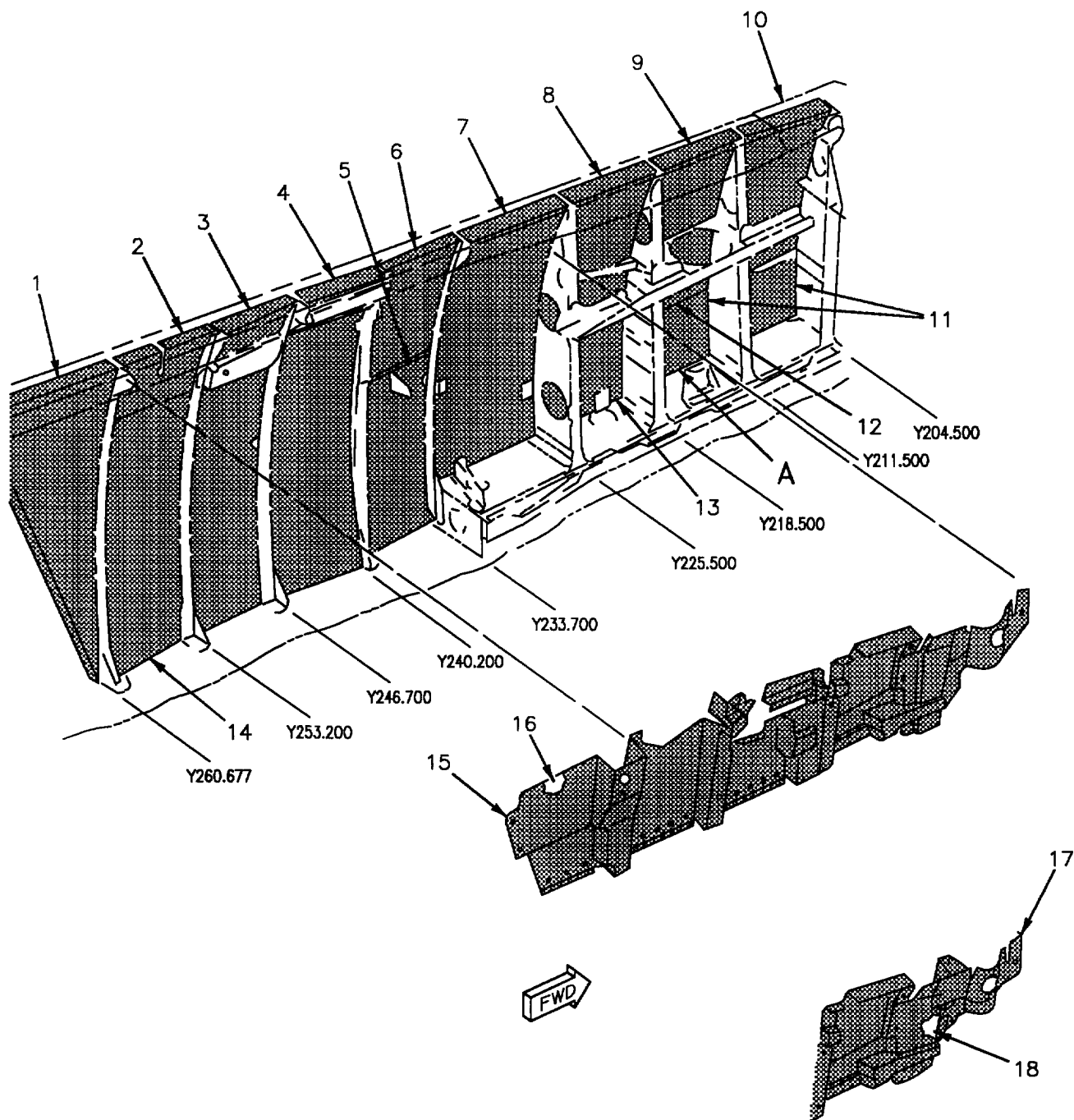


Figure 1. Material Index (Sheet 1)

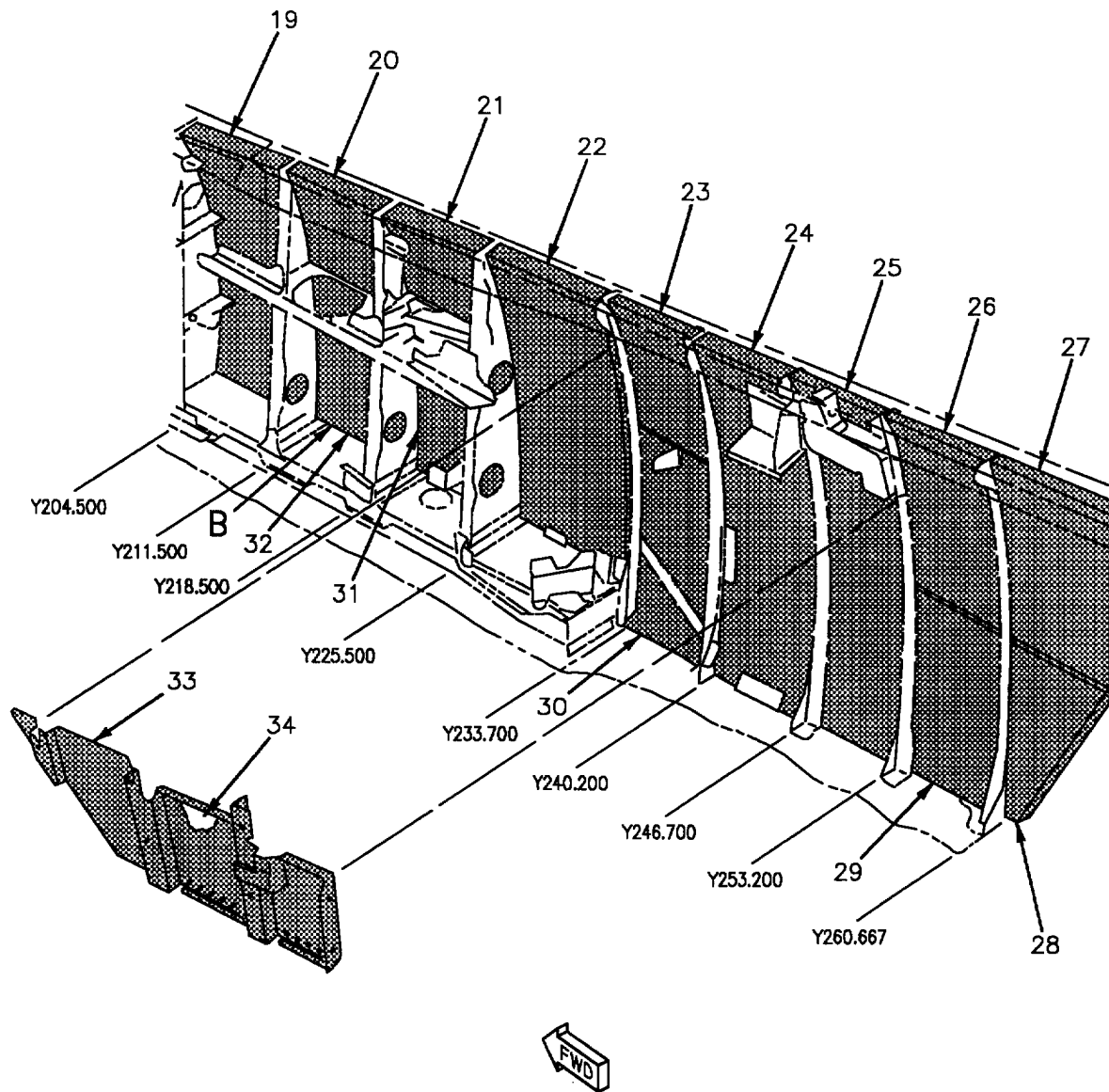


Figure 1. Material Index (Sheet 2)

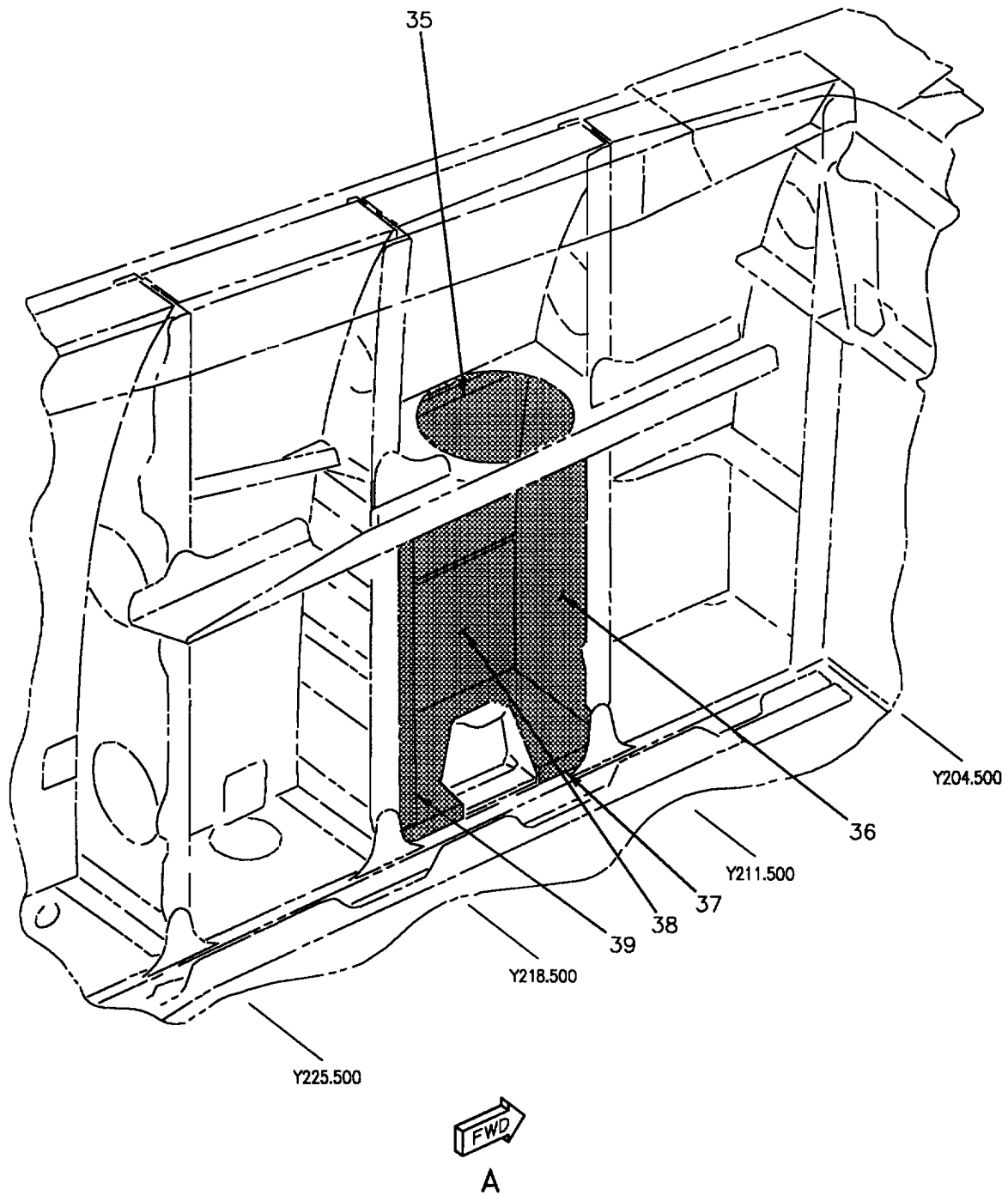


Figure 1. Material Index (Sheet 3)

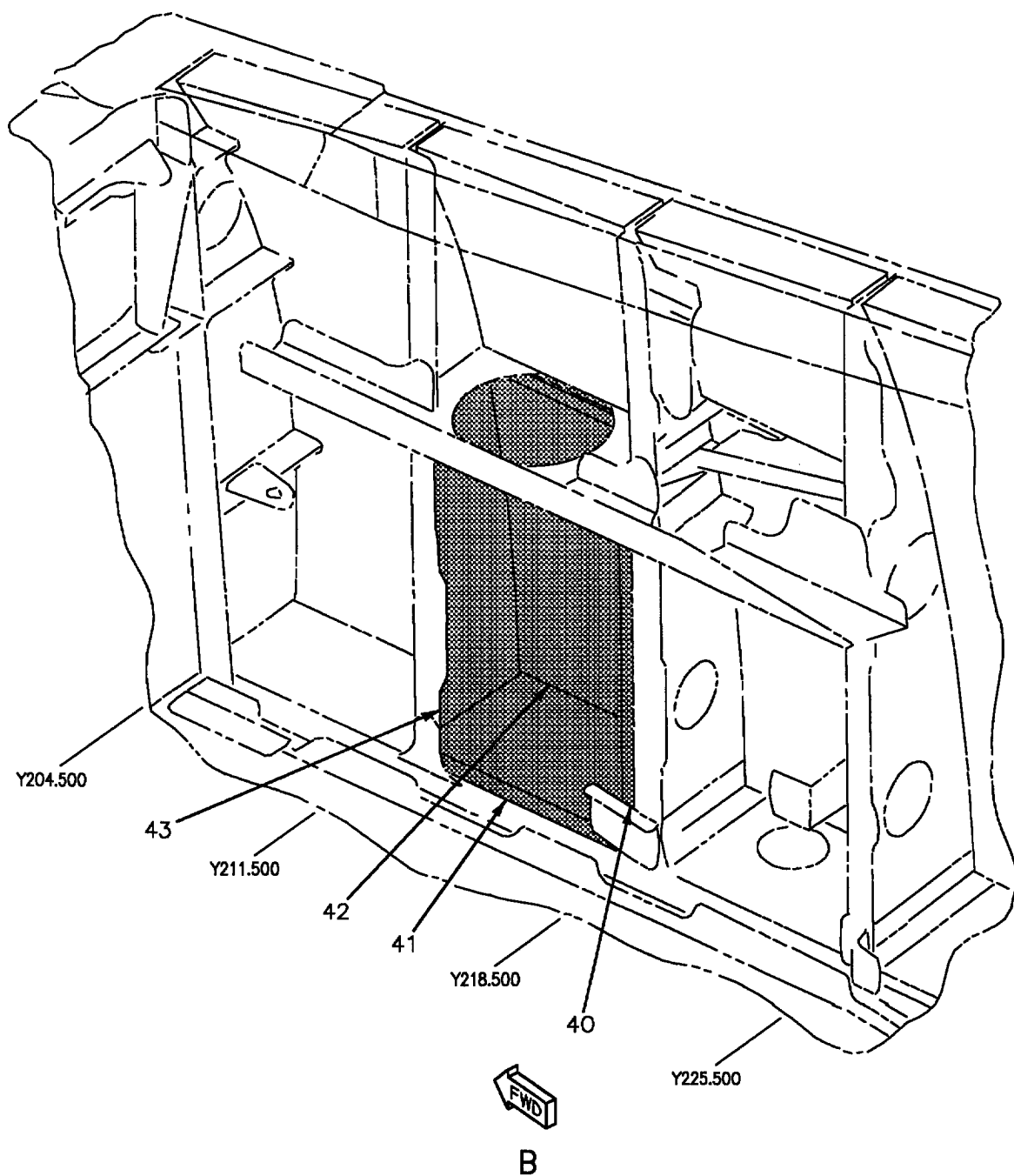


Figure 1. Material Index (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Blanket 74A800664-2001	1.50 Thickness	
2		Blanket 74A800664-2023	1.50 Thickness	
3		Blanket 74A800664-2005	1.50 Thickness	
4		Blanket 74A800664-2007	1.50 Thickness	
5		Blanket 74A800664-2009	1.50 Thickness	
6		Blanket 74A800664-2039	1.50 Thickness	
7		Blanket 74A800664-2011	1.50 Thickness	
8		Blanket 74A800664-2027	1.50 Thickness	
9		Blanket 74A800664-2029	1.50 Thickness	
10		Blanket 74A800664-2031	1.50 Thickness	
11		Blanket 74A800664-2015	1.50 Thickness	
12		Blanket 74A800664-2017	1.50 Thickness	
13		Blanket 74A800664-2013	1.50 Thickness	
14		Blanket 74A800664-2003	1.50 Thickness	
15	 	Liner (Door CPAE) 74A800665-2069 74A800665-2077 74A800665-2081 74A800665-2087	Sheet	Thermoplastic
16	 	Backing 74A800665-2071 74A800665-2079 74A800665-2083	0.005 Roll	Aluminum Foil

Figure 1. Material Index (Sheet 5)





















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
17	 	Liner (Door CPAD) 74A800665-2065 74A800665-2085	Sheet Sheet	Thermoplastic Polycarbonate
18		Backing 74A800665-2067	0.005 Roll	Aluminum Foil
19		Blanket 74A800664-2033	1.50 Thickness	
20		Blanket 74A800664-2030	1.50 Thickness	
21		Blanket 74A800664-2028	1.50 Thickness	
22		Blanket 74A800664-2012	1.50 Thickness	
23		Blanket 74A800664-2026	1.50 Thickness	
24		Blanket 74A800664-2008	1.50 Thickness	
25		Blanket 74A800664-2006	1.50 Thickness	
26		Blanket 74A800664-2036	1.50 Thickness	
27		Blanket 74A800664-2038	1.50 Thickness	
28		Blanket 74A800664-2002	1.50 Thickness	
29		Blanket 74A800664-2019	1.50 Thickness	
30		Blanket 74A800664-2010	1.50 Thickness	
31		Blanket 74A800664-2014	1.50 Thickness	
32		Blanket 74A800664-2035	1.50 Thickness	
33	  	Liner (Door CPAF) 74A800666-2009 74A800666-2013 74A800666-2017	Sheet Sheet	Thermoplastic Polycarbonate

Figure 1. Material Index (Sheet 6)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
34	8 9	Backing 74A800866-2011 74A800866-2015	0.005 Roll	Aluminum Foil
35		Blanket 74A800812-2003	0.50 Thickness	2
36		Blanket 74A800812-2009	0.50 Thickness	2
37		Blanket 74A800812-2007	0.50 Thickness	2
38		Blanket 74A800812-2005	0.50 Thickness	2
39		Blanket 74A800812-2001	0.50 Thickness	2
40		Blanket 74A800812-2013	0.50 Thickness	2
41		Blanket 74A800812-2015	0.50 Thickness	2
42		Blanket 74A800812-2011	0.50 Thickness	2
43		Blanket 74A800812-2017	0.50 Thickness	2
LEGEND 1 63210 thermal blanket. 2 Polyether scottfelt 5-650 EZ foam. 3 161353 THRU 161714. 4 161715 THRU 161965. 5 161966 THRU 162477. 6 162826 AND UP. 7 161353 THRU 162477. 8 161353 THRU 161734. 9 161735 THRU 162477.				

Figure 1. Material Index (Sheet 7)

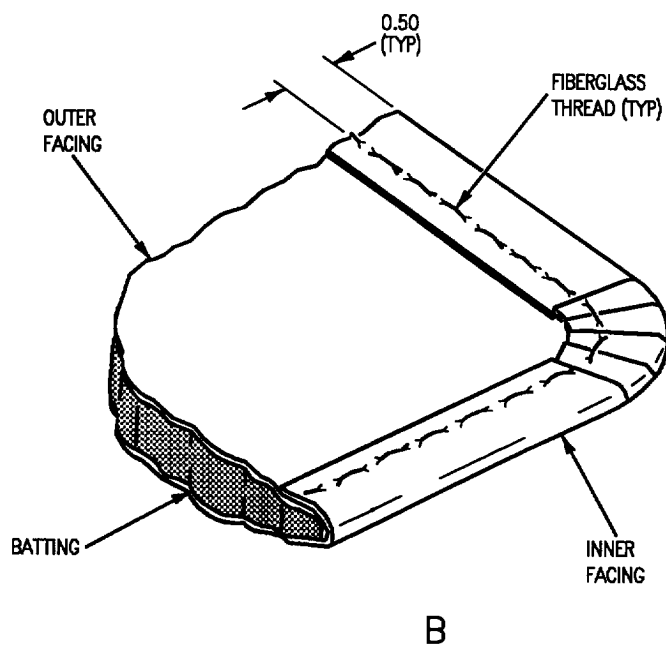
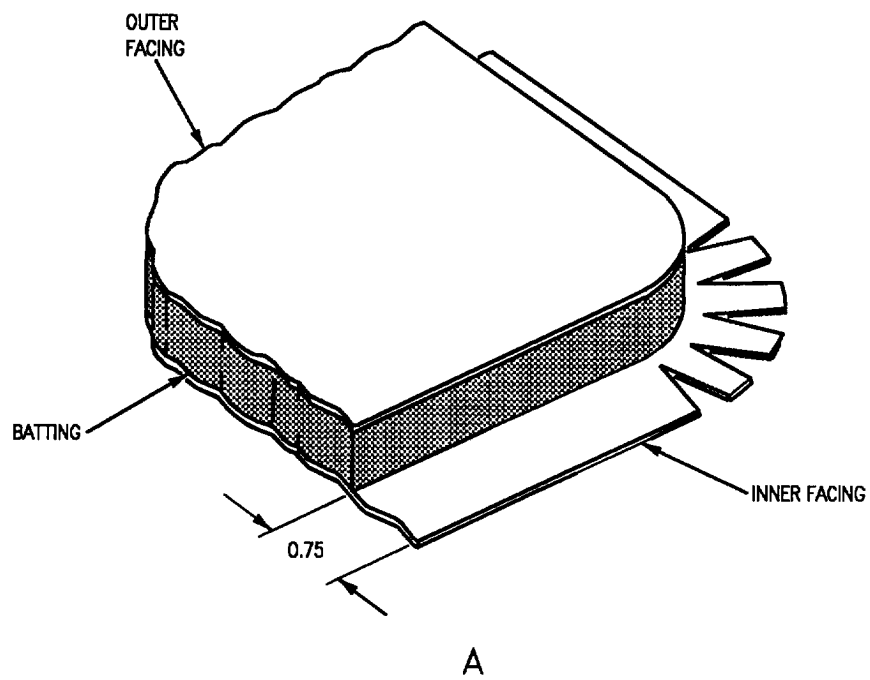
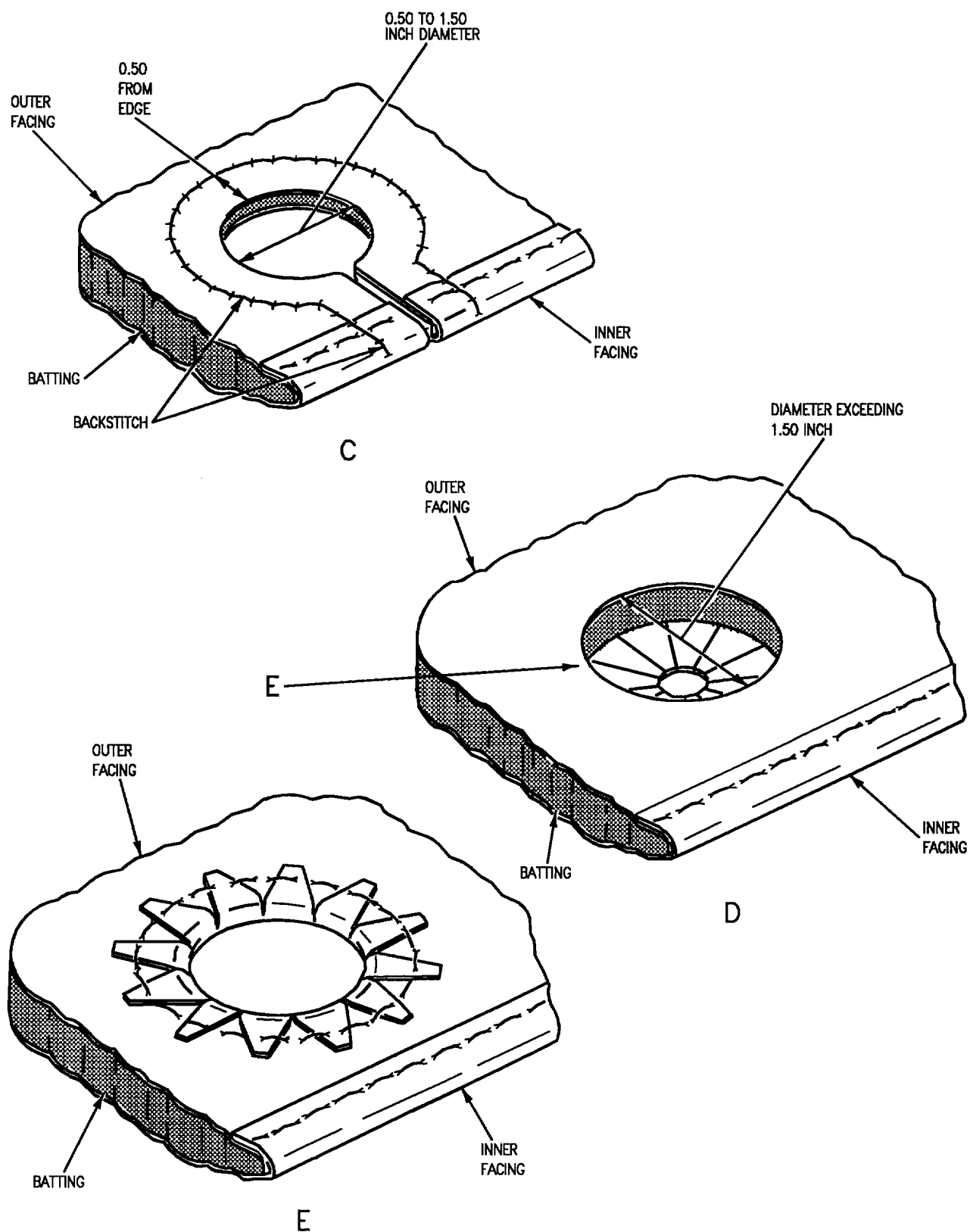


Figure 2. 74A800664 Blanket Replacement (Sheet 1)



18AC-SRM-222-(25-2)01-SCAN

Figure 2. 74A800664 Blanket Replacement (Sheet 2)

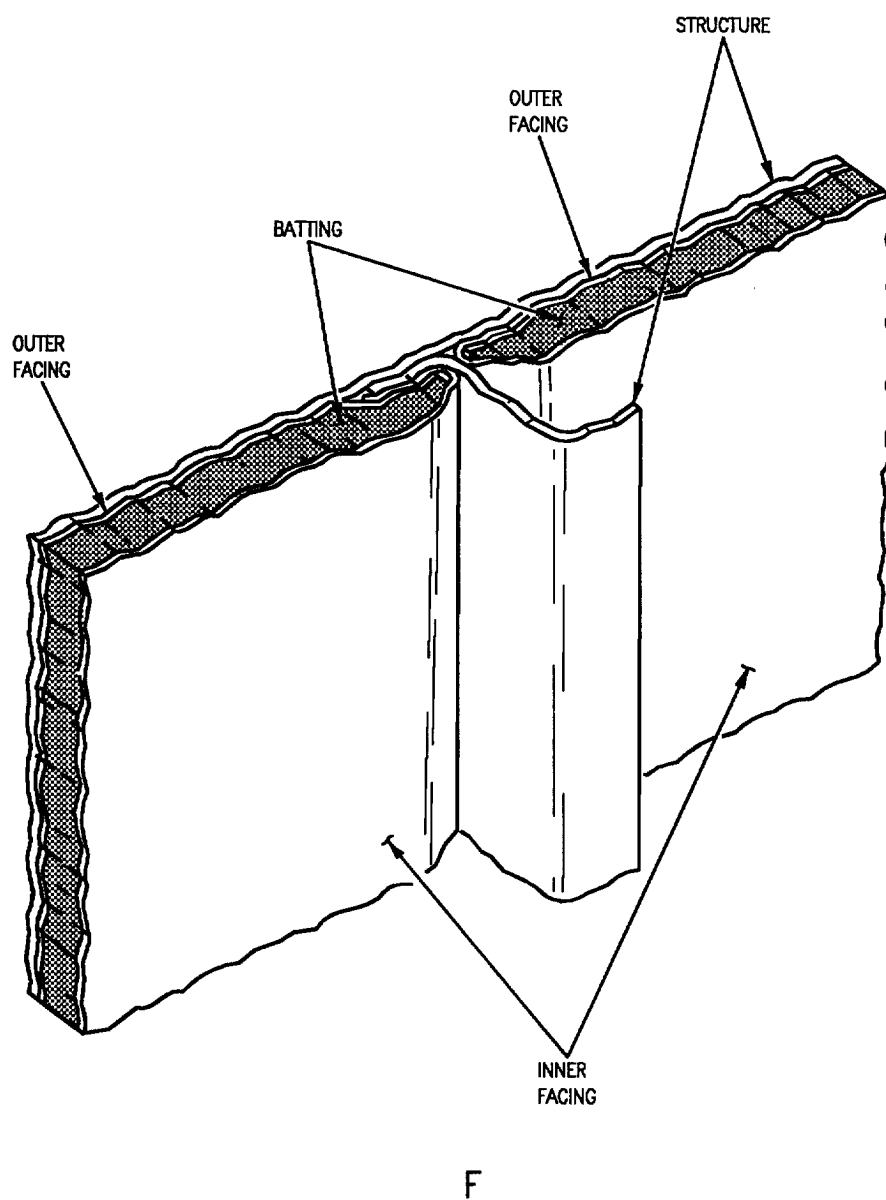


Figure 2. 74A800664 Blanket Replacement (Sheet 3)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

AFT COCKPIT LINERS AND INSULATION BLANKETS

Reference Material

Aircraft Corrosion Control	A1-F18AC-SRM-500
Priming Procedures	WP011 00

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74A802608 Blanket	2

Record of Applicable Directives

None

1. **DAMAGE EVALUATION.** See figure 1.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of material used are shown on figure 1. Damage not listed or exceeding the following limits requires depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage may be allowed to exist as is. The type and limits for 74A802608 blankets are:

a. Damage less than 0.50 inch in length.

b. Damage less than 0.50 inch is diameter.

4. **REPAIRABLE DAMAGE.** Repairable damage is damage that can be permanently repaired with no adverse affect on structural integrity, flight characteristics,

or safety or the aircraft. Damages are unlimited in size or number for 74A802608 blankets.

5. **REPAIRS.**

6. **74A802608 BLANKET.**

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440	Cheesecloth
TYPE 1 CLASS 1	
K-836	Blanket, Thermal

Materials Required (Continued)

Specification or Part Number	Nomenclature
H-B-695 CLASS 1 GRADE A SIZE 1	Brush, Varnish
RTV-732, CLEAR	Adhesive
TT-M-261	Methyl Ethyl Ketone



Methyl Ethyl Ketone, TT-M-261 10

a. Wipe area to be repaired with clean cheesecloth moistened with methyl ethyl ketone.

b. Fabricate patch 1 inch larger than damaged area using K-836 thermal blanket material.



Adhesive, RTV-732 11

NOTE

It is not necessary to apply adhesive to both surfaces being bonded.

c. Brush apply a thin coat of adhesive to one of the bonding surfaces.

d. Install patch over damaged area.

e. Work out trapped air between blanket and repair patch.

f. Allow to air dry for 24 hours.

7. REPLACEMENT.

8. **74A802608 BLANKET.** See figure 2.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440	Cheesecloth
TYPE 1 CLASS 1 63210	Blanket, Thermal
H-B-695 CLASS 1 GRADE A SIZE 1	Brush, Varnish
RTV-732, CLEAR	Adhesive
1200 RTV PRIMER	Primer, Adhesive
COAT CLEAR	
TT-M-261	Methyl Ethyl Ketone
B-4, B-6, E-12, E-18, Owens-Corning	Thread, Fiberglass
-	Scraper

a. Remove blanket and any residual adhesive and/or remnants of blanket from structure using plastic scraper.



Methyl Ethyl Ketone, TT-M-261 10

b. Wipe exposed structure where blanket was removed with clean cheesecloth moistened with methyl ethyl ketone.

c. Apply priming procedures as required to structure (A1-F18AC-SRM-500, WP011 00).

NOTE

Insulation blanket may be fabricated with round or square corners.

- d. Make a pattern of area requiring blanket.
- e. Lay out blanket 1 inch larger than pattern.

NOTE

Fastener and spacer holes shall be punched or cut out on installation.

- f. Cut out blanket.

NOTE

Gray side of blanket is inner facing.

- g. Remove 0.75 inch of batting and facing from outer surface of blanket. See detail A.

NOTE

Stitching shall meet the requirements of federal specification STD-751, Type 301, using five to eight stitches per inch.

- h. Fold inner facing over outer facing and stitch a minimum of 0.50 inch from edge using fiberglass thread. See detail B.

- i. Cutouts and slots are fabricated per procedures below:

(1) Cutouts and slots 0.50 to 1.50 inch diameter are backstitched 0.50 inch from edge. See detail C.

(2) Cutouts and slots exceeding 1.50 inch diameter have fabricated edges per steps g and h. See detail D.



Primer, Adhesive, 1200 RTV

12

- j. Apply a light coat of adhesive primer to structure using clean cheesecloth.

- k. Allow adhesive primer to air dry a minimum of 45 minutes before application of adhesive.



Adhesive, RTV-732

11

NOTE

It is not necessary to apply adhesive to both surfaces being bonded.

- l. Brush apply a thin coat of adhesive to one of the bonding surfaces.

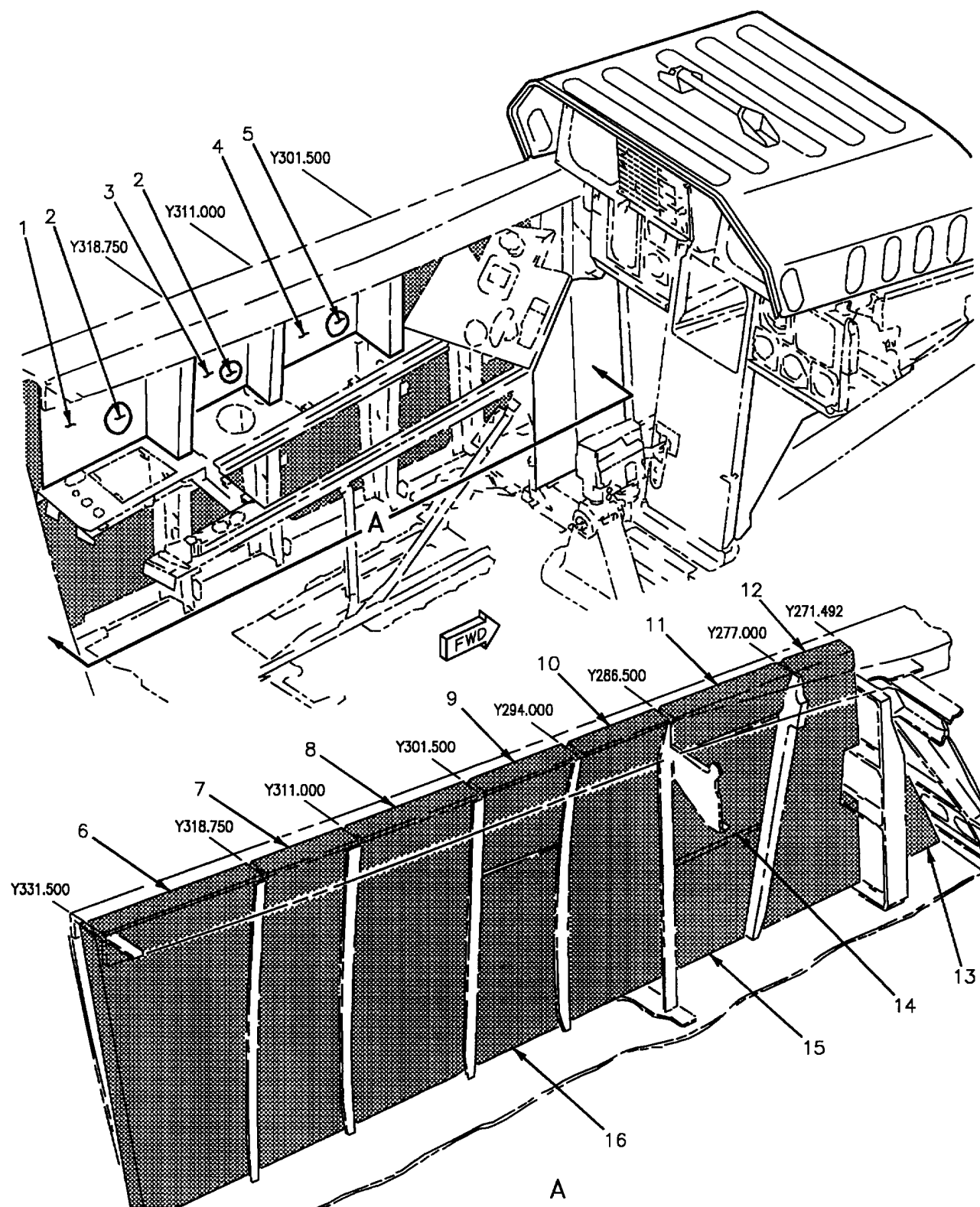
NOTE

Electrical wiring and clamps shall be left exposed when cementing insulation blanket to structure.

- m. Install blankets to fit snug against structure. See detail E.

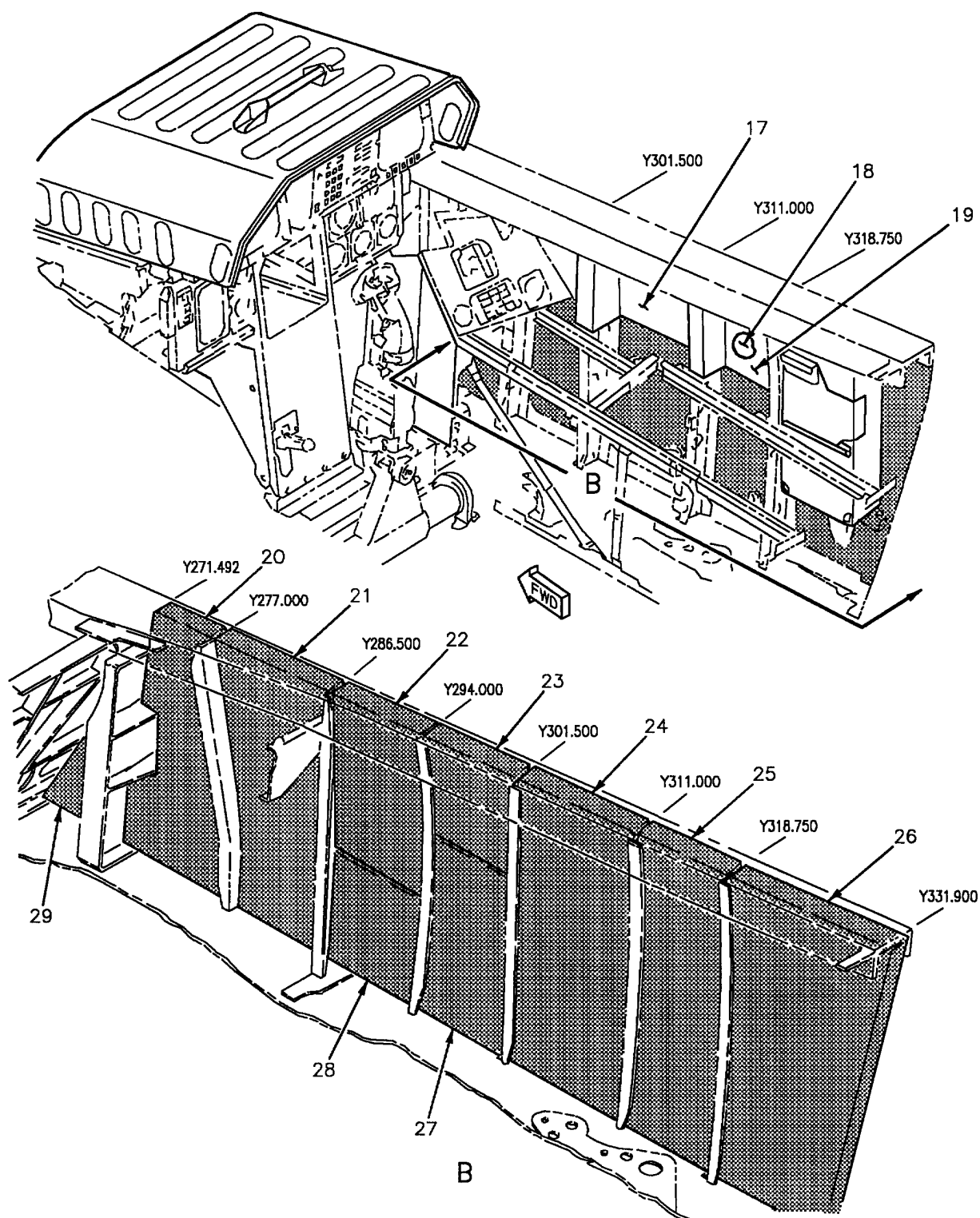
- n. Work out trapped air between blanket and structure.

- o. Allow to air dry for 24 hours.



18AC-SRM-222-(26-1)01-SCAN

Figure 1. Material Index (Sheet 1)



18AC-SRM-222-(26-2)01-SCAN

Figure 1. Material Index (Sheet 2)

























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2		Backing  5 74A802611-2013	0.005 Roll	 4 Aluminum Foil
3		Liner  5 74A802611-2007	0.035 Sheet	 2 Thermoplastic  3 Polycarbonate
4		Liner  6 74A802611-2009	0.035 Sheet	 2 Thermoplastic  3 Polycarbonate
5		Backing  6 74A802611-2011	0.005 Roll	 4 Aluminum Foil
6		Blanket 74A802608-2029	1.50 Roll	 1
7		Blanket 74A802608-2031	1.50 Roll	 1
8		Blanket 74A802608-2033	1.50 Roll	 1
9		Blanket 74A802608-2041	1.50 Roll	 1
10		Blanket 74A802608-2021	1.50 Roll	 1
11		Blanket 74A802608-2025	1.50 Roll	 1
12		Blanket 74A802608-2037	1.50 Roll	 1
13		Blanket 74A802608-2039	1.50 Roll	 1
14		Blanket 74A802608-2027	1.50 Roll	 1
15		Blanket 74A802608-2023	1.50 Roll	 1
16		Blanket 74A802608-2035	1.50 Roll	 1

Figure 1. Material Index (Sheet 3)


























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19		Liner  74A802612-2007	0.035 Sheet	 Thermoplastic  Polycarbonate
20		Blanket 74A802608-2003	1.50 Roll	
21		Blanket 74A802608-2005	1.50 Roll	
22		Blanket 74A802608-2019	1.50 Roll	
23		Blanket 74A802608-2017	1.50 Roll	
24		Blanket 74A802608-2011	1.50 Roll	
25		Blanket 74A802608-2013	1.50 Roll	
26		Blanket 74A802608-2015	1.50 Roll	
27		Blanket 74A802608-2009	1.50 Roll	
28		Blanket 74A802608-2007	1.50 Roll	
29		Blanket 74A802608-2001	1.50 Roll	
LEGEND				
 63210 thermal blanket.				
 Lexan F60061 on F/A-18B 161354 THRU 161947.				
 AMS 3611 on F/A-18B 162402 AND UP.				
 Y427 lined aluminum foil tape.				
 Liner and backing make up door CPAH.				
 Liner and backing make up door CPAI.				
 Liner and backing make up door CPAG.				

Figure 1. Material Index (Sheet 4)

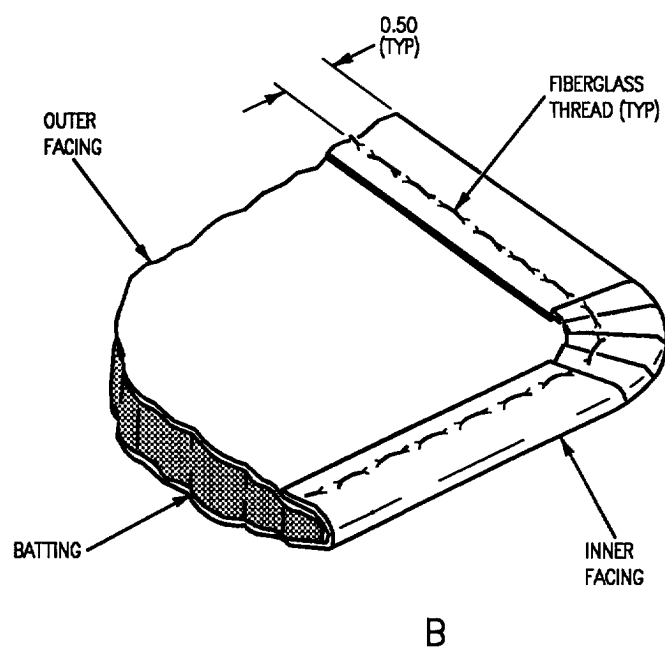
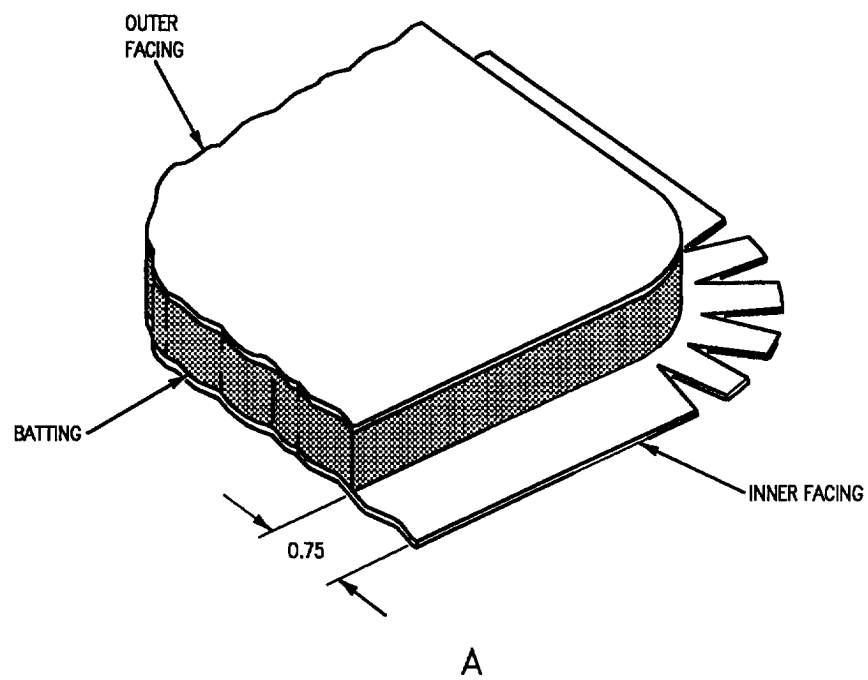


Figure 2. 74A802608 Blanket Replacement (Sheet 1)

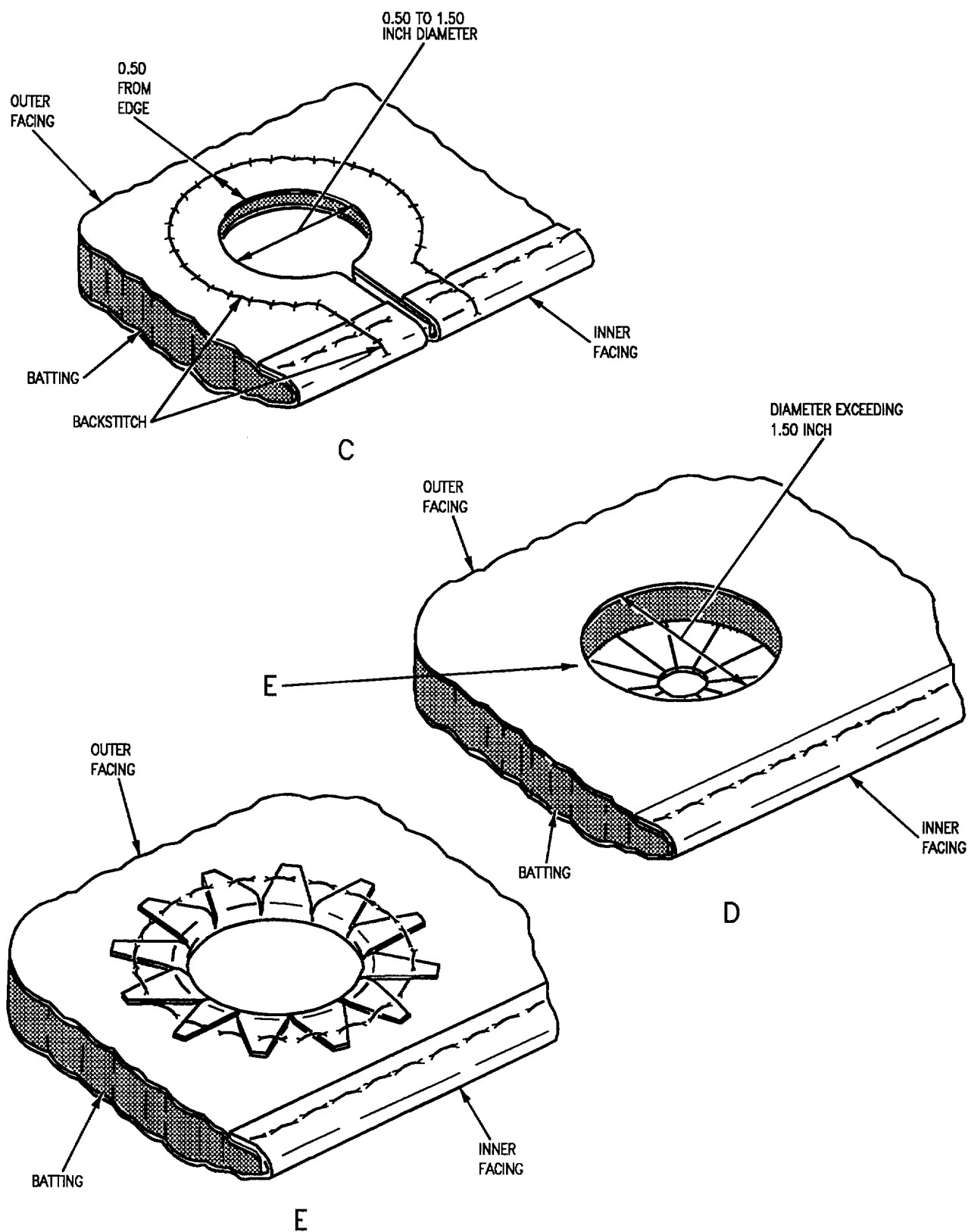


Figure 2. 74A802608 Blanket Replacement (Sheet 2)

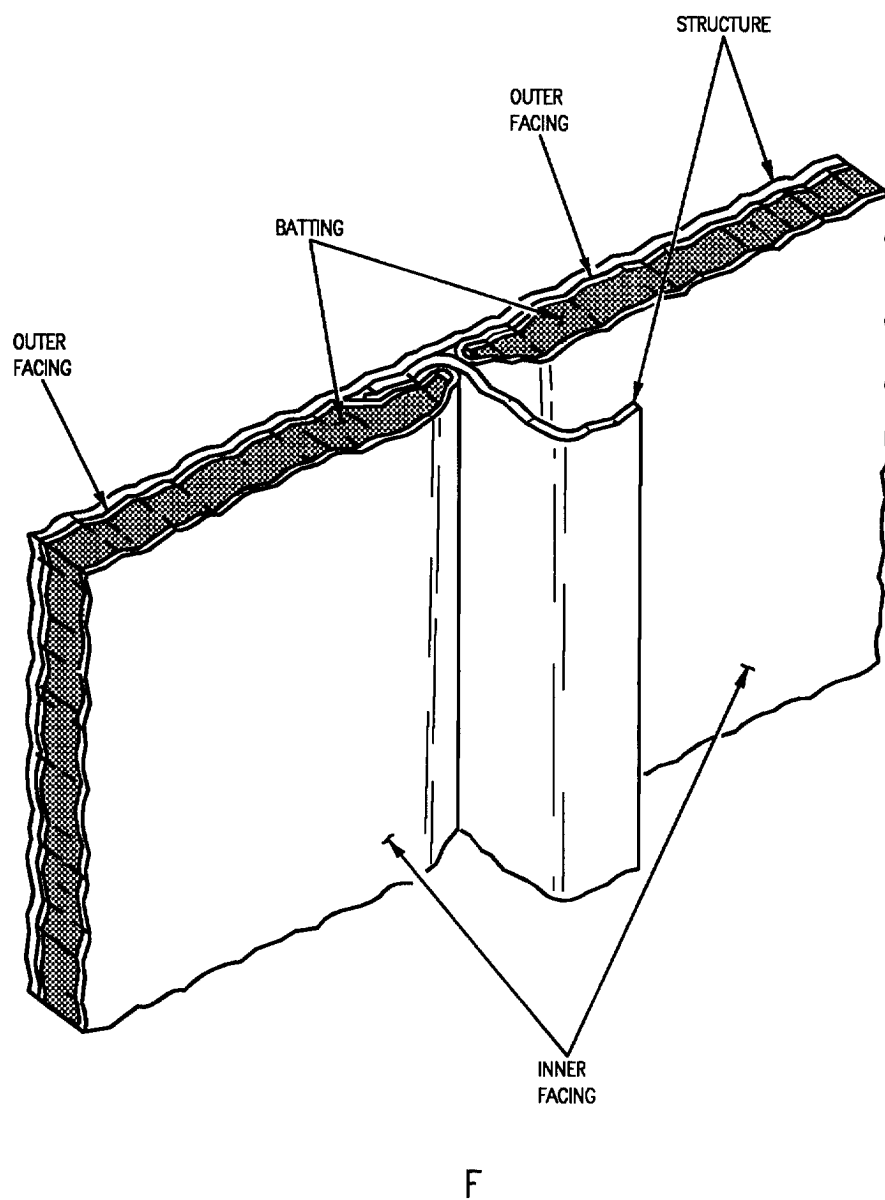


Figure 2. 74A802608 Blanket Replacement (Sheet 3)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

FUEL TANK CAVITY NUMBER 1 FILLER BLOCKS

Reference Material

Fuel System	AF-F18AC-460-300
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18A	WP017 01
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18B	WP017 02
Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Fuel Tank Cavity Number 1 Filler Blocks, 74A314670 and 74A582075, Fabrication	WP031 02
Fuel Tank Cavity Number 1 Filler Blocks, 74A314857-2001 Thru 74A314857-2088, Fabrication	WP031 03
Fuel Tank Cavity Number 1 Filler Blocks, 74A314857-2089 Thru 74A314857-2203, Fabrication	WP031 04
Fuel Tank Cavity Number 1 Filler Blocks, 74A314857-2205 Thru 74A314857-2311, Fabrication	WP031 05

Alphabetical Index

Subject	Page No.
Damage Evaluation	1
Repairs	1
Replacement	1

Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

None

5. REPLACEMENT.

6. Replacement of blocks require fabrication of blocks. Fabricate blocks from material identified in figure 1 or 2. Use dimensions shown in the applicable referenced WP below. Remove and install blocks (A1-F18AC-460-300, WP017 01 for F/A-18A or WP017 02 for F/A-18B).

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. The figure identifies block location, type of material, and stock size.

3. **REPAIRS.**

4. Repairs are not practical. Blocks should be replaced when damaged.

a. 74A314670 and 74A582075 blocks (WP031 02).

b. 74A314857-2001 THRU 74A314857-2088 blocks (WP031-03).

c. 74A314857-2089 THRU 74A314857-2203 blocks (WP031 04).

d. 74A314857-2205 THRU 74A314857-2311 blocks (WP031 05).

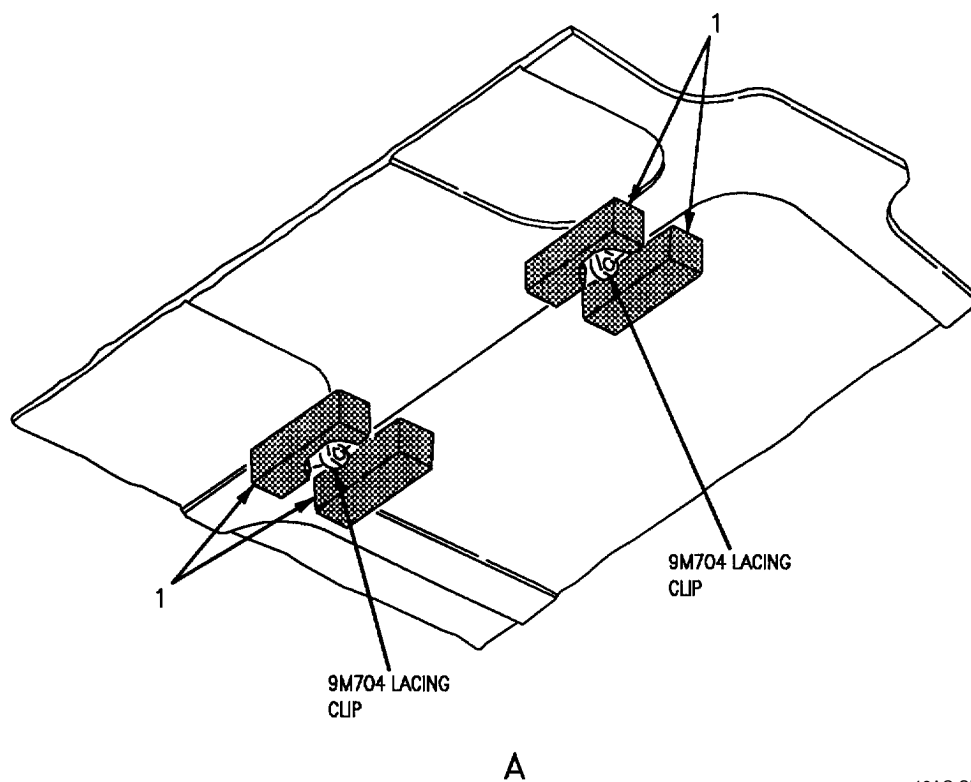
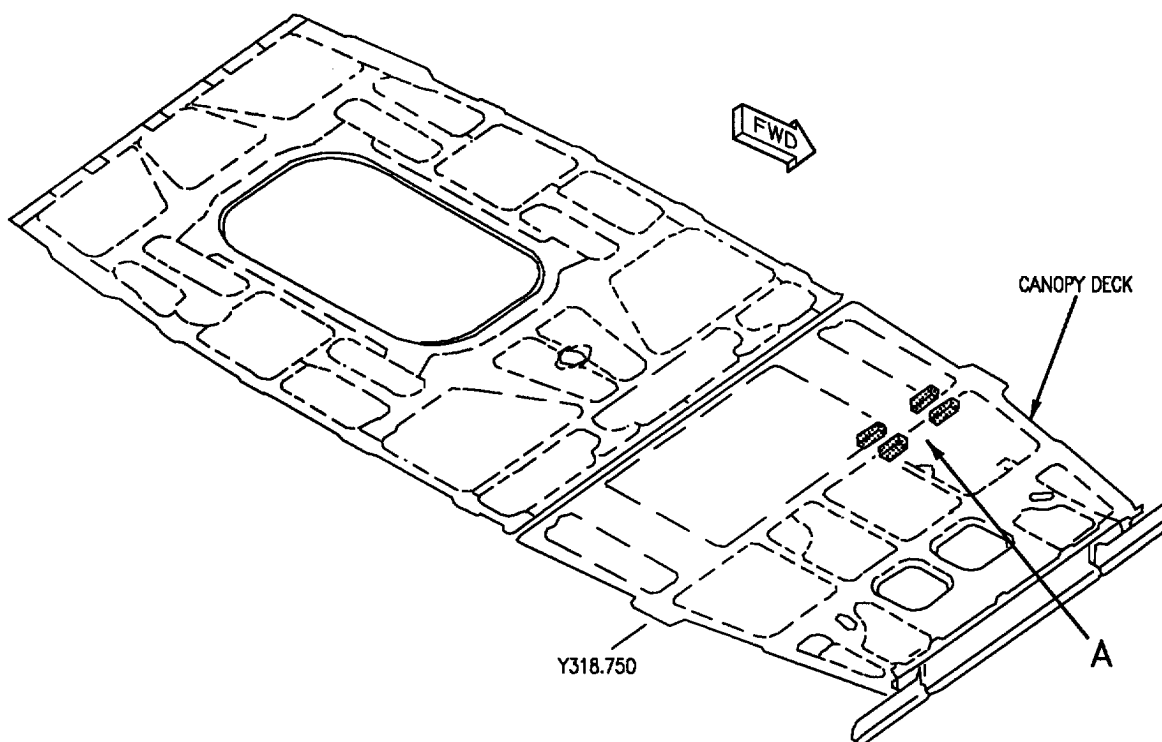


Figure 1. Material Index - F/A-18A (Sheet 1)

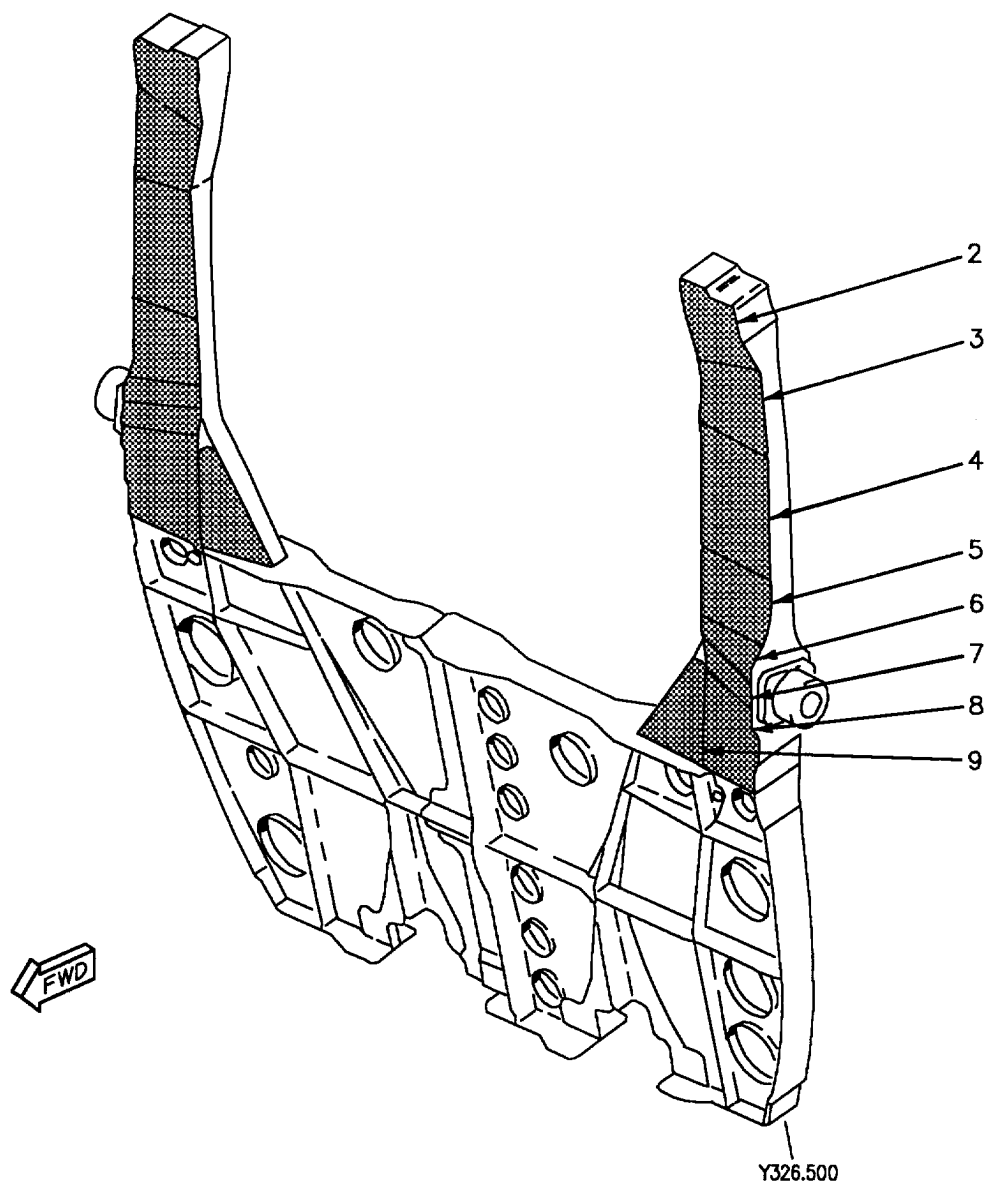


Figure 1. Material Index - F/A-18A (Sheet 2)

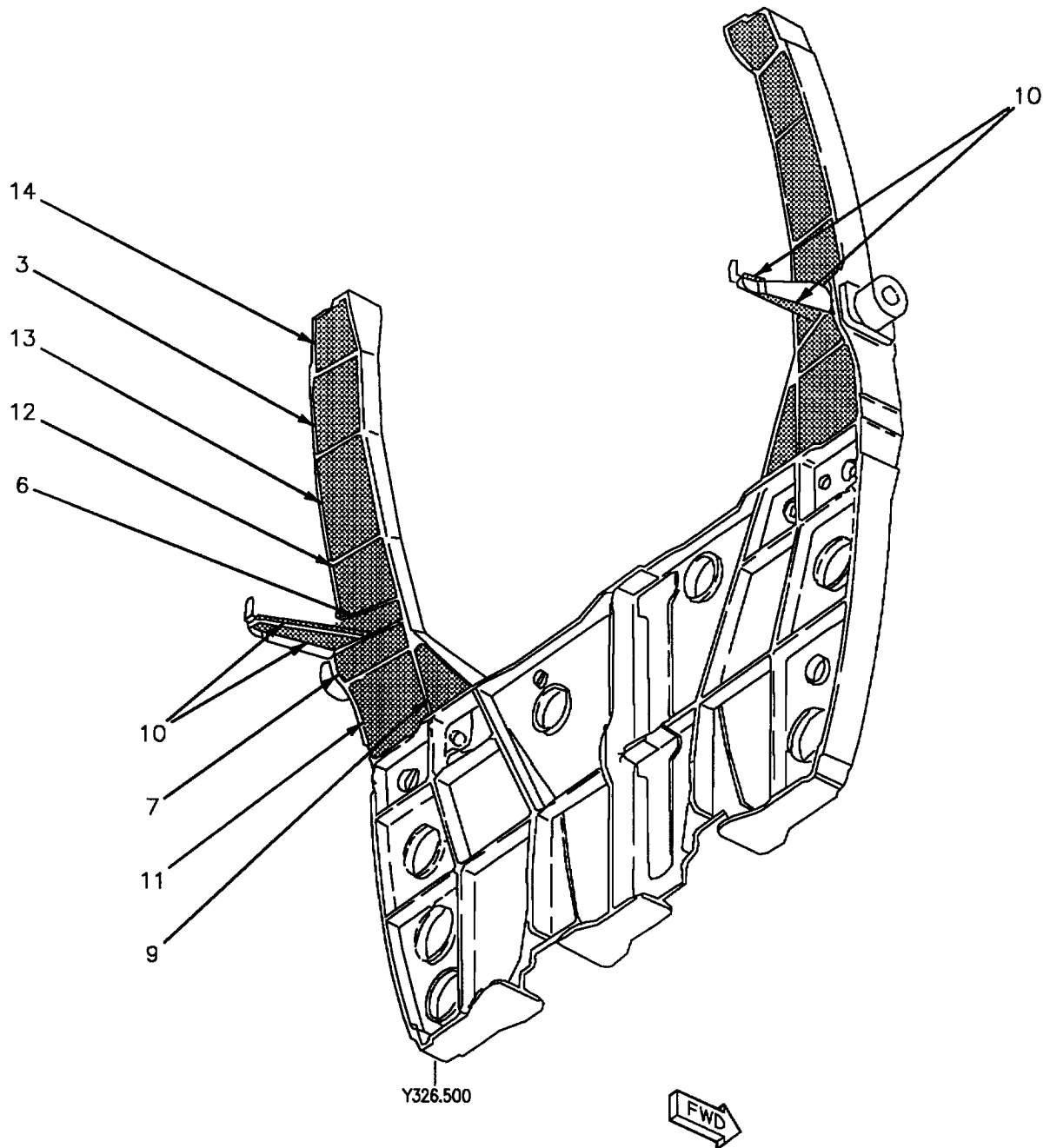
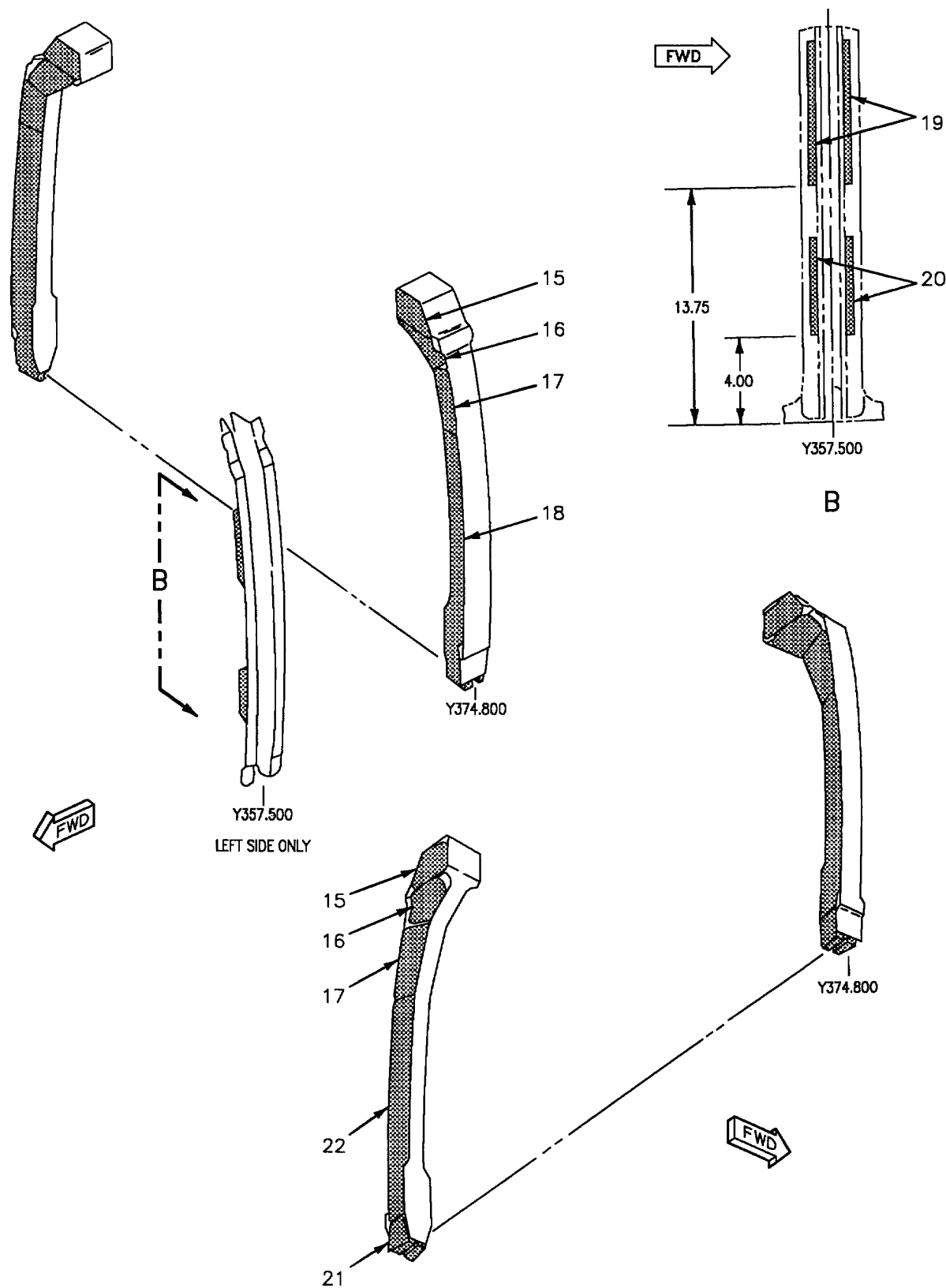


Figure 1. Material Index - F/A-18A (Sheet 3)



18AC-SRM-222-(28-4)01-SCAN

Figure 1. Material Index - F/A-18A (Sheet 4)

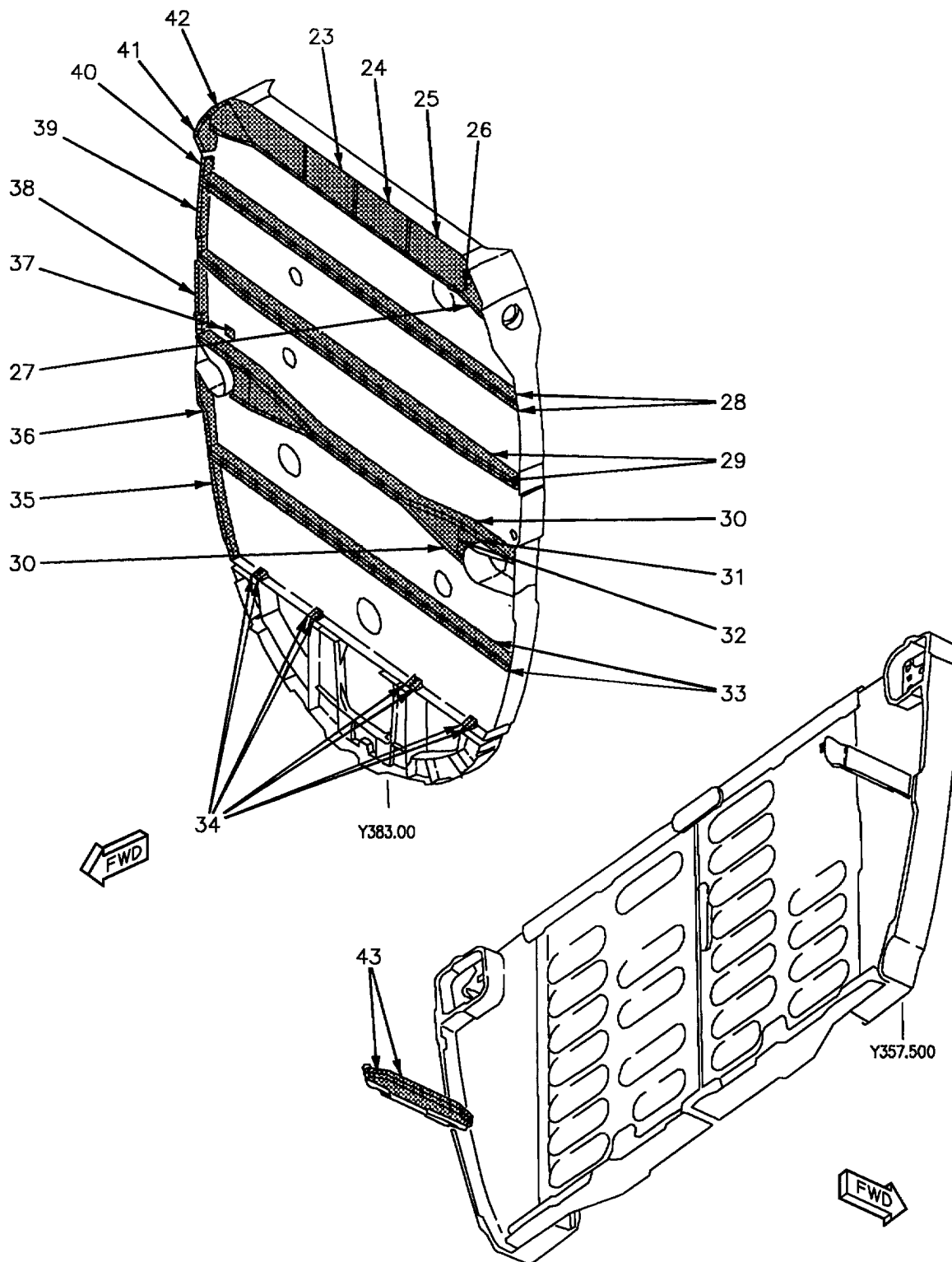


Figure 1. Material Index - F/A-18A (Sheet 5)

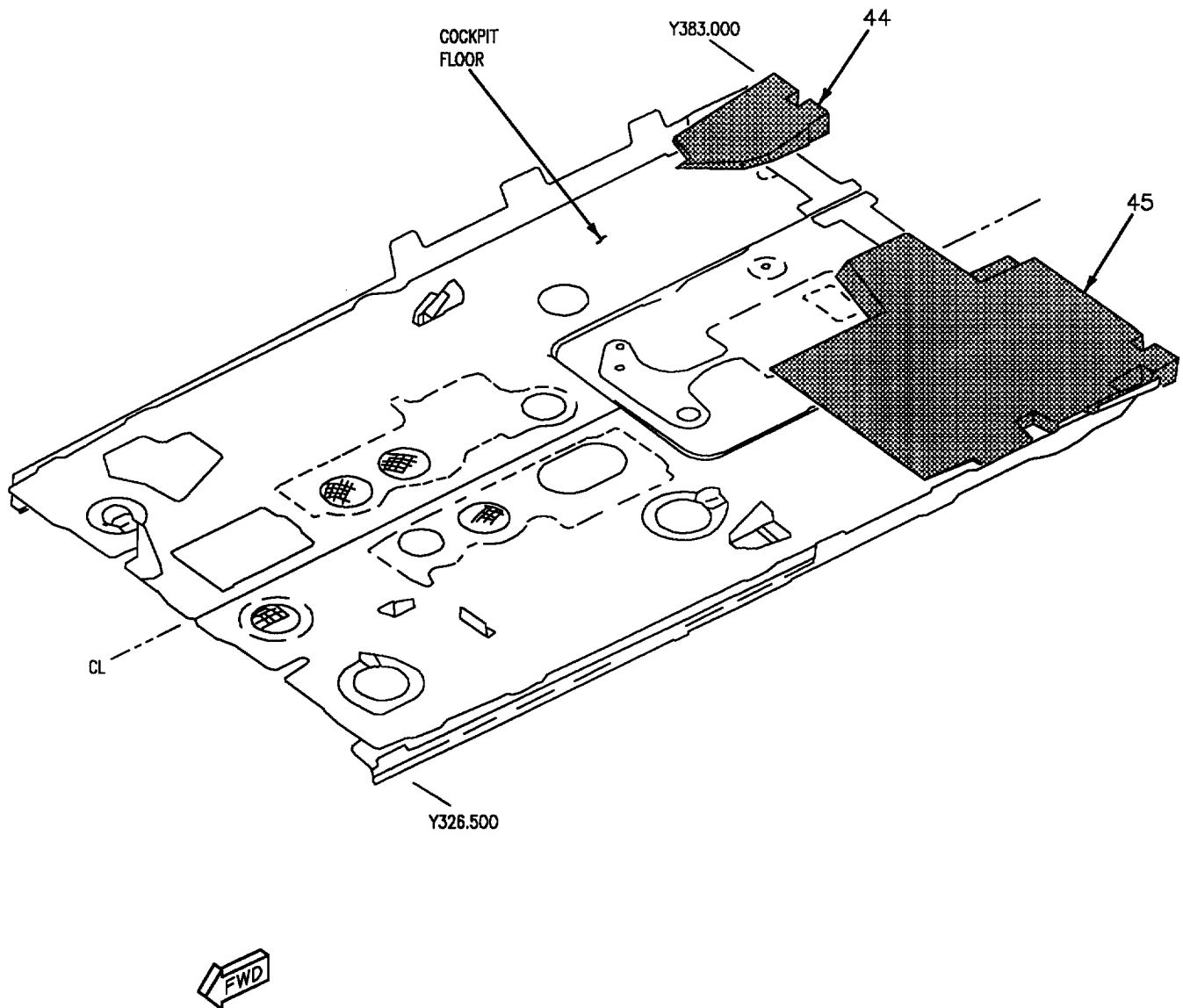


Figure 1. Material Index - F/A-18A (Sheet 6)

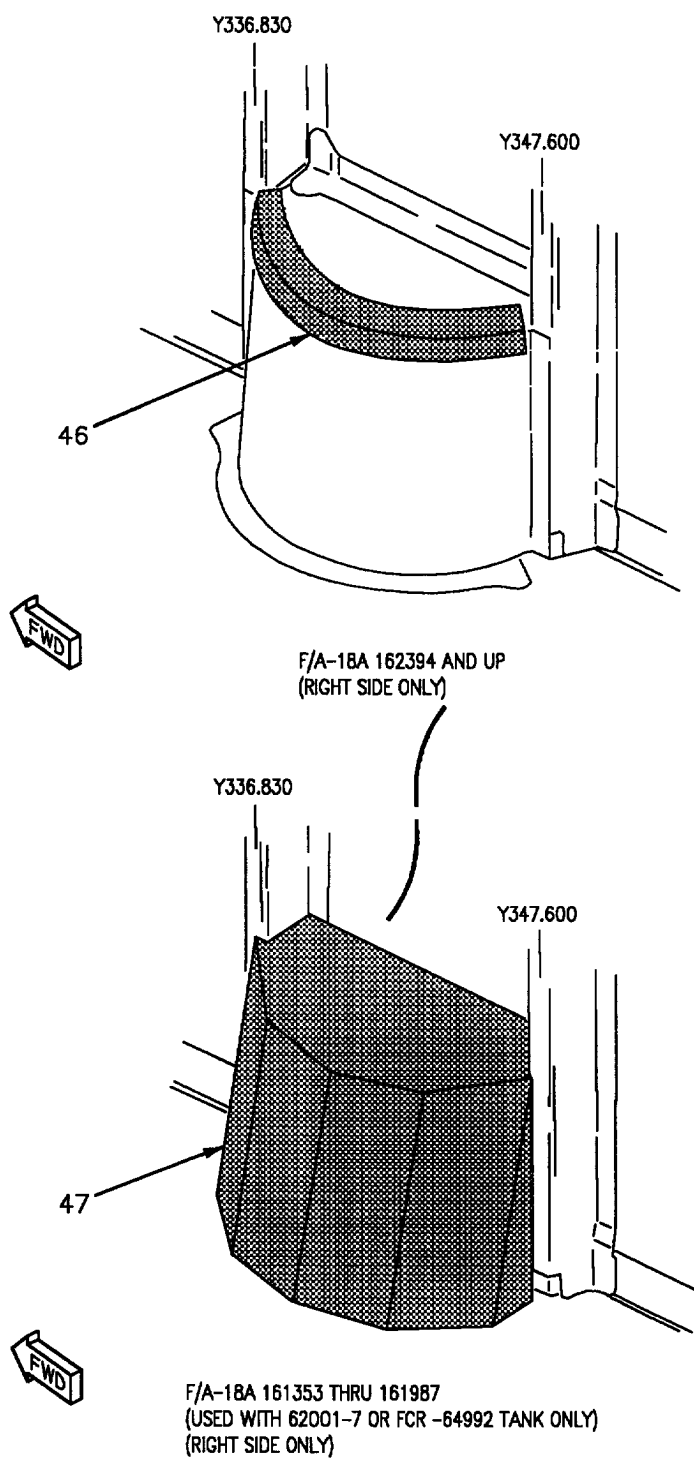


Figure 1. Material Index - F/A-18A (Sheet 7)






















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Block (Foam) 74A314670-2255	0.60 X 0.60 X 2.00	
2	 	Block (Foam) 74A314670-2211, -2212 74A314670-2259, -2260	1.50 X 2.50 X 3.96	
3		Block (Foam) 74A314670-2217, -2218	1.50 X 3.81 X 4.63	
4		Block (Foam) 74A314670-2205, -2206	1.50 X 4.06 X 6.00	
5		Block (Foam) 74A314670-2213, -2214	3.00 X 3.32 X 3.96	
6		Block (Foam) 74A314670-2207, -2208	1.50 X 2.36 X 3.81	
7		Block (Foam) 74A314670-2199, -2200	1.50 X 2.85 X 4.18	
8		Block (Foam) 74A314670-2197, -2198	3.00 X 4.41 X 5.35	
9		Block (Foam) 74A314670-2219, -2220	1.50 X 3.78 X 4.40	
10		Block (Foam) 74A314670-2235	0.25 X 2.30 X 6.89	
11		Block (Foam) 74A314670-2195, -2196	3.00 X 4.41 X 5.29	
12		Block (Foam) 74A314670-2215, -2216	3.00 X 3.32 X 3.96	
13		Block (Foam) 74A314670-2203, -2204	1.50 X 4.06 X 6.00	
14	 	Block (Foam) 74A314670-2209, -2210 74A314670-2257, -2258	1.50 X 2.68 X 3.96	
15		Block (Foam) 74A314670-2225, -2226	2.00 X 1.89 X 3.55	
16		Block (Foam) 74A314670-2227, -2228	2.00 X 1.80 X 4.36	
17		Block (Foam) 74A314670-2229, -2230	1.00 X 3.04 X 5.19	

Figure 1. Material Index - F/A-18A (Sheet 8)


























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
18		Block (Foam) 74A314670-2223, -2224	1.50 X 1.72 X 18.50	
19		Block (Foam) 74A314670-2239	0.50 X 1.70 X 7.12	
20		Block (Foam) 74A314670-2241	0.50 X 1.70 X 4.82	
21		Block (Foam) 74A314670-2231, -2232	1.50 X 1.67 X 2.09	
22		Block (Foam) 74A314670-2221, -2222	1.50 X 1.72 X 16.10	
23		Block 74A314670-2089	1.00 X 3.45 X 7.07	 
24		Block 74A314670-2193	1.00 X 3.45 X 7.07	 
25		Block 74A314670-2099, -2100	1.00 X 3.34 X 10.35	 
26		Block 74A314670-2109, -2110	1.00 X 2.87 X 2.95	 
27		Block (Foam) 74A314670-2245	0.25 X 1.55 X 42.30	
28		Block (Foam) 74A314670-2243	0.25 X 0.95 X 44.20	
29		Block (Foam) 74A314670-2201	0.25 X 1.62 X 45.32	
30		Block (Foam) 74A314670-2249	0.25 X 1.75 X 44.50	
31		Block 74A314670-2105	1.75 X 2.22 X 3.07	 
32		Block 74A314670-2107	1.75 X 3.26 X 6.54	 
33		Block (Foam) 74A314670-2247	0.25 X 1.12 X 41.75	
34		Block (Foam) 74A314670-2233	0.25 X 1.20 X 1.71	
35		Block (Foam) 74A314670-2275	0.50 X 1.30 X 9.00	

Figure 1. Material Index - F/A-18A (Sheet 9)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
36	8	Block (Foam) 74A314670-2273	0.50 X 1.30 X 8.00	1
37	8	Block (Foam) 74A314670-2263	0.50 X 1.60 X 1.60	1
38	8	Block (Foam) 74A314670-2271	0.50 X 1.30 X 7.65	1
39	8	Block (Foam) 74A314670-2269	0.50 X 1.30 X 8.00	1
40	8	Block (Foam) 74A314670-2267	0.50 X 1.30 X 2.30	1
41	8	Block (Foam) 74A314670-2265	0.50 X 2.80 X 4.30	1
42	9	Block (Foam) 74A314670-2277, -2278	0.80 X 2.06 X 3.46	1
43		Block (Foam) 74A314670-2237	0.50 X 0.65 X 7.35	1
44		Block (Foam) 74A314670-2253	1.50 X 5.00 X 8.25	4
45		Block (Foam) 74A314670-2251	1.50 X 16.85 X 21.00	4
46		Pad (Foam) 74A314670-2261	0.25 X 3.80 X 11.20	1 5
47		Block (Foam) 74A582075-2001	6.75 X 9.00 X 12.00	4
LEGEND				
1	PPP-C-1752, type 1, 2 pounds per cu. ft., class 3.			
2	Hexcel HRH-10-3/16, 2 pounds per cu. ft., nylon base honeycomb core, 1.00 in. thick 0-006 .			
3	Hexcel HRH-10-3/16, 2 pounds per cu. ft., nylon base honeycomb core, 1.75 in. thick 0-006 .			
4	PPP-C-1752, type 5, 9 pounds per cu. ft., class 3.			
5	3M pressure sensitive tape no. 8564X over honeycomb blocks, fasteners, and structural edges.			
6	F/A-18A 161353 THRU 161761.			
7	F/A-18A 161925 AND UP.			
8	F/A-18A 161973 AND UP.			
9	F/A-18A 162826 AND UP.			

Figure 1. Material Index - F/A-18A (Sheet 10)

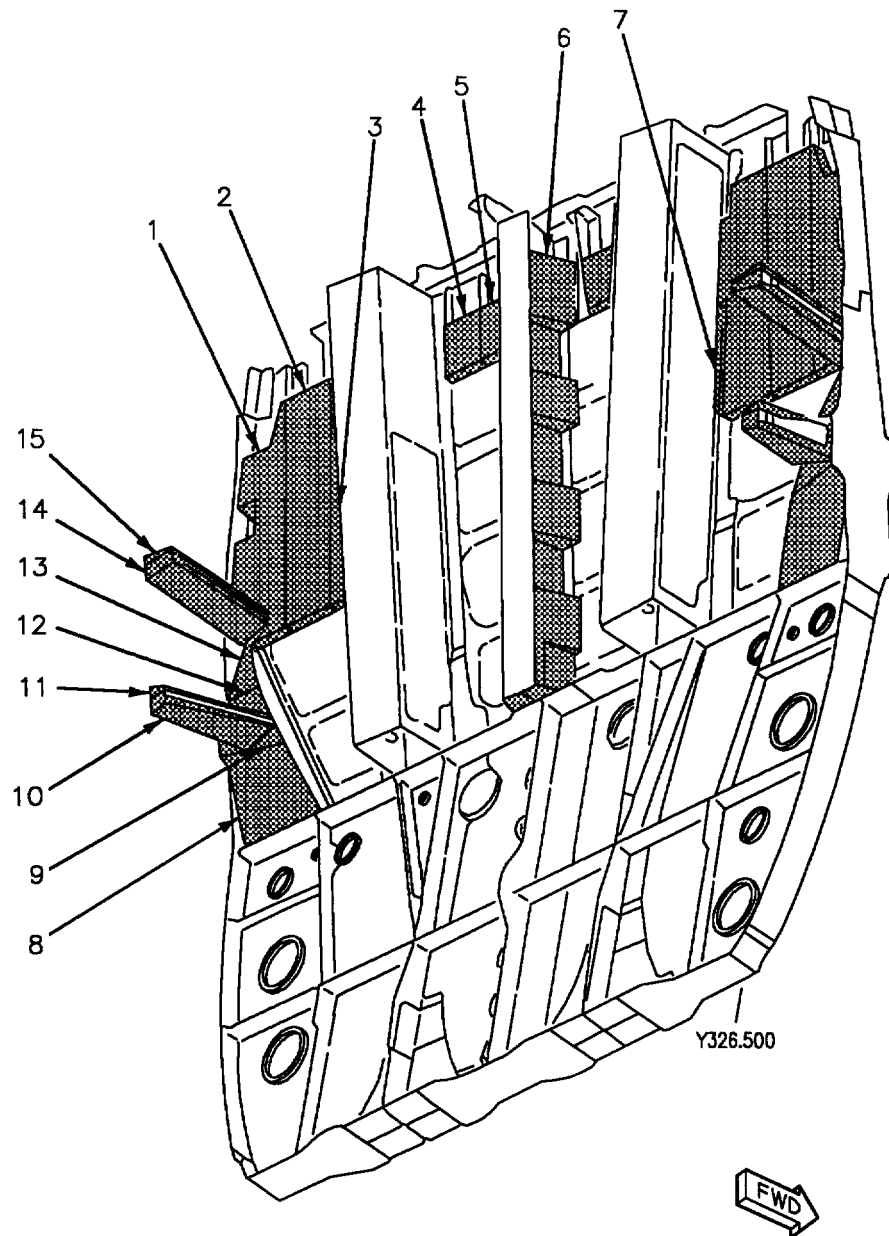


Figure 2. Material Index - F/A-18B (Sheet 1)

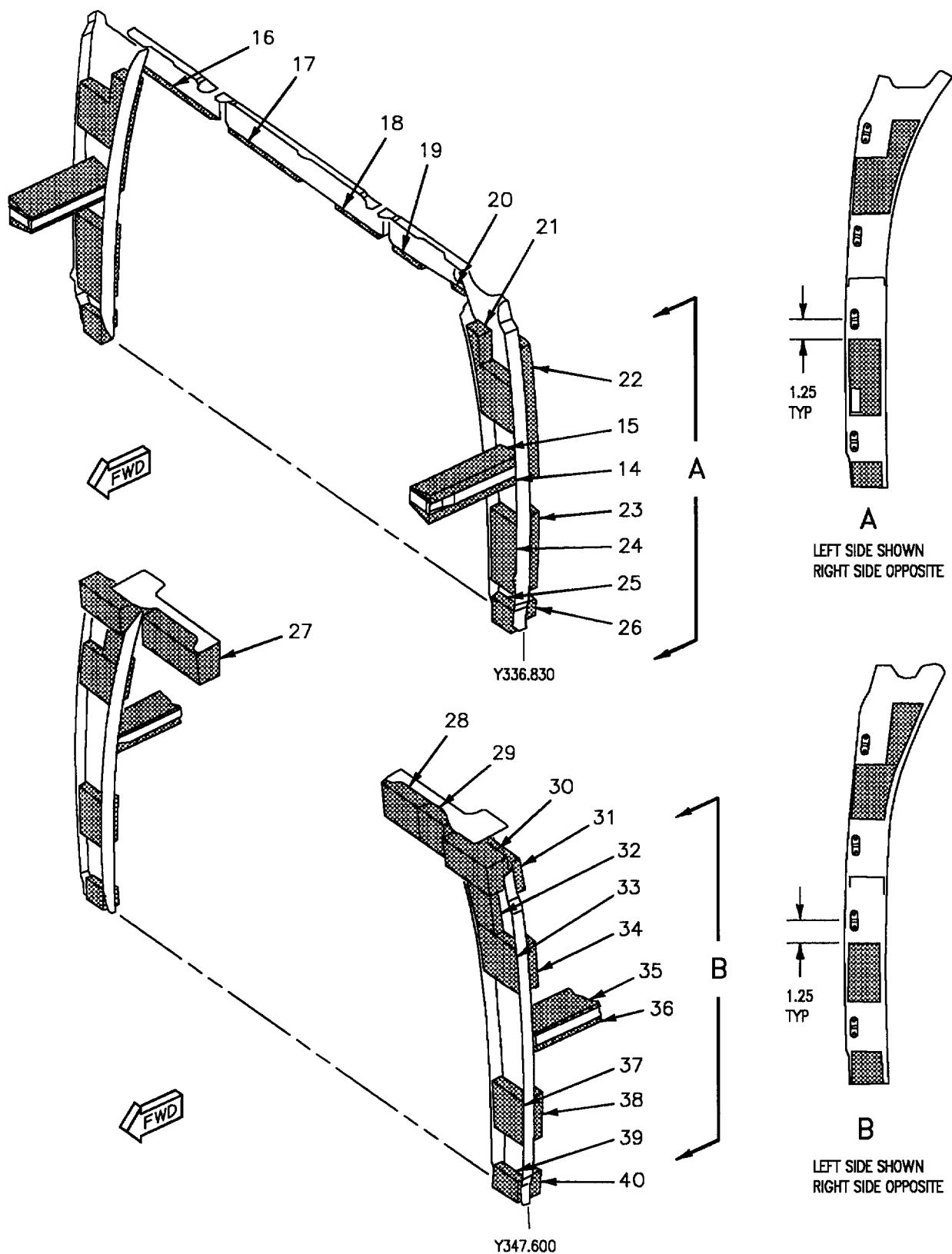


Figure 2. Material Index - F/A-18B (Sheet 2)

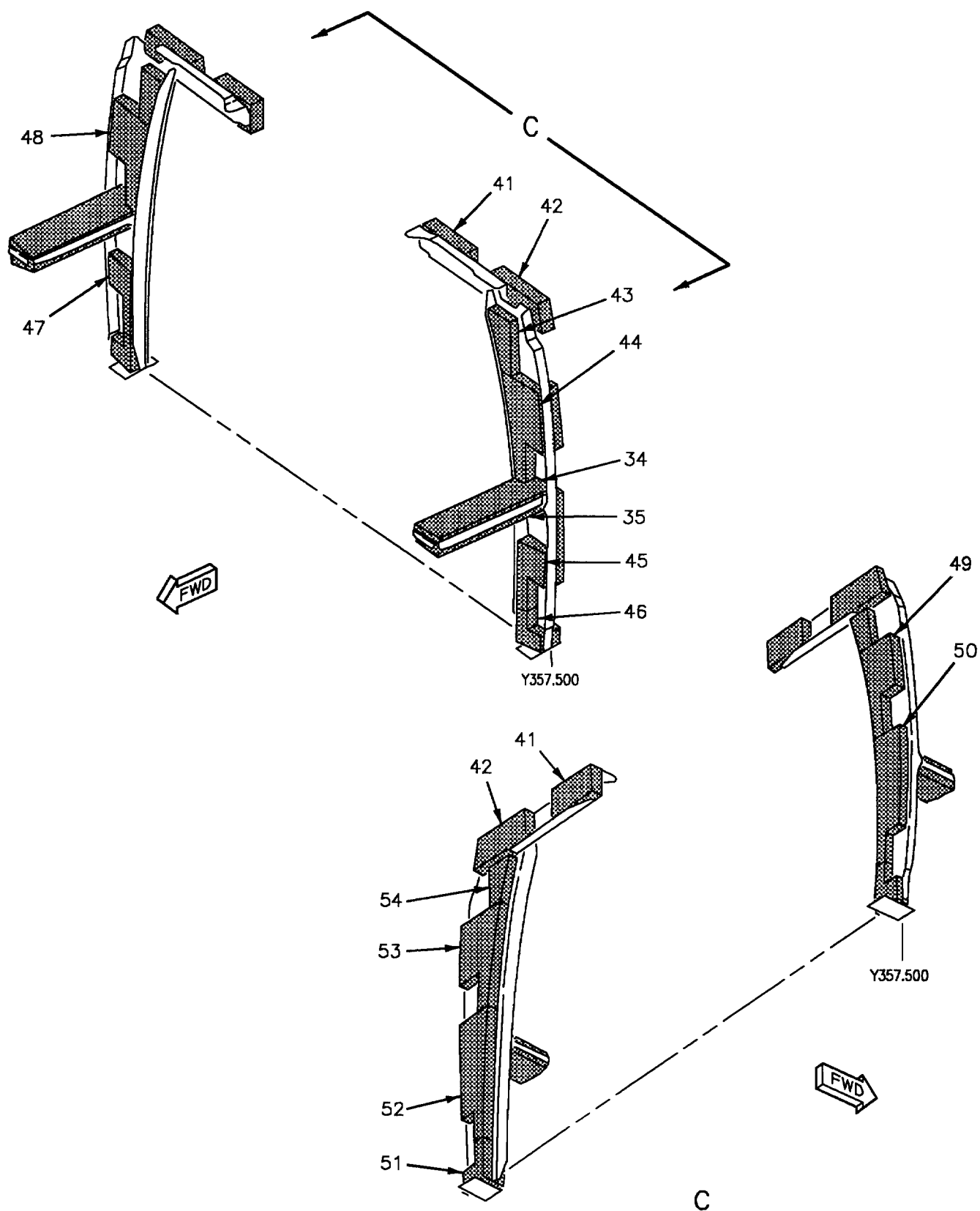


Figure 2. Material Index - F/A-18B (Sheet 3)

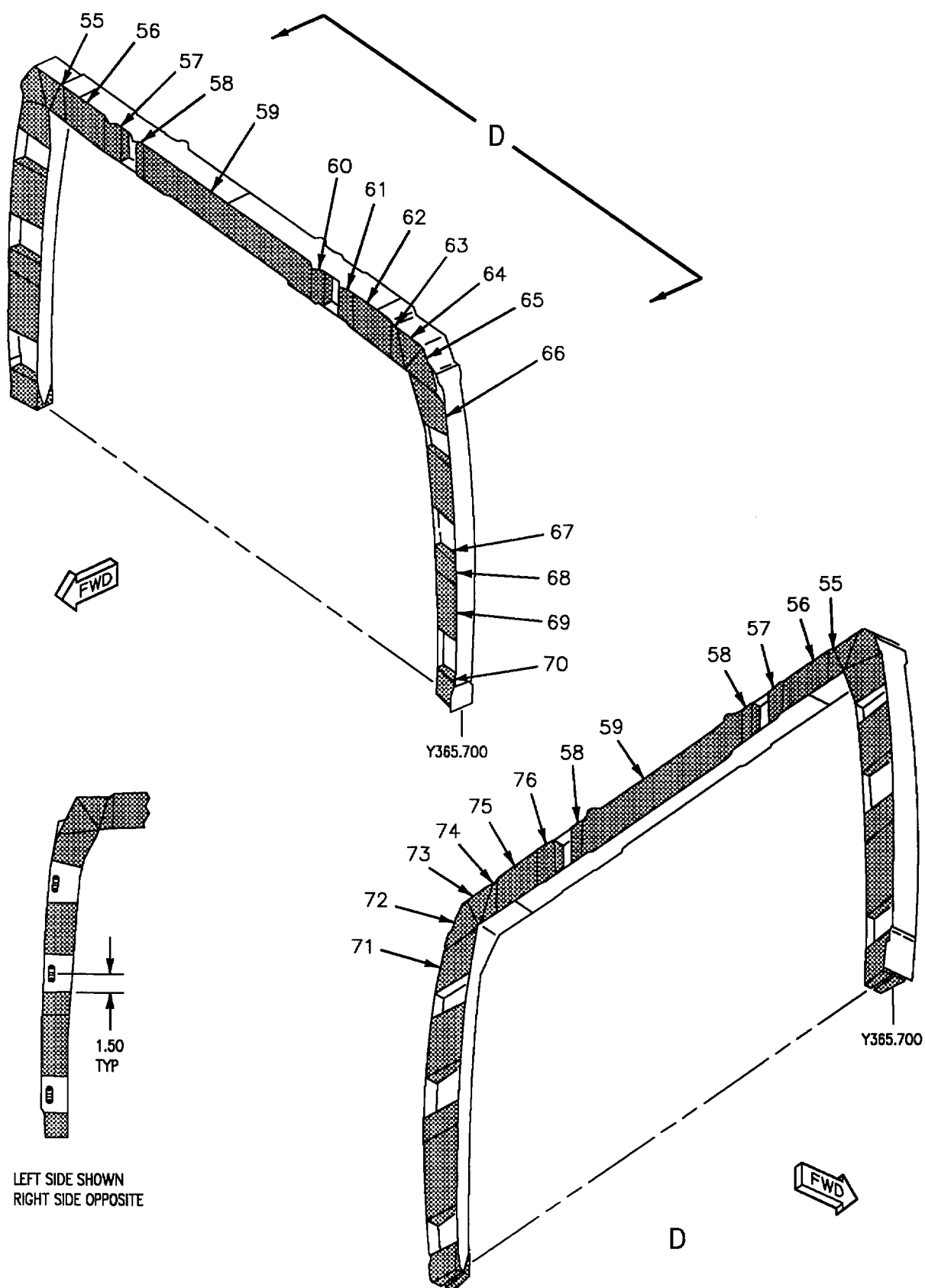


Figure 2. Material Index - F/A-18B (Sheet 4)

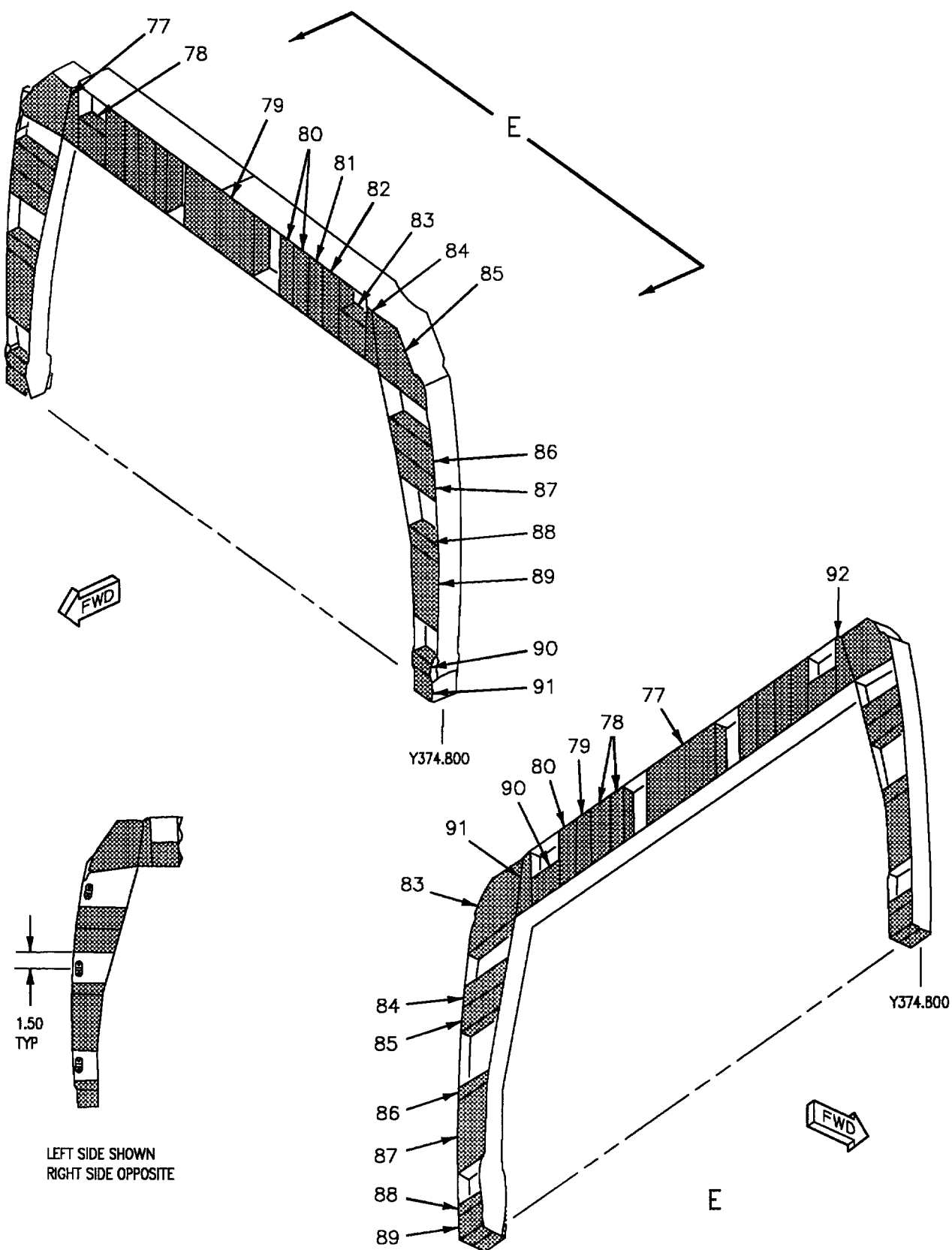


Figure 2. Material Index - F/A-18B (Sheet 5)

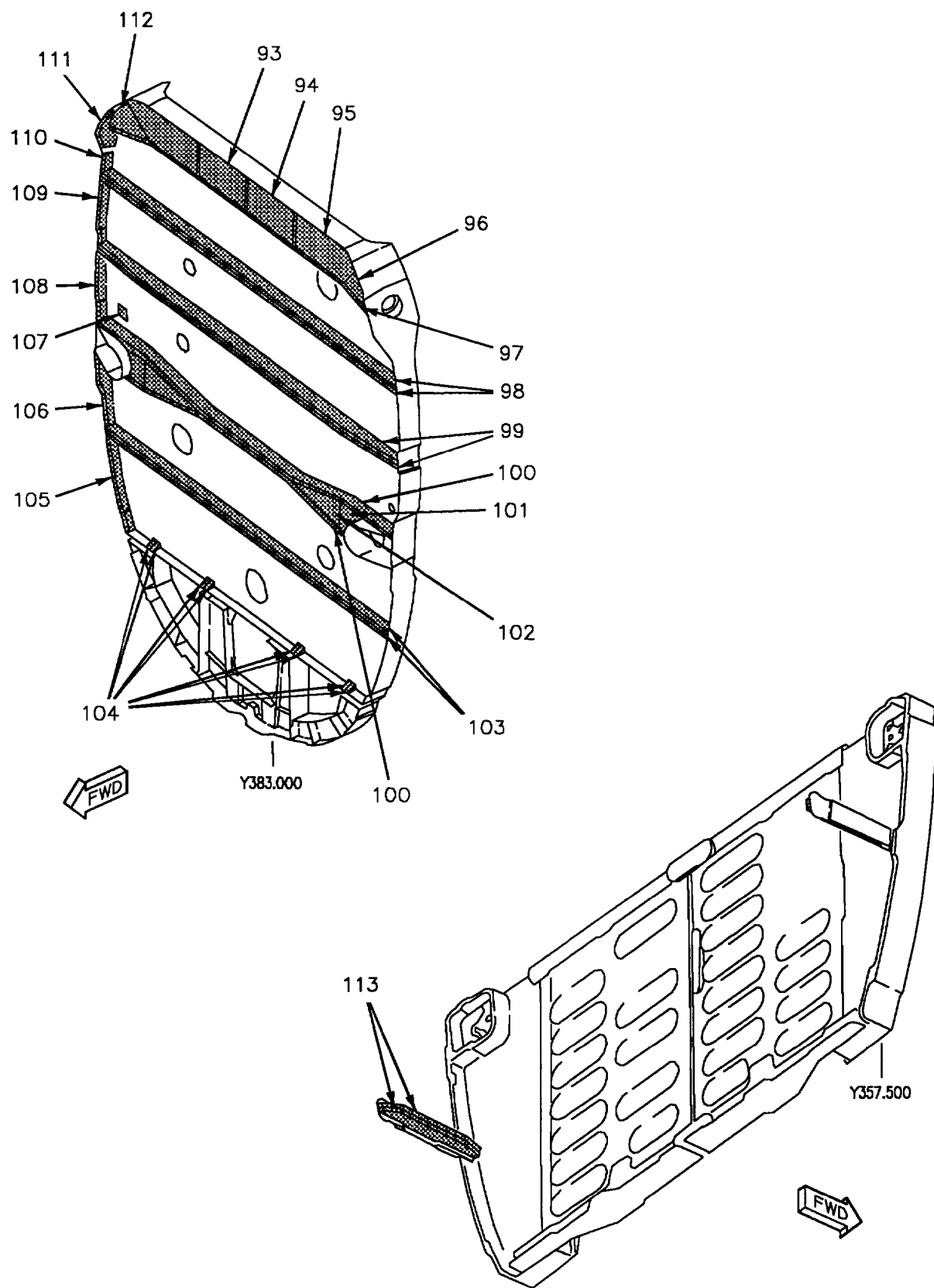


Figure 2. Material Index - F/A-18B (Sheet 6)

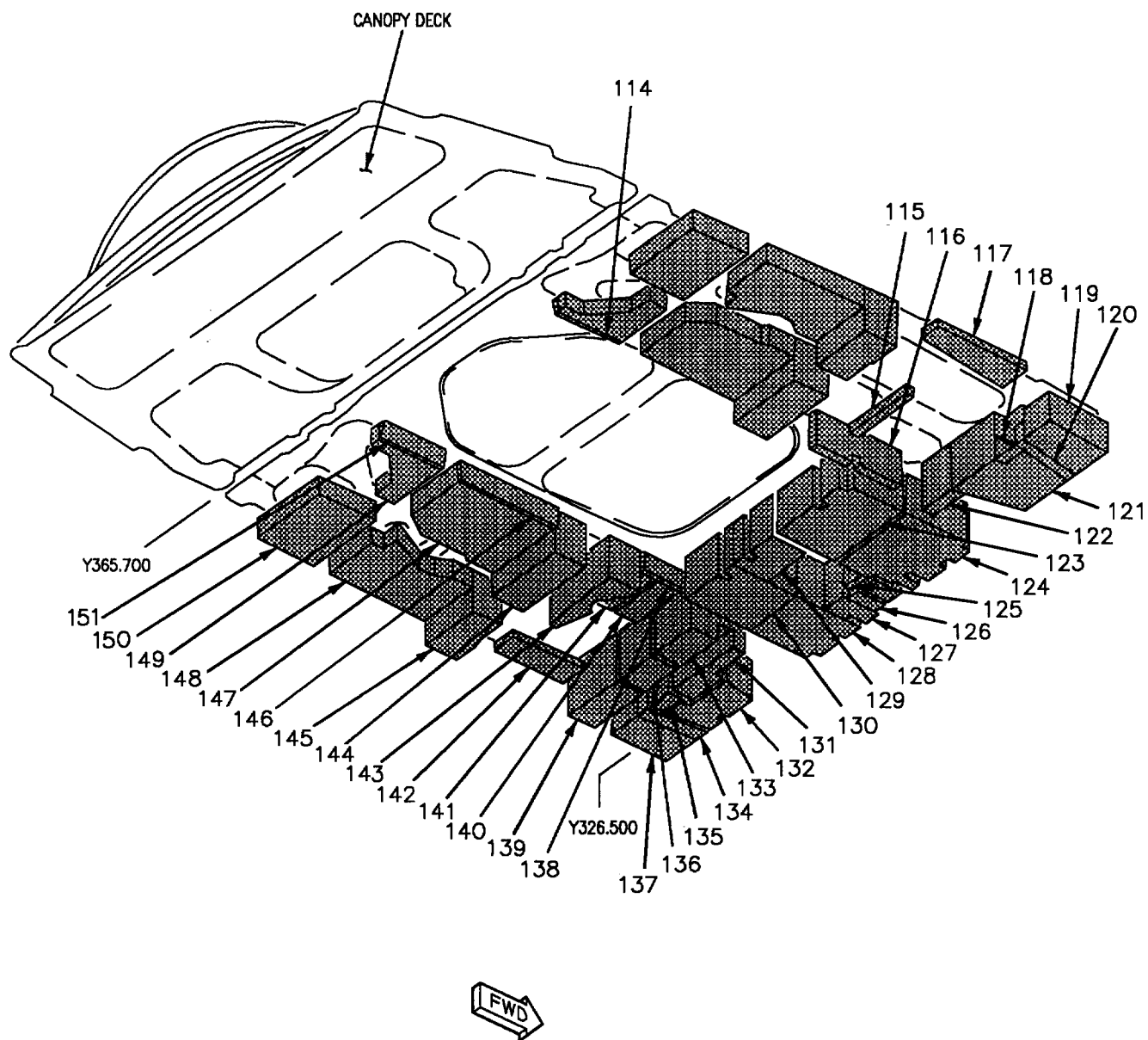
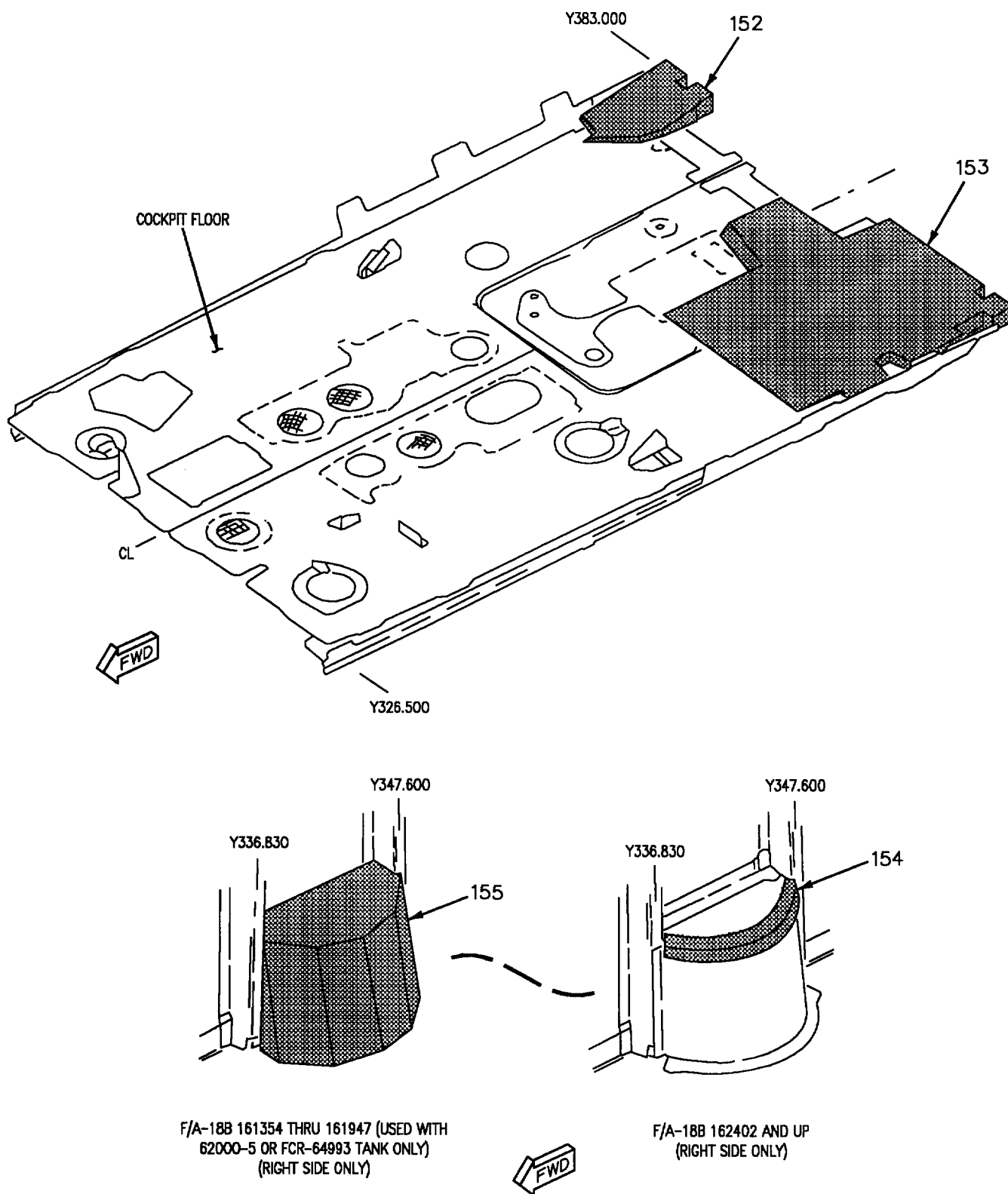


Figure 2. Material Index - F/A-18B (Sheet 7)



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Figure 2. Material Index - F/A-18B (Sheet 8)


















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Block (Foam) 74A314857-2229	1.00 X 2.95 X 11.94	
2		Block (Foam) 74A314857-2219	1.00 X 2.72 X 11.94	
L				
R		74A314857-2299	1.00 X 2.72 X 12.90	
3		Block (Foam) 74A314857-2221	1.00 X 4.00 X 11.94	
L				
R		74A314857-2222	1.00 X 4.00 X 12.78	
4		Block (Foam) 74A314857-2223	1.00 X 2.02 X 2.35	
5		Block (Foam) 74A314857-2225	1.00 X 2.16 X 2.35	
6		Block (Foam) 74A314857-2017, -2018	1.50 X 2.12 X 22.16	
7		Block (Foam) 74A314857-2039	1.00 X 4.50 X 0.75	
8		Block (Foam) 74A314857-2001, -2002	2.00 X 4.50 X 5.00	
9		Block (Foam) 74A314857-2003, -2004	1.50 X 2.00 X 3.00	
10		Block (Foam) 74A314857-2301	0.25 X 2.23 X 8.02	
11		Block (Foam) 74A314857-2303	0.25 X 2.22 X 6.76	
12		Block (Foam) 74A314857-2005, -2006	1.50 X 2.00 X 2.00	
13		Block (Foam) 74A314857-2007, -2008	1.00 X 1.50 X 2.00	
14		Block (Foam) 74A314857-2137, -2138	2.00 X 2.16 X 7.05	
15		Block (Foam) 74A314857-2135, -2136	1.00 X 2.22 X 7.08	
16		Block (Foam) 74A314857-2249	1.50 X 2.60 X 12.32	
17		Block (Foam) 74A314857-2265	1.00 X 0.25 X 6.50	

Figure 2. Material Index - F/A-18B (Sheet 9)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
18		Block (Foam) 74A314857-2263	1.00 X 0.25 X 4.60	
19		Block (Foam) 74A314857-2261	1.00 X 0.72 X 3.64	
20		Block (Foam) 74A314857-2243	1.00 X 1.17 X 5.60	
21		Block (Foam) 74A314857-2271, -2272	2.00 X 4.20 X 5.60	
22		Block (Foam) 74A314857-2269, -2270	1.00 X 4.24 X 10.70	
23		Block (Foam) 74A314857-2025	1.00 X 2.02 X 4.50	
24		Block (Foam) 74A314857-2027	1.50 X 2.22 X 4.29	
25		Block (Foam) 74A314857-2031, -2032	1.50 X 1.56 X 2.16	
26		Block (Foam) 74A314857-2029, -2030	1.00 X 1.56 X 1.96	
27		Block (Foam) 74A314857-2171	3.00 X 2.84 X 5.80	
28		Block (Foam) 74A314857-2157	1.50 X 2.93 X 2.93	
29		Block (Foam) 74A314857-2159	2.00 X 2.82 X 2.92	
30		Block (Foam) 74A314857-2187, -2188	3.00 X 2.65 X 4.80	
31		Block (Foam) 74A314857-2231, -2232	3.00 X 0.37 X 3.72	
32		Block (Foam) 74A314857-2233, -2234	1.50 X 2.50 X 3.72	
33		Block (Foam) 74A314857-2055, -2056	2.00 X 3.10 X 3.30	
34		Block (Foam) 74A314857-2053, -2054	1.00 X 2.89 X 3.30	
35		Block (Foam) 74A314857-2139, -2140	1.00 X 2.32 X 9.62	

Figure 2. Material Index - F/A-18B (Sheet 10)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
36		Block (Foam) 74A314857-2141, -2142	2.00 X 2.23 X 9.62	
37		Block (Foam) 74A314857-2059	2.00 X 2.23 X 3.54	
38		Block (Foam) 74A314857-2057	1.00 X 2.04 X 3.54	
39		Block (Foam) 74A314857-2063, -2064	2.00 X 2.03 X 2.30	
40		Block (Foam) 74A314857-2061, -2062	1.00 X 2.03 X 2.10	
41		Block (Foam) 74A314857-2175, -2176	1.00 X 2.16 X 4.50	
42		Block (Foam) 74A314857-2237, -2238	1.00 X 2.16 X 6.34	
43		Block (Foam) 74A314857-2235, -2236	1.50 X 3.32 X 4.83	
44		Block (Foam) 74A314857-2039	2.00 X 3.17 X 7.92	
45		Block (Foam) 74A314857-2041	2.00 X 2.27 X 5.10	
46		Block (Foam) 74A314857-2045, -2046	1.50 X 2.16 X 3.24	
47		Block (Foam) 74A314857-2067	2.00 X 2.07 X 5.10	
48		Block (Foam) 74A314857-2073	1.00 X 2.96 X 7.58	
49		Block (Foam) 74A314857-2071	2.00 X 3.17 X 7.92	
50		Block (Foam) 74A314857-2069	1.00 X 1.95 X 10.08	
51		Block (Foam) 74A314857-2047, -2048	1.00 X 1.96 X 3.24	
52		Block (Foam) 74A314857-2043	1.00 X 2.15 X 10.02	
53		Block (Foam) 74A314857-2037	1.00 X 2.96 X 7.58	

Figure 2. Material Index - F/A-18B (Sheet 11)


















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
54		Block (Foam) 74A314857-2227, -2228	3.00 X 0.38 X 4.05	
55		Block (Foam) 74A314857-2297, -2298	1.00 X 1.38 X 1.33	
56		Block (Foam) 74A314857-2117, -2118	1.50 X 2.43 X 3.94	
57		Block (Foam) 74A314857-2295	1.50 X 1.33 X 2.35	
58		Block (Foam) 74A314857-2277	1.00 X 1.33 X 2.35	
59		Block (Foam) 74A314857-2281	1.50 X 2.34 X 16.28	
60		Block (Foam) 74A314857-2185	1.50 X 2.38 X 3.05	
61		Block (Foam) 74A314857-2275	1.50 X 2.38 X 3.05	
62		Block (Foam) 74A314857-2273	3.00 X 3.12 X 4.16	
63		Block (Foam) 74A314857-2283	1.00 X 3.04 X 3.14	
64		Block (Foam) 74A314857-2291	2.00 X 1.79 X 3.02	
L				
R		74A314857-2292	1.50 X 2.79 X 1.83	
65		Block (Foam) 74A314857-2287	3.00 X 2.33 X 3.02	
L				
R		74A314857-2288	1.50 X 2.33 X 2.80	
66		Block (Foam) 74A314857-2143, -2144	1.50 X 2.49 X 3.41	
67		Block (Foam) 74A314857-2105, -2106	1.00 X 2.46 X 4.08	
68		Block (Foam) 74A314857-2103, -2104	1.00 X 1.75 X 1.88	
69		Block (Foam) 74A314857-2101	1.00 X 1.76 X 4.62	
70		Block (Foam) 74A314857-2099, -2100	1.00 X 1.66 X 1.97	

Figure 2. Material Index - F/A-18B (Sheet 12)


















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
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L				
R		74A314857-2286	2.00 X 2.33 X 2.80	
73		Block (Foam) 74A314857-2289	3.00 X 2.05 X 3.52	
L				
R		74A314857-2290	1.50 X 2.05 X 2.12	
74		Block (Foam) 74A314857-2279	1.00 X 3.20 X 3.63	
75		Block (Foam) 74A314857-2115	4.00 X 2.96 X 3.33	
76		Block (Foam) 74A314857-2293	1.50 X 3.13 X 3.12	
77		Block (Foam) 74A314857-2089	1.00 X 1.98 X 4.07	
78		Block (Foam) 74A314857-2091	2.00 X 2.11 X 2.22	
79		Block (Foam) 74A314857-2097	3.00 X 4.28 X 7.08	
80		Block (Foam) 74A314857-2095	1.50 X 2.08 X 4.28	
81		Block (Foam) 74A314857-2133	1.50 X 2.32 X 4.28	
82		Block (Foam) 4A314857-2093	1.50 X 2.27 X 4.28	
83		Block (Foam) 74A314857-2305	1.50 X 2.11 X 2.22	
84		Block (Foam) 74A314857-2307	1.50 X 0.80 X 4.07	
85		Block (Foam) 74A314857-2087, -2088	3.00 X 4.67 X 4.94	
86		Block (Foam) 74A314857-2085, -2086	2.00 X 1.85 X 4.53	
87		Block (Foam) 74A314857-2083, -2084	2.00 X 2.15 X 4.09	

Figure 2. Material Index - F/A-18B (Sheet 13)


























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
88		Block (Foam) 74A314857-2081, -2082	1.00 X 1.38 X 2.70	
89		Block (Foam) 74A314857-2079, -2080	1.50 X 2.43 X 5.14	
90		Block (Foam) 74A314857-2077	1.00 X 1.15 X 1.80	
91		Block (Foam) 74A314857-2075, -2076	1.50 X 1.67 X 1.76	
92		Block (Foam) 74A314857-2090	1.00 X 1.98 X 4.07	
93		Block 74A314670-2089	1.00 X 3.45 X 7.07	 
94		Block 74A314670-2193	1.00 X 3.45 X 7.07	 
95		Block 74A314670-2099, -2100	1.00 X 3.34 X 10.35	 
96		Block 74A314670-2109, -2110	1.00 X 2.87 X 2.95	 
97		Block (Foam) 74A314670-2245	0.25 X 1.55 X 42.30	
98		Block (Foam) 74A314670-2243	0.25 X 0.95 X 44.20	
99		Block (Foam) 74A314670-2201	0.25 X 1.62 X 45.32	
100		Block (Foam) 74A314670-2249	0.25 X 1.75 X 44.50	
101		Block 74A314670-2105	1.75 X 2.22 X 3.07	 
102		Block 74A314670-2107	1.75 X 3.26 X 6.54	 
103		Block (Foam) 74A314670-2247	0.25 X 1.12 X 41.75	
104		Block (Foam) 74A314670-2233	0.25 X 1.20 X 1.71	
105		Block (Foam) 74A314670-2275	0.50 X 1.30 X 9.00	

Figure 2. Material Index - F/A-18B (Sheet 14)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
106	6	Block (Foam) 74A314670-2273	0.50 X 1.30 X 8.00	1
107	6	Block (Foam) 74A314670-2263	0.50 X 1.60 X 1.60	1
108	6	Block (Foam) 74A314670-2271	0.50 X 1.30 X 7.65	1
109	6	Block (Foam) 74A314670-2269	0.50 X 1.30 X 8.00	1
110	6	Block (Foam) 74A314670-2267	0.50 X 1.30 X 2.30	1
111	6	Block (Foam) 74A314670-2265	0.50 X 2.80 X 4.30	1
112	7	Block (Foam) 74A314670-2277 -2278	0.80 X 2.06 X 3.46	1
113		Block (Foam) 74A314670-2237	0.50 X 0.65 X 7.35	1
114		Block (Foam) 74A314857-2267	1.50 X 0.30 X 5.57	1
115		Block (Foam) 74A314857-2189	1.00 X 0.45 X 5.40	1
116		Block (Foam) 74A314857-2163	1.00 X 2.38 X 6.66	1
117		Block (Foam) 74A314857-2153	1.00 X 2.13 X 6.78	1
118		Block (Foam) 74A314857-2215	1.00 X 1.21 X 1.60	1
119		Block (Foam) 74A314857-2253	2.00 X 3.08 X 4.95	1
120		Block (Foam) 74A314857-2213	1.50 X 0.55 X 4.75	1
121		Block (Foam) 74A314857-2203	3.00 X 4.95 X 5.28	1
122		Block (Foam) 74A314857-2251	2.00 X 3.14 X 3.18	1
123		Block (Foam) 74A314857-2259	3.00 X 2.50 X 6.50	1

Figure 2. Material Index - F/A-18B (Sheet 15)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
124		Block (Foam) 74A314857-2209	3.00 X 5.06 X 6.38	
125		Block (Foam) 74A314857-2211	1.50 X 1.67 X 3.12	
126		Block (Foam) 74A314857-2239, -2240	1.00 X 2.12 X 3.58	
127		Block (Foam) 74A314857-2207	2.00 X 3.00 X 3.21	
128		Block (Foam) 74A314857-2217	3.00 X 4.47 X 5.06	
129		Block (Foam) 74A314857-2255	3.00 X 2.50 X 3.36	
130		Block (Foam) 74A314857-2257	3.00 X 2.50 X 4.60	
131		Block (Foam) 74A314857-2199	2.00 X 3.15 X 3.68	
132		Block (Foam) 74A314857-2205	3.50 X 3.95 X 5.20	
133		Block (Foam) 74A314857-2245	3.00 X 3.52 X 3.73	
134		Block (Foam) 74A314857-2197	1.00 X 2.18 X 4.75	
135		Block (Foam) 74A314857-2195	1.00 X 1.75 X 2.40	
136		Block (Foam) 74A314857-2247	3.00 X 3.52 X 2.80	
137		Block (Foam) 74A314857-2201	3.00 X 3.25 X 5.02	
138		Block (Foam) 74A314857-2177	1.00 X 2.38 X 3.75	
139		Block (Foam) 74A314857-2241	3.00 X 3.52 X 5.79	
140		Block (Foam) 74A314857-2193	2.00 X 0.55 X 5.40	
141		Block (Foam) 74A314857-2191	1.00 X 3.50 X 5.40	

Figure 2. Material Index - F/A-18B (Sheet 16)























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
142		Block (Foam) 74A314857-2155	2.00 X 0.50 X 5.08	
143		Block (Foam) 74A314857-2167	3.00 X 2.70 X 5.80	
144		Block (Foam) 74A314857-2173, -2174	3.00 X 2.55 X 5.80	
145		Block (Foam) 74A314857-2183, -2184	3.00 X 2.55 X 4.95	
146		Block (Foam) 74A314857-2179	1.50 X 0.30 X 7.16	
147		Block (Foam) 74A314857-2151, -2152	1.50 X 5.60 X 7.20	
148		Block (Foam) 74A314857-2161, -2162	1.50 X 5.08 X 7.20	
149 L R		Block (Foam) 74A314857-2165 74A314857-2166	1.50 X 4.50 X 4.60 1.50 X 4.60 X 5.28	
150 L R		Block (Foam) 74A314857-2169 74A314857-2170	1.50 X 3.90 X 6.00 1.50 X 5.54 X 6.00	
151		Block (Foam) 74A314857-2181	1.50 X 0.30 X 4.60	
152		Block (Foam) 74A314670-2253	1.50 X 5.00 X 8.25	
153		Block (Foam) 74A314670-2251	1.50 X 16.85 X 21.00	
154		Pad (Foam) 74A314857-2311	0.25 X 3.10 X 10.50	
155		Block (Foam) 74A582075-2003	6.75 X 9.00 X 12.00	
LEGEND				
 PPP-C-1752 Type 1, Class 3, 2 pounds per cu. ft.				
 Hexcel HRH-10-3/16, 2 pounds per cu. ft., nylon base honeycomb core, 1.00 in. thick 0.006 .				
 Hexcel HRH-10-3/16, 2 pounds per cu. ft., nylon base honeycomb core, 1.75 in. thick 0.006 .				
 PPP-C-1752 Type 5, Class 3, 9 pounds per cu ft.				
 3M pressure sensitive tape no. 8564X over blocks.				
 F/A-18B 162402 AND UP.				
 F/A-18B 162836 AND UP.				

Figure 2. Material Index - F/A-18B (Sheet 17)

INTERMEDIATE MAINTENANCE

STRUCTURE REPAIR

FUEL CAVITY NUMBER 1 FILLER BLOCKS, 74A314670 AND 74A582075, FABRICATION

Reference Material

Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Fuel Tank Cavity Number 1 Filler Blocks	WP031 01
Fuel System	A1-F18AC-460-300
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18A	WP017 01
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18B	WP017 02

Alphabetical Index

Subject	Page No.
Fabrication	1
Block, 74A582075	2

Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
EC847	Adhesive
H-B-695 TYPE 1 GRADE A SIZE 1	Brush, Varnish
PPP-T-66 TYPE 1 CLASS 2, 3/4 White	Tape, Pressure sensitive

Materials Required (Continued)

Specification or Part Number	Nomenclature
PPP-C-1752 TYPE V	Foam Block
1. FABRICATION. See figure 1.	
2. See figure for block dimensions. For type of material and stock size (WP031 01). For removal and installation of blocks (A1-F18AC-460-300, WP017 01 or WP017 02).	

3. **BLOCK, 74A582075.** See figure 1.

a. Cut four pieces of foam. Score mating surfaces.



Adhesive, EC847

13

b. Brush EC847 adhesive on mating surfaces of foam.

c. Allow adhesive to become tacky (5 to 10 minutes) before bonding.

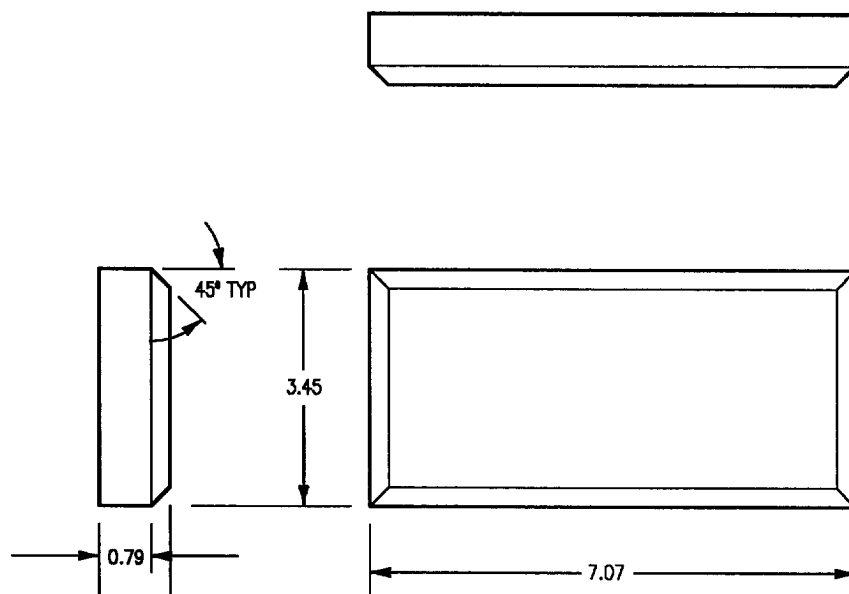
d. Bond four blocks together. Apply hand pressure to be sure of proper seating and remove trapped air.

e. Tape foam blocks together with pressure tape.

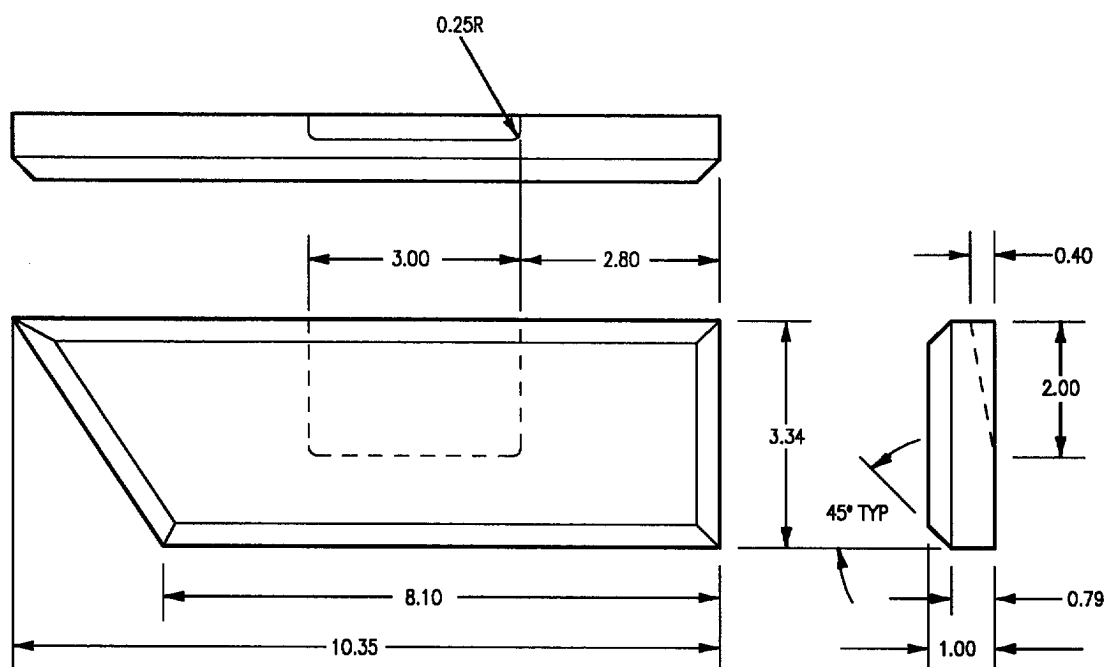
f. Allow 2 hours to dry.

g. Cut foam filler block per figure.

h. Remove pressure tape.

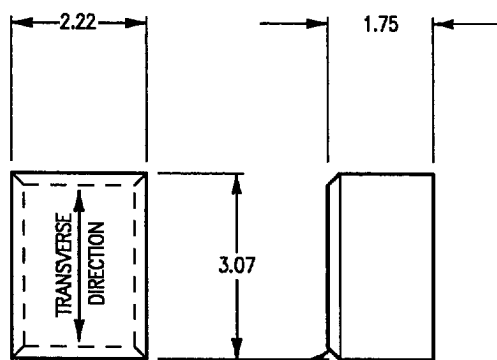


74A314670-2089



74A314670-2099 LEFT SIDE
74A314670-2100 RIGHT SIDE

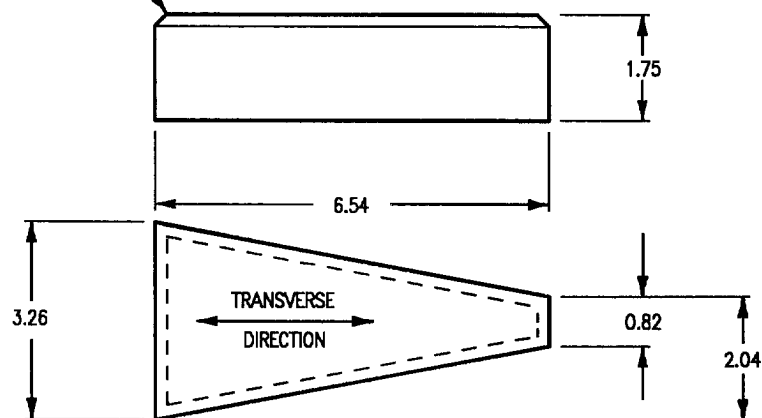
Figure 1. Blocks Fabrication (Sheet 1)



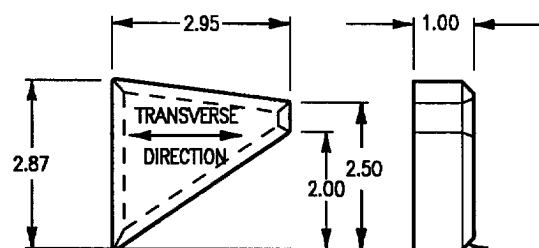
CHAMFER
0.20 X 45° TYP

74A314670-2015

CHAMFER
0.20 X 45° TYP



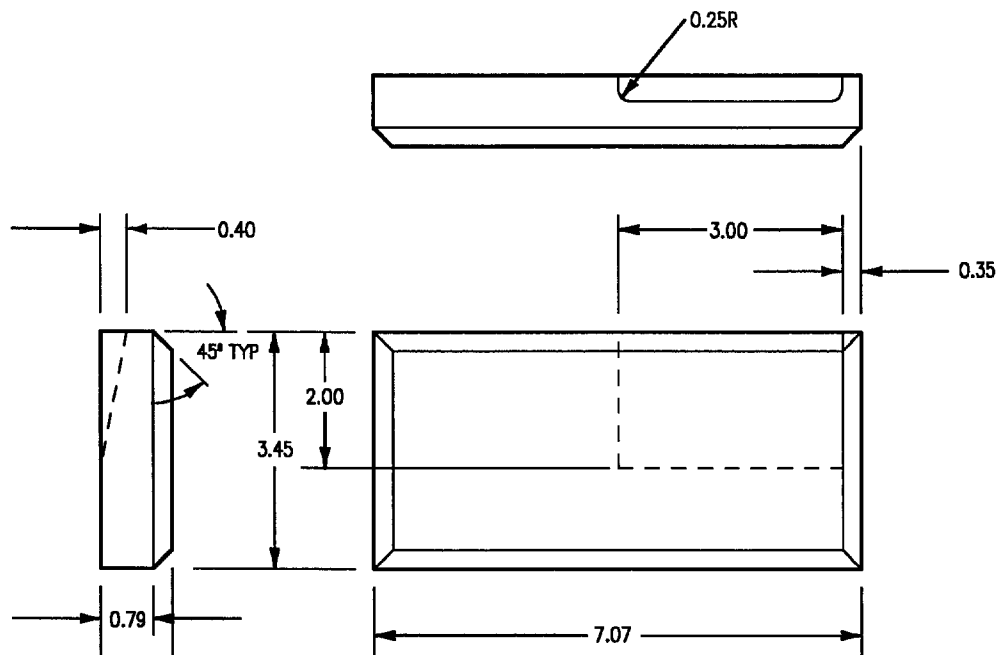
74A314670-2107



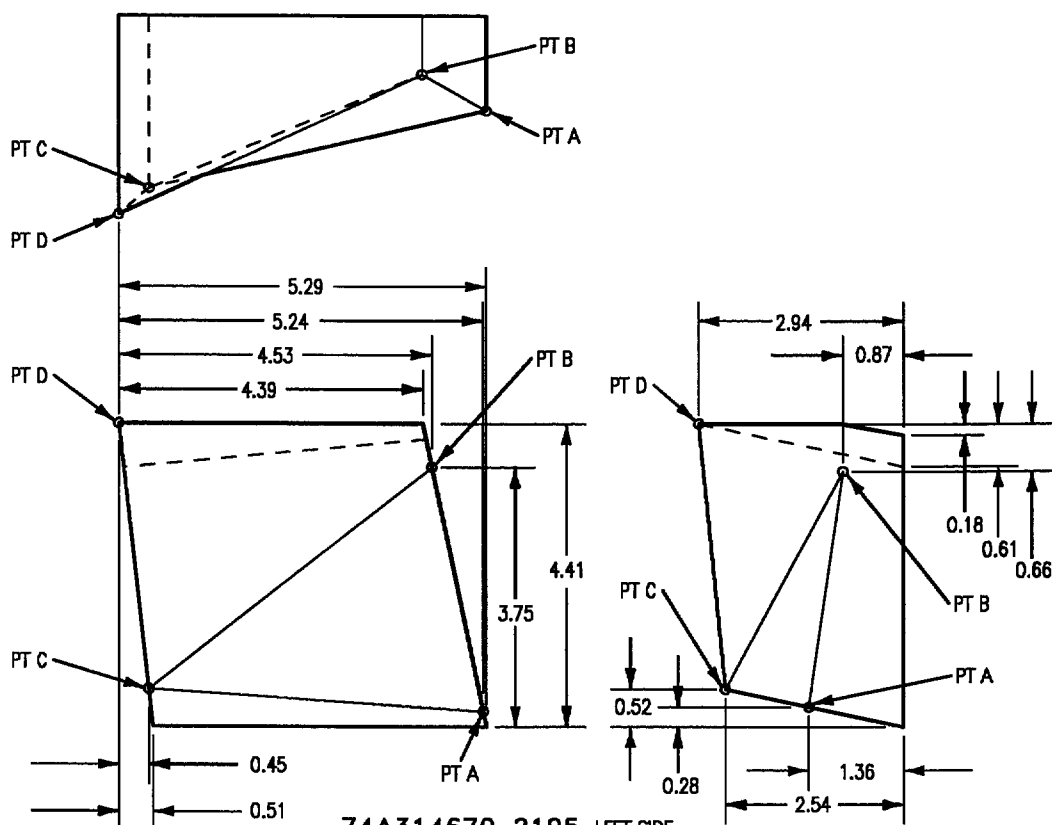
74A314670-2109 LEFT SIDE
74A314670-2110 RIGHT SIDE

CHAMFER
0.20 X 45° TYP

Figure 1. Blocks Fabrication (Sheet 2)



74A314670-2193



74A314670-2195 LEFT SIDE

74A314670-2196 RIGHT SIDE

18AC-SRM-222-(30-3)01-CATI

Figure 1. Blocks Fabrication (Sheet 3)

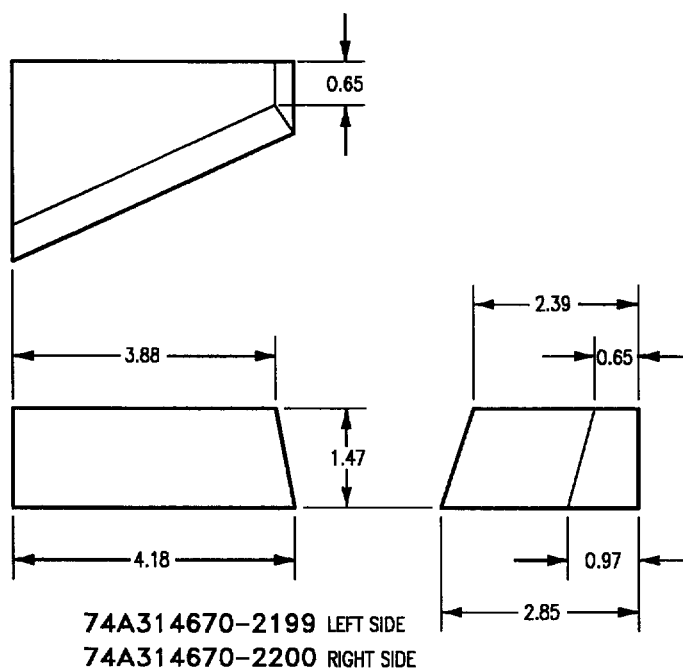
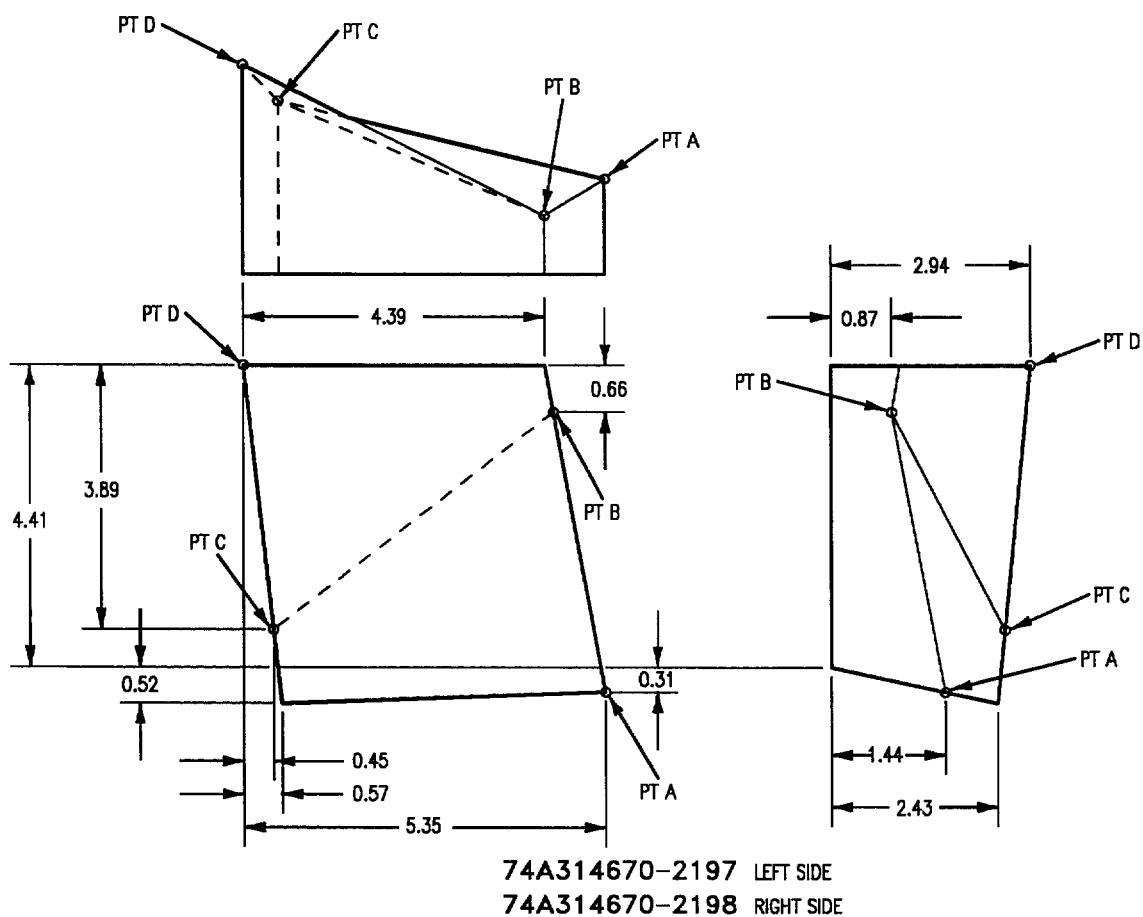


Figure 1. Blocks Fabrication (Sheet 4)

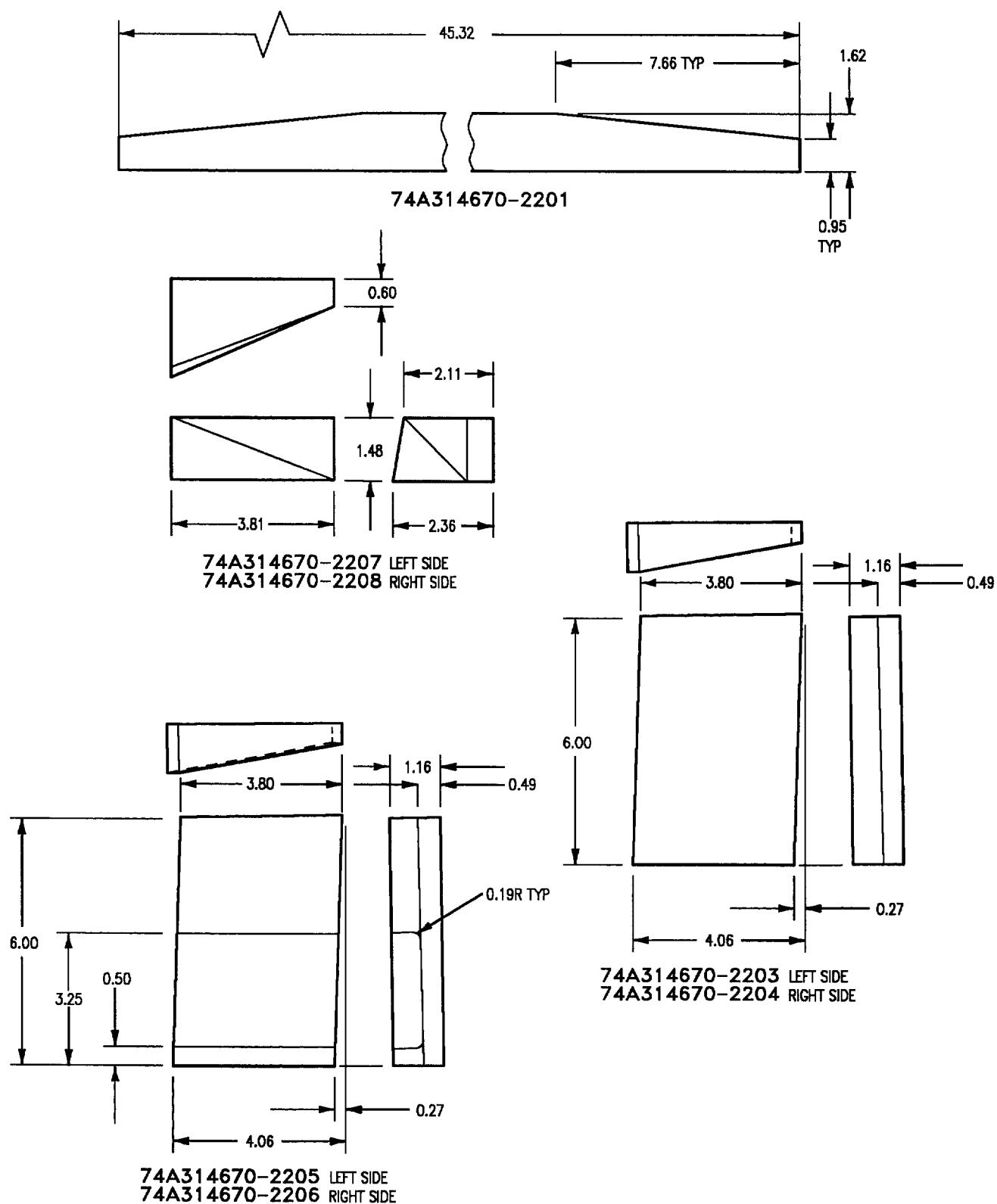
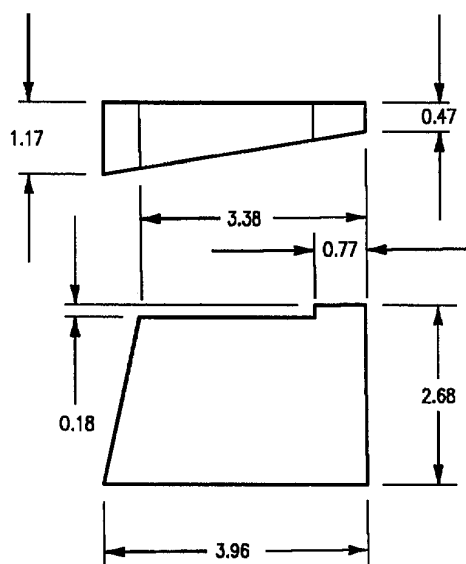
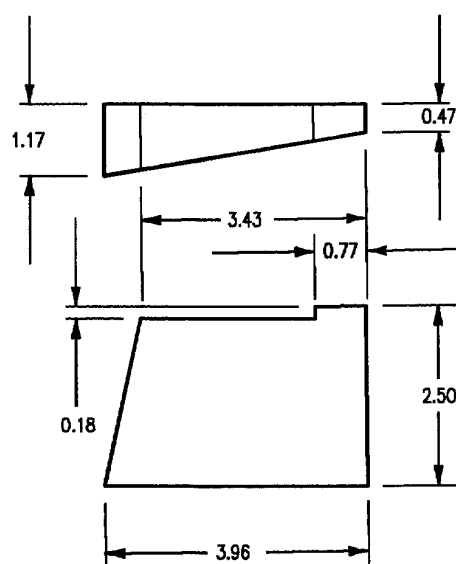


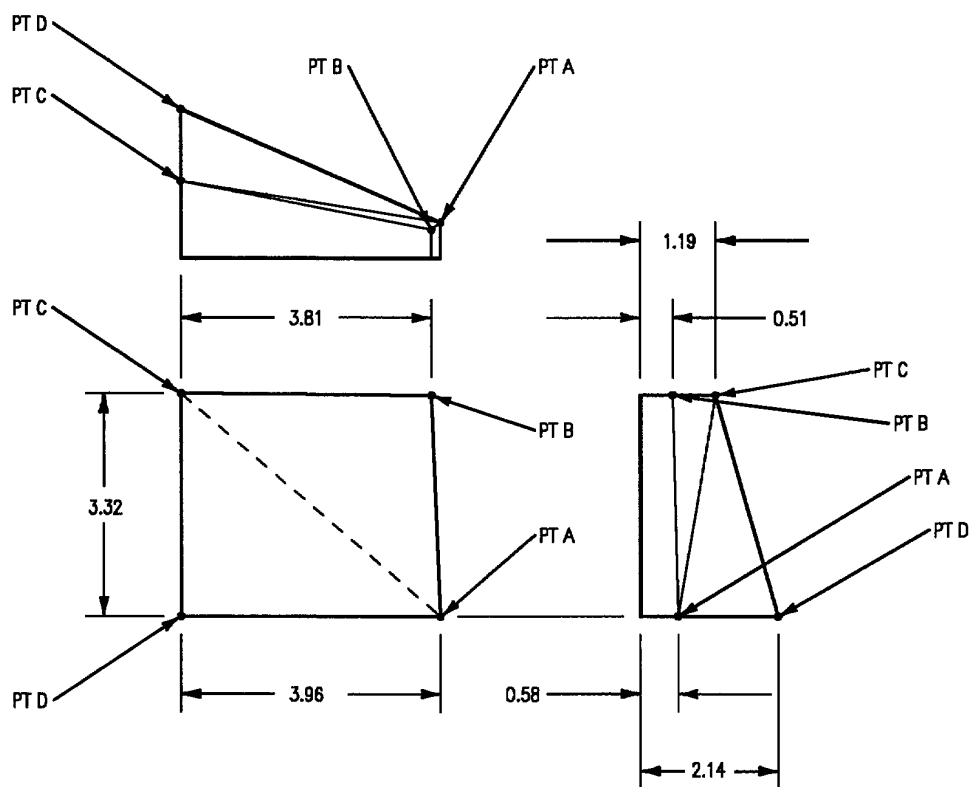
Figure 1. Blocks Fabrication (Sheet 5)



74A314670-2209 LEFT SIDE
74A314670-2210 RIGHT SIDE

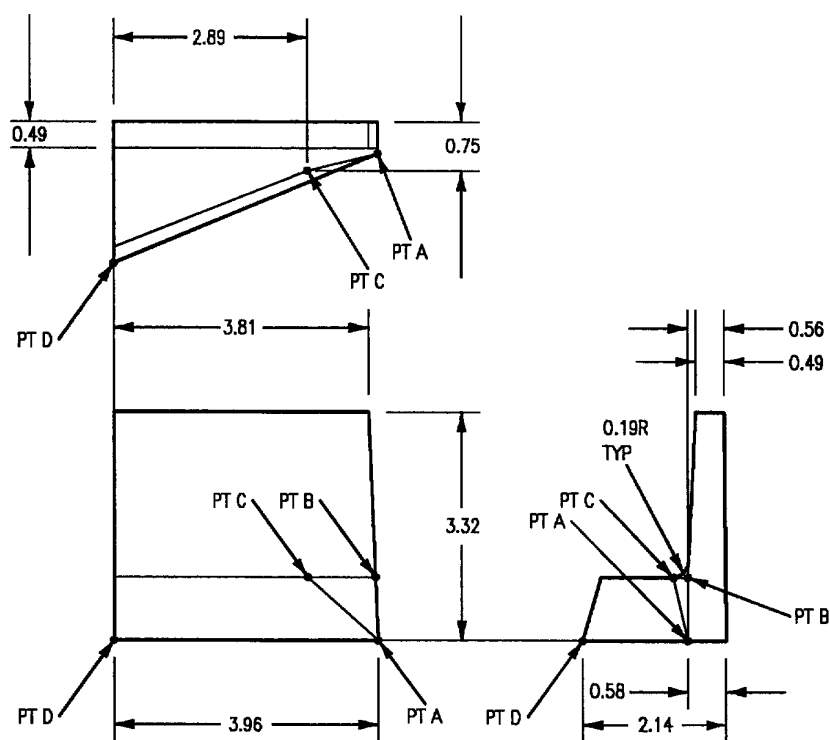


74A314670-2211 LEFT SIDE
74A314670-2212 RIGHT SIDE



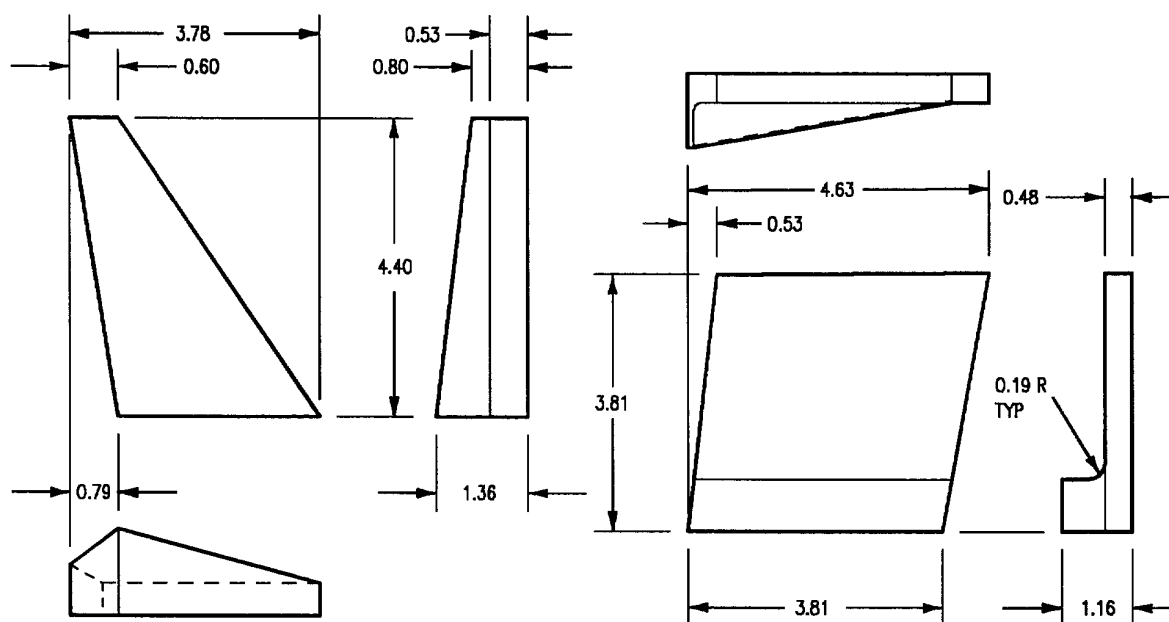
74A314670-2213 LEFT SIDE
74A314670-2214 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 6)



74A314670-2215 LEFT SIDE

74A314670-2216 RIGHT SIDE



74A314670-2219 LEFT SIDE

74A314670-2220 RIGHT SIDE

74A314670-2217 LEFT SIDE

74A314670-2218 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 7)

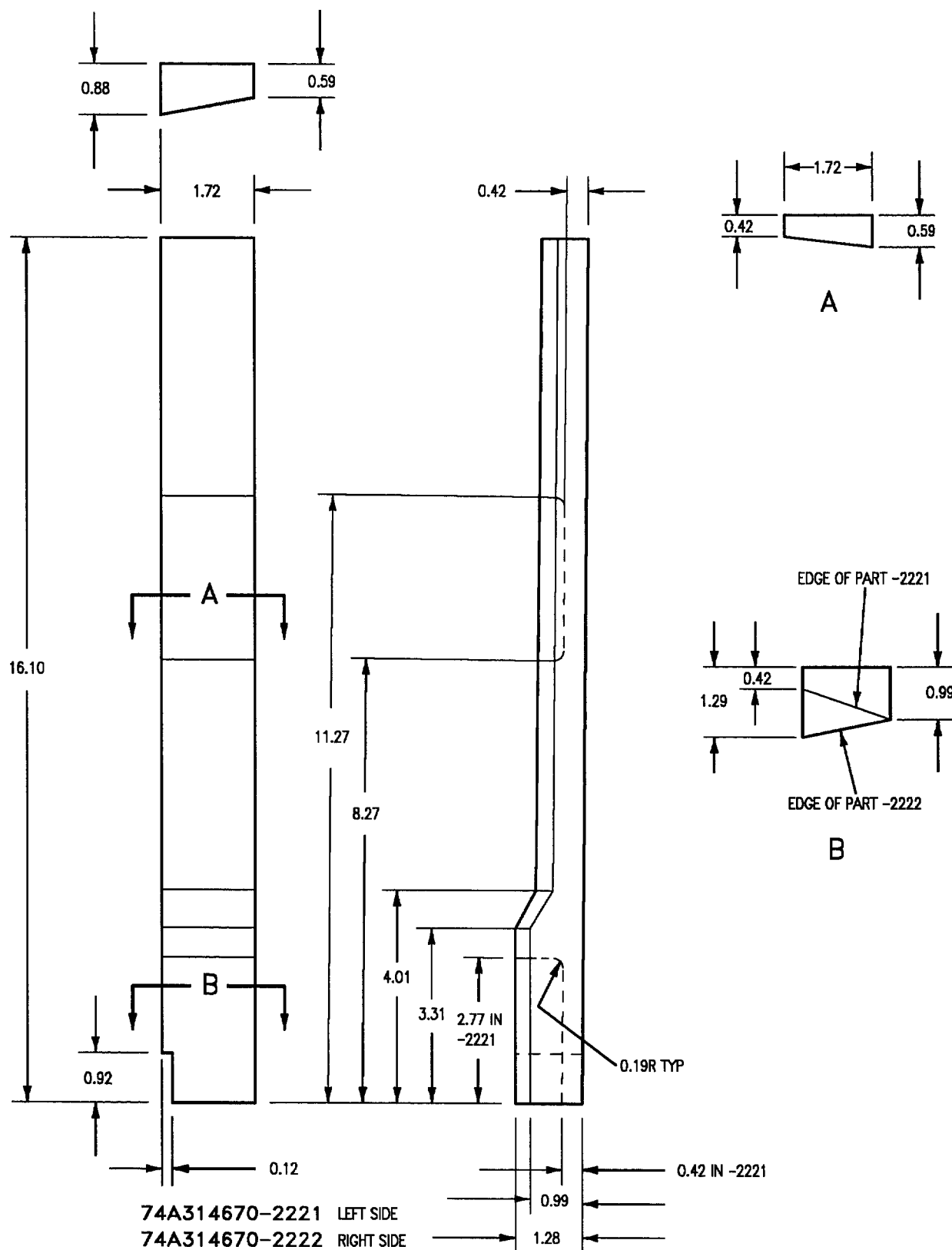


Figure 1. Blocks Fabrication (Sheet 8)

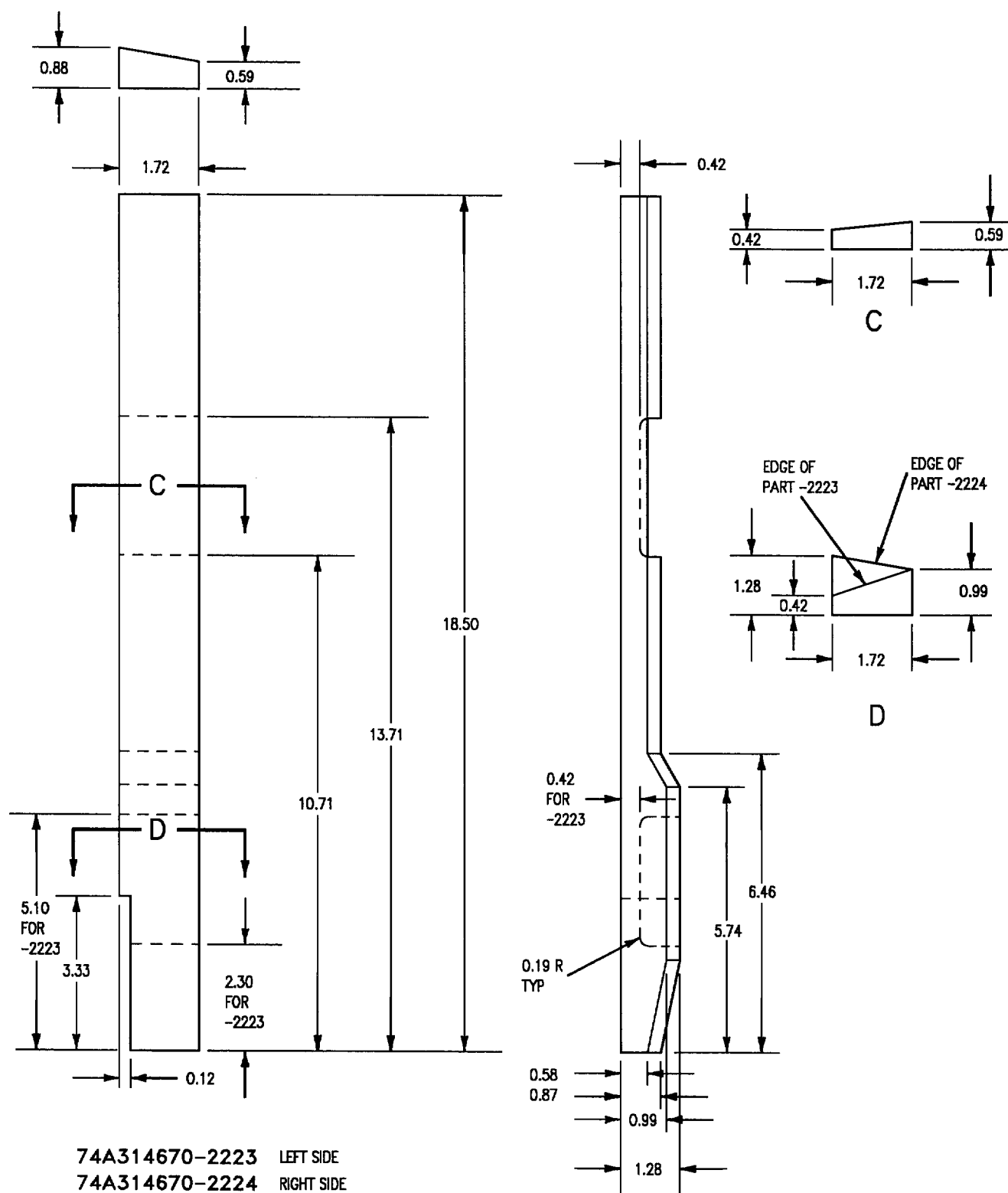
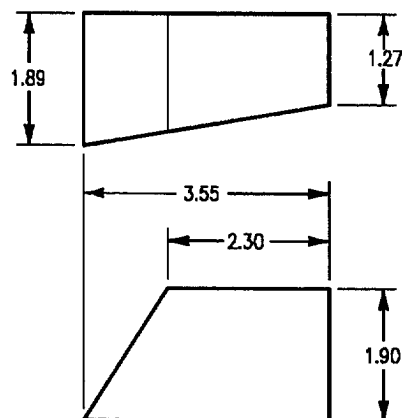
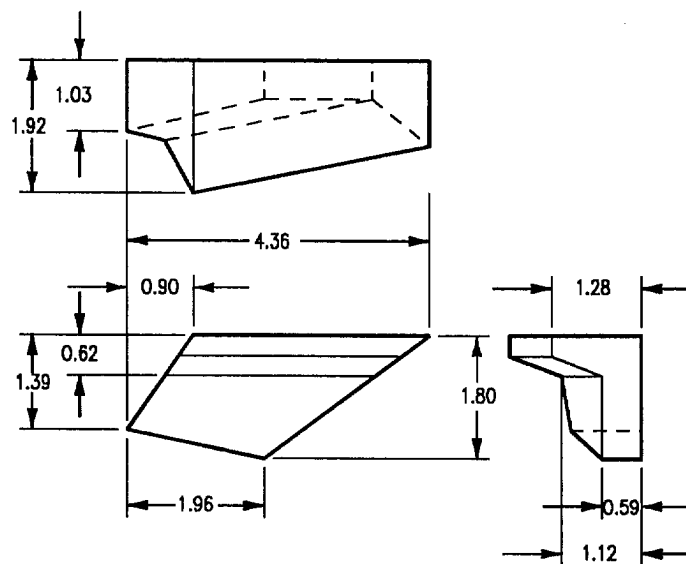


Figure 1. Blocks Fabrication (Sheet 9)



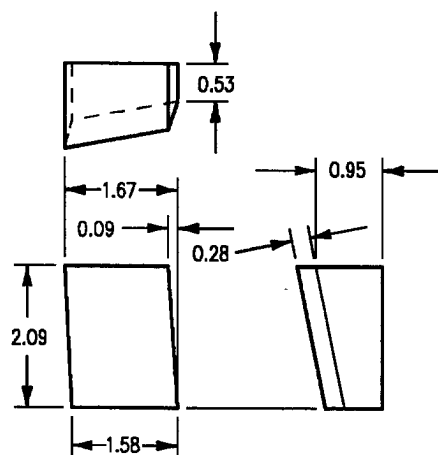
74A314670-2225 LEFT SIDE

74A314670-2226 RIGHT SIDE



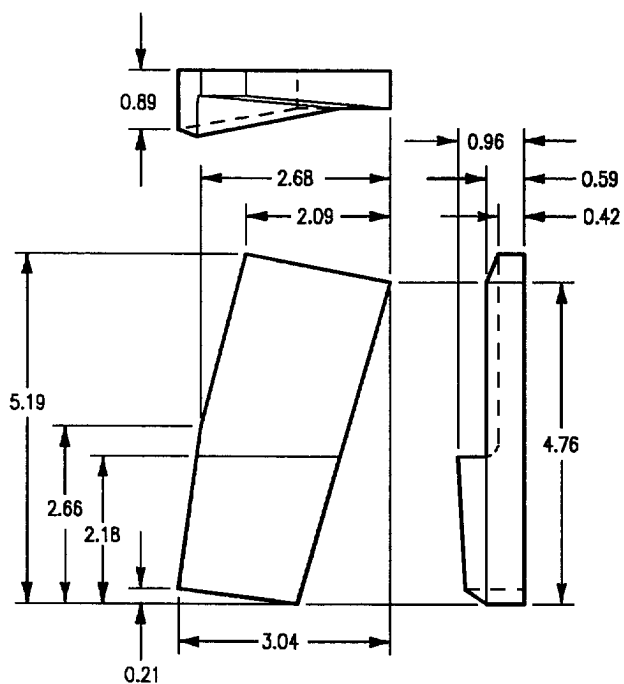
74A314670-2227 LEFT SIDE

74A314670-2228 RIGHT SIDE



74A314670-2231 LEFT SIDE

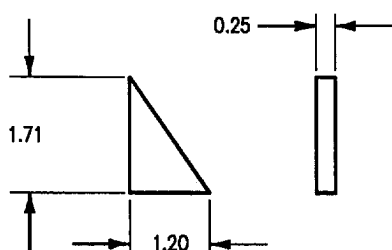
74A314670-2232 RIGHT SIDE



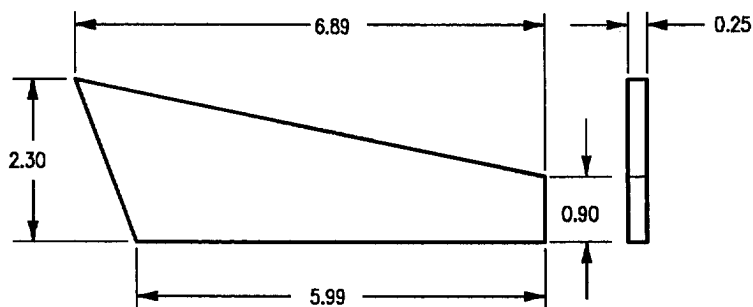
74A314670-2229 LEFT SIDE

74A314670-2230 RIGHT SIDE

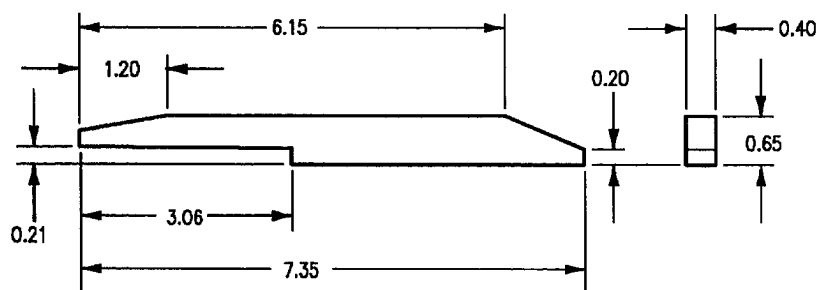
Figure 1. Blocks Fabrication (Sheet 10)



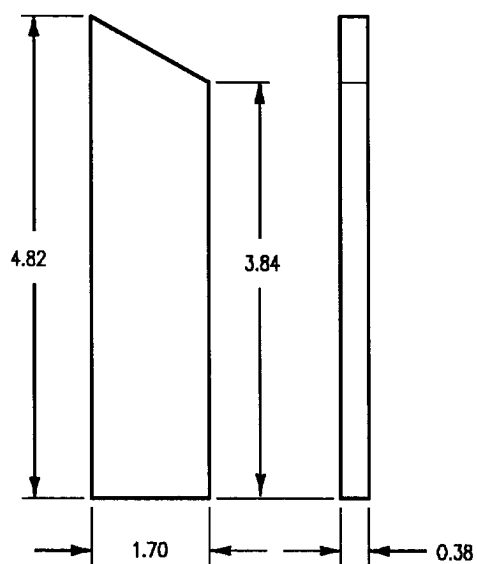
74A314670-2233



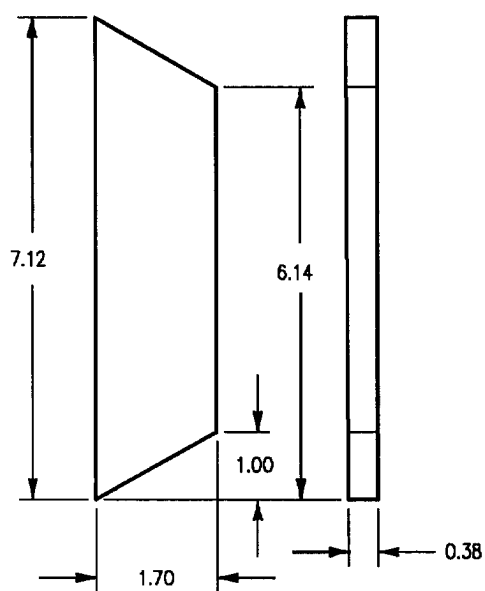
74A314670-2235



74A314670-2237



74A314670-2241



74A314670-2239

Figure 1. Blocks Fabrication (Sheet 11)

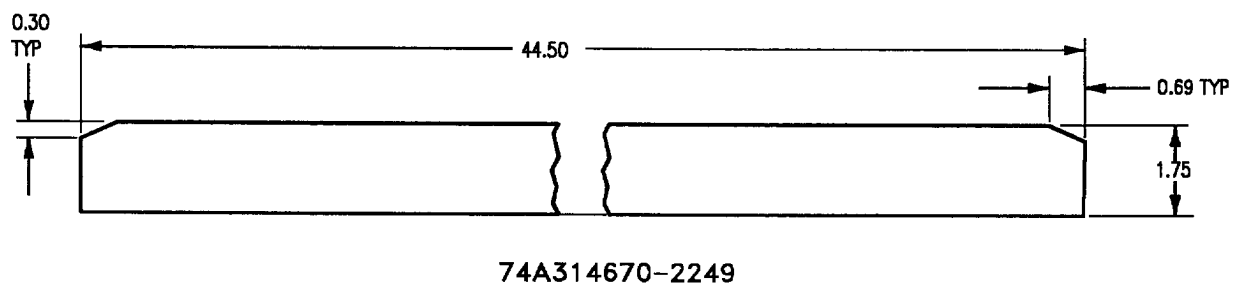
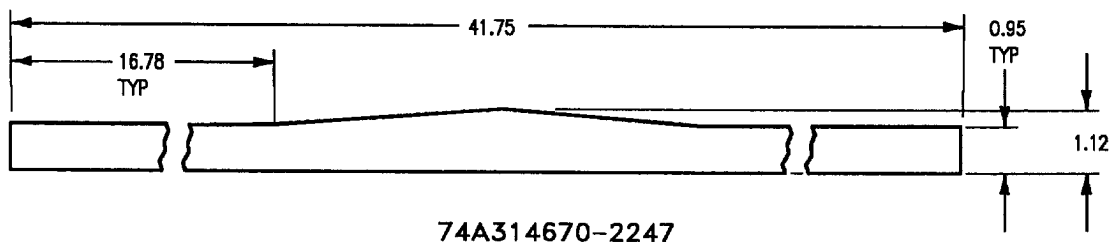
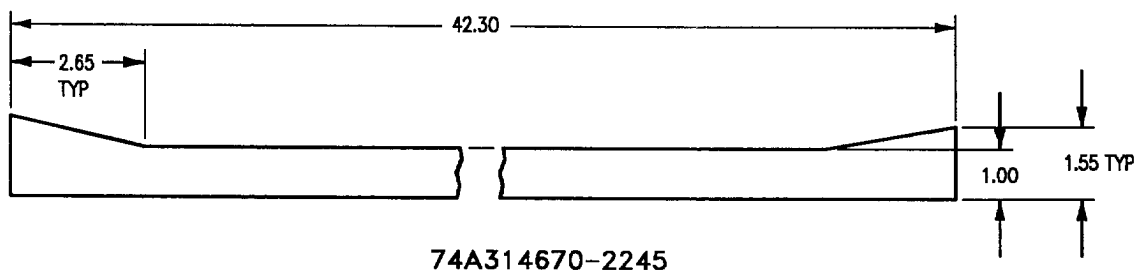
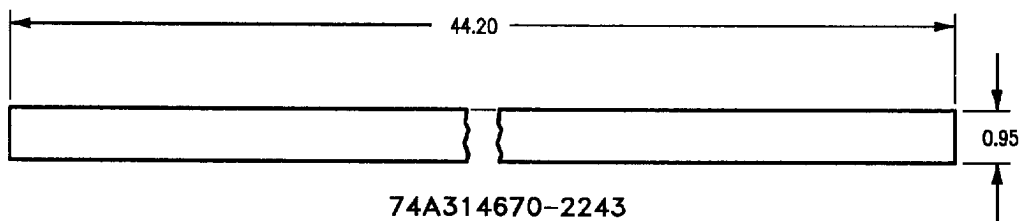
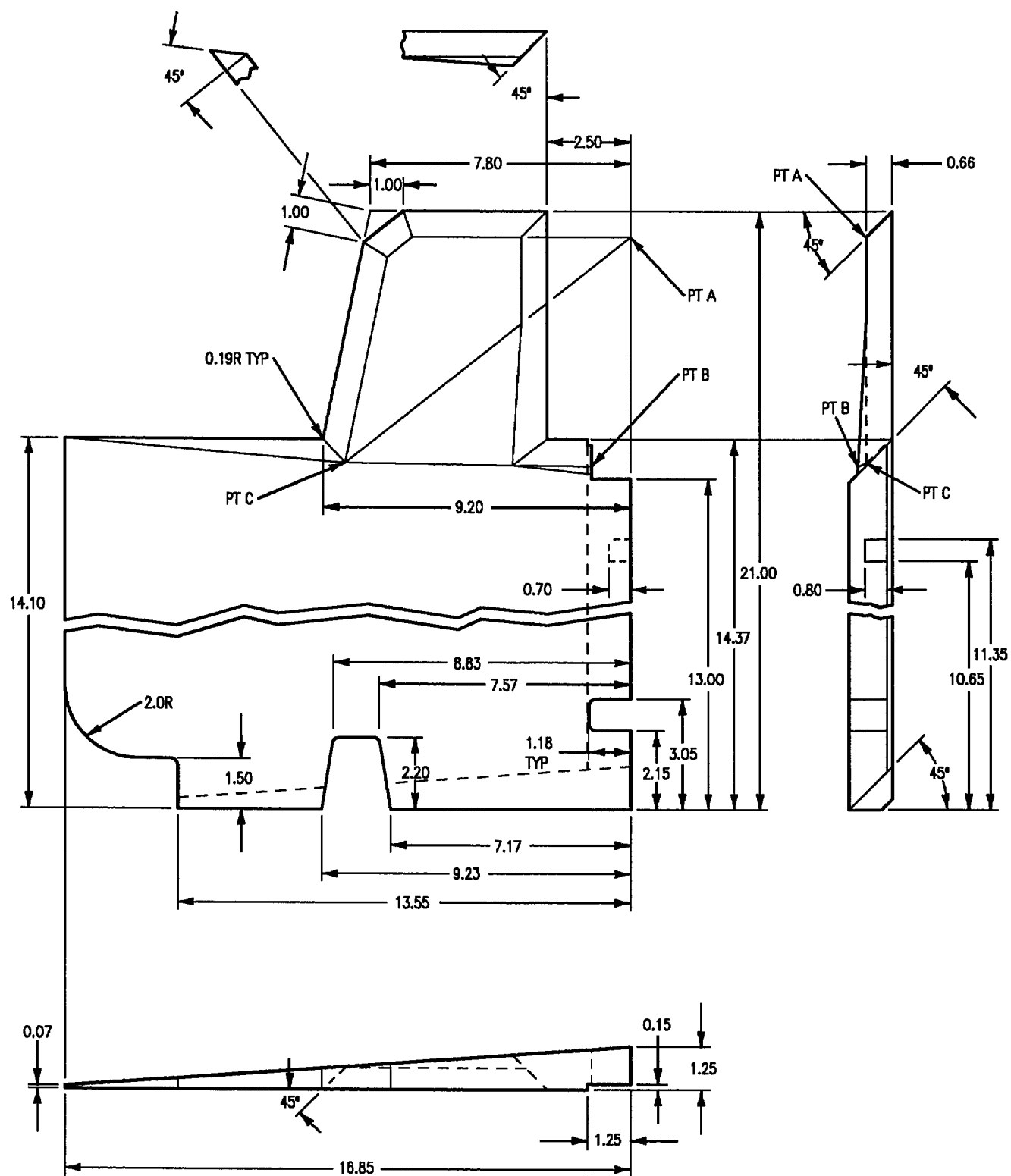


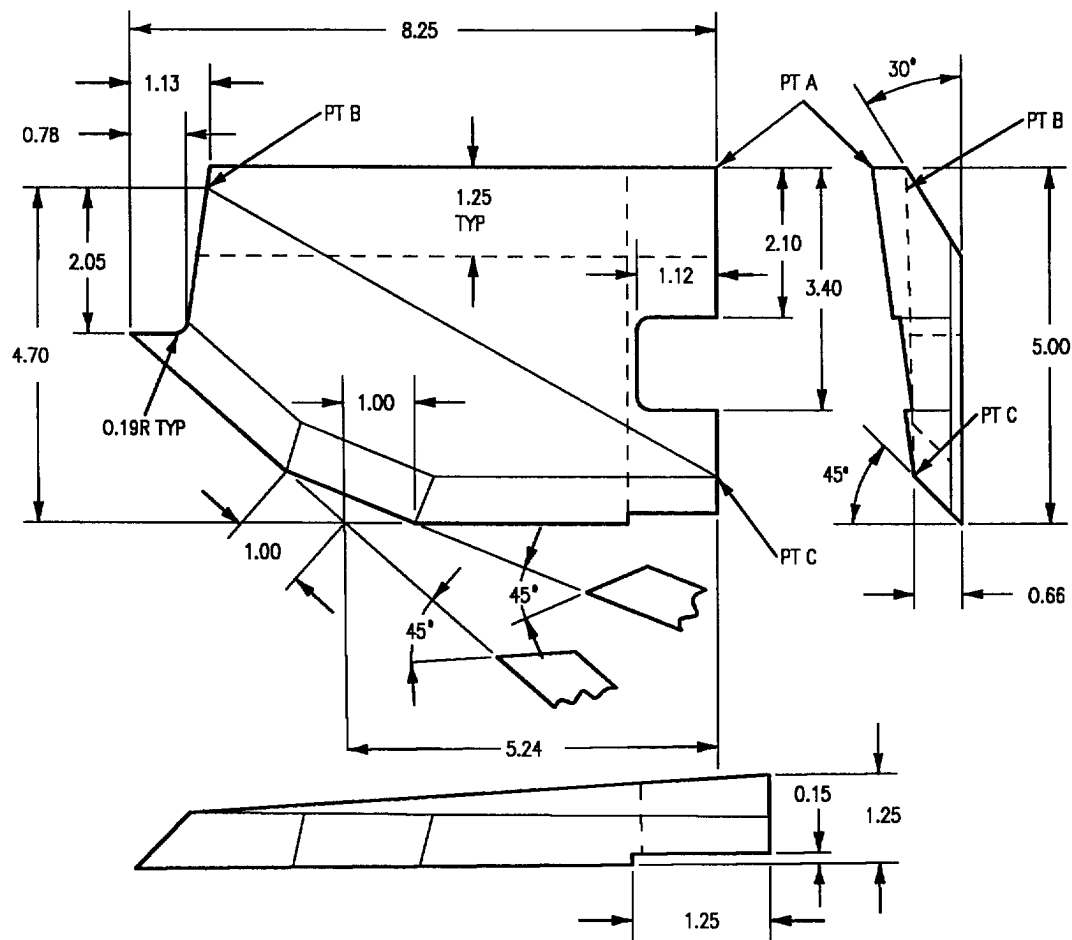
Figure 1. Blocks Fabrication (Sheet 12)



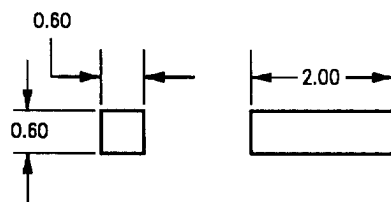
74A314670-2251

18AC-SRM-222-(30-13)01-CAT1

Figure 1. Blocks Fabrication (Sheet 13)



74A314670-2253



74A314670-2255

Figure 1. Blocks Fabrication (Sheet 14)

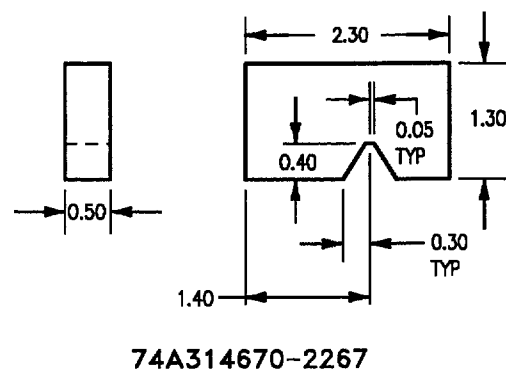
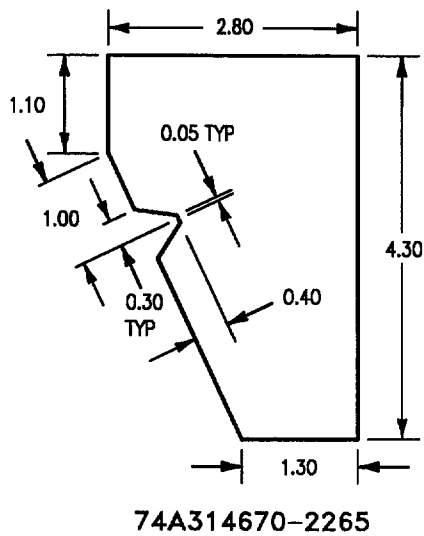
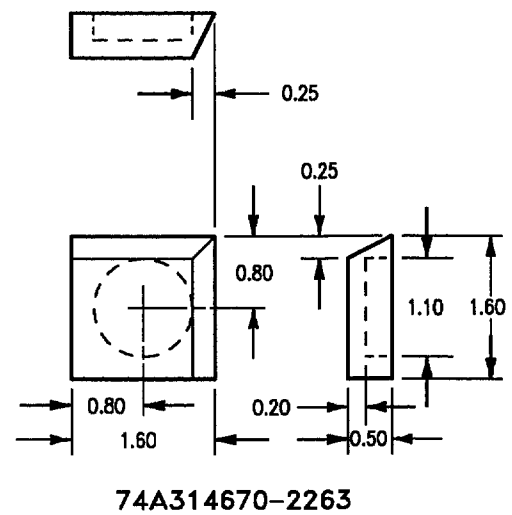
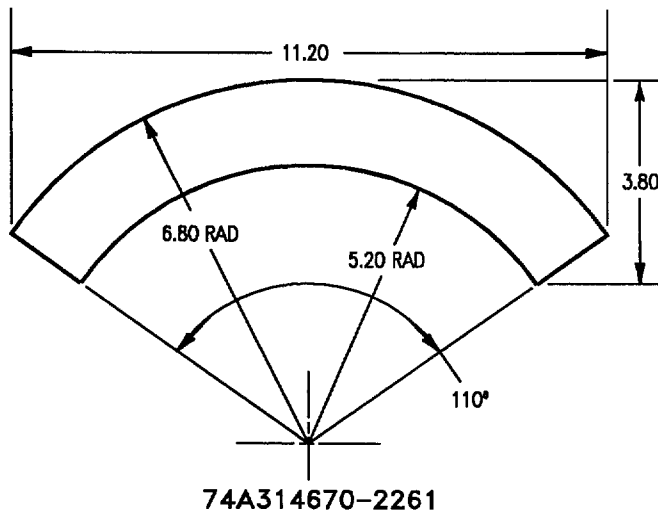
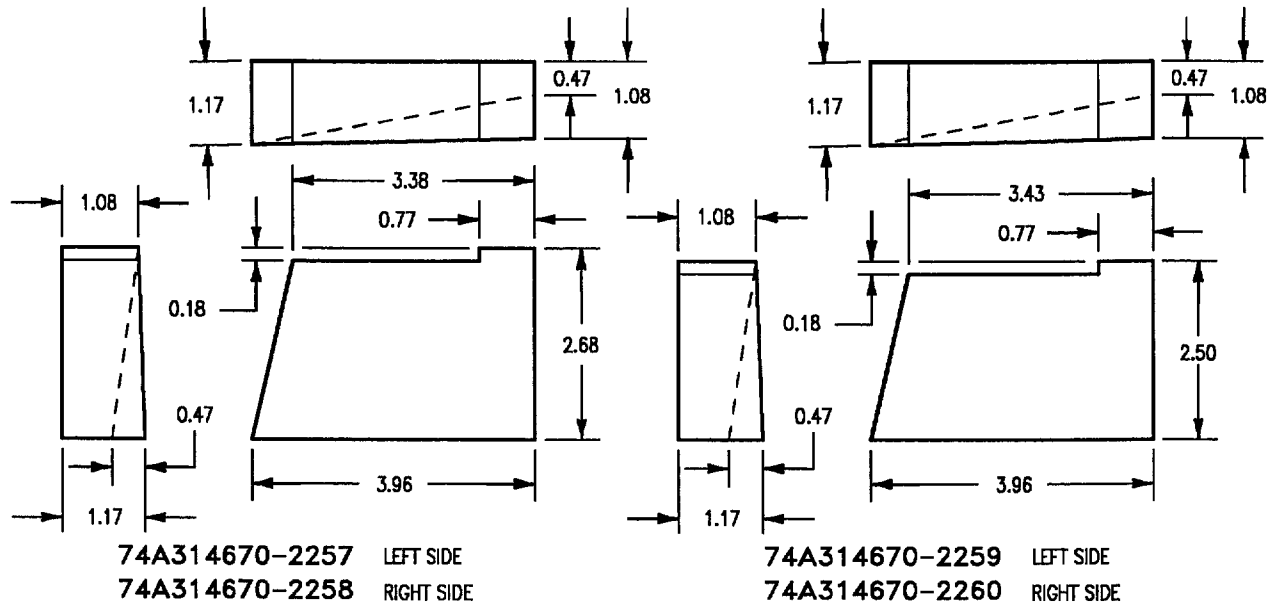


Figure 1. Blocks Fabrication (Sheet 15)

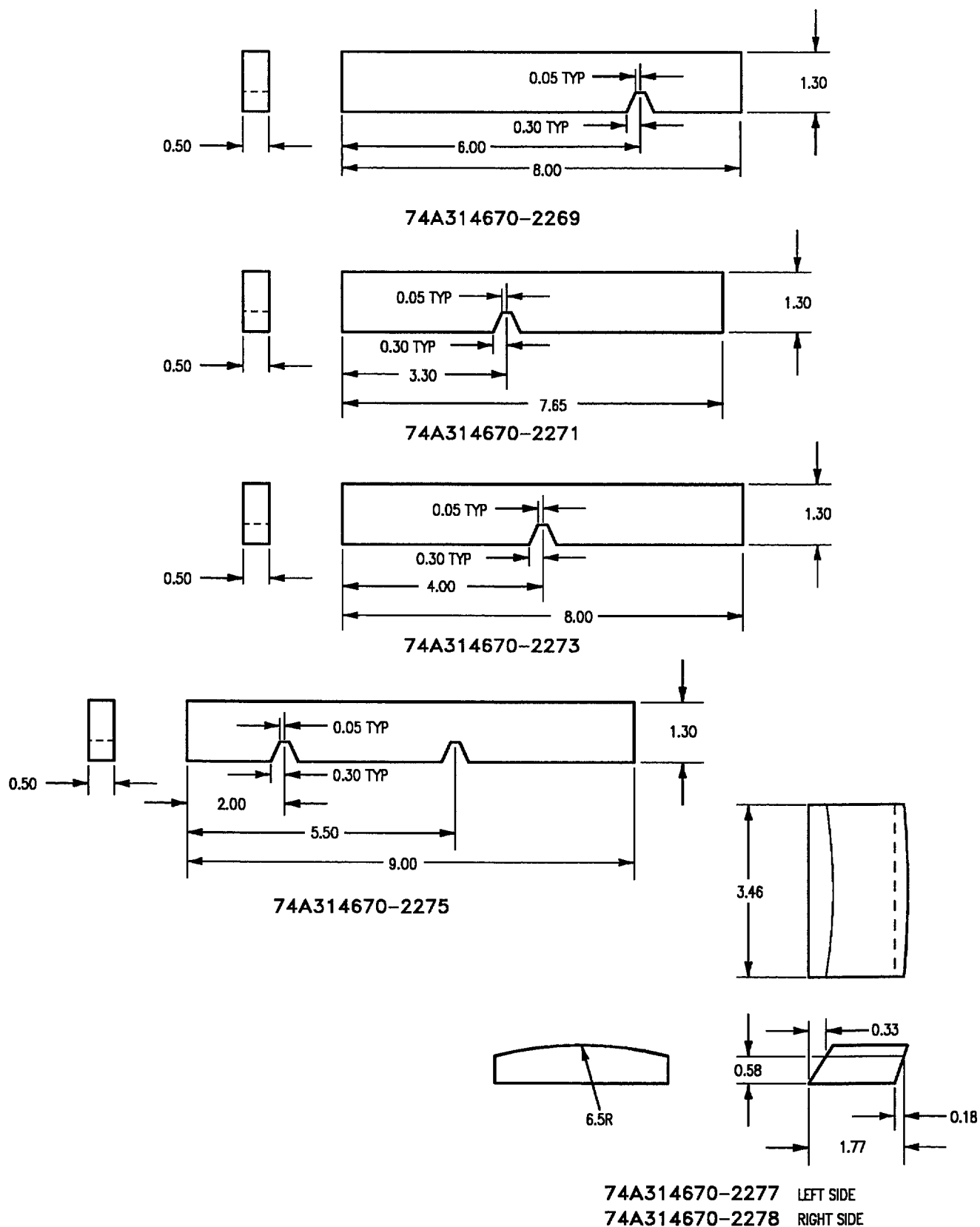
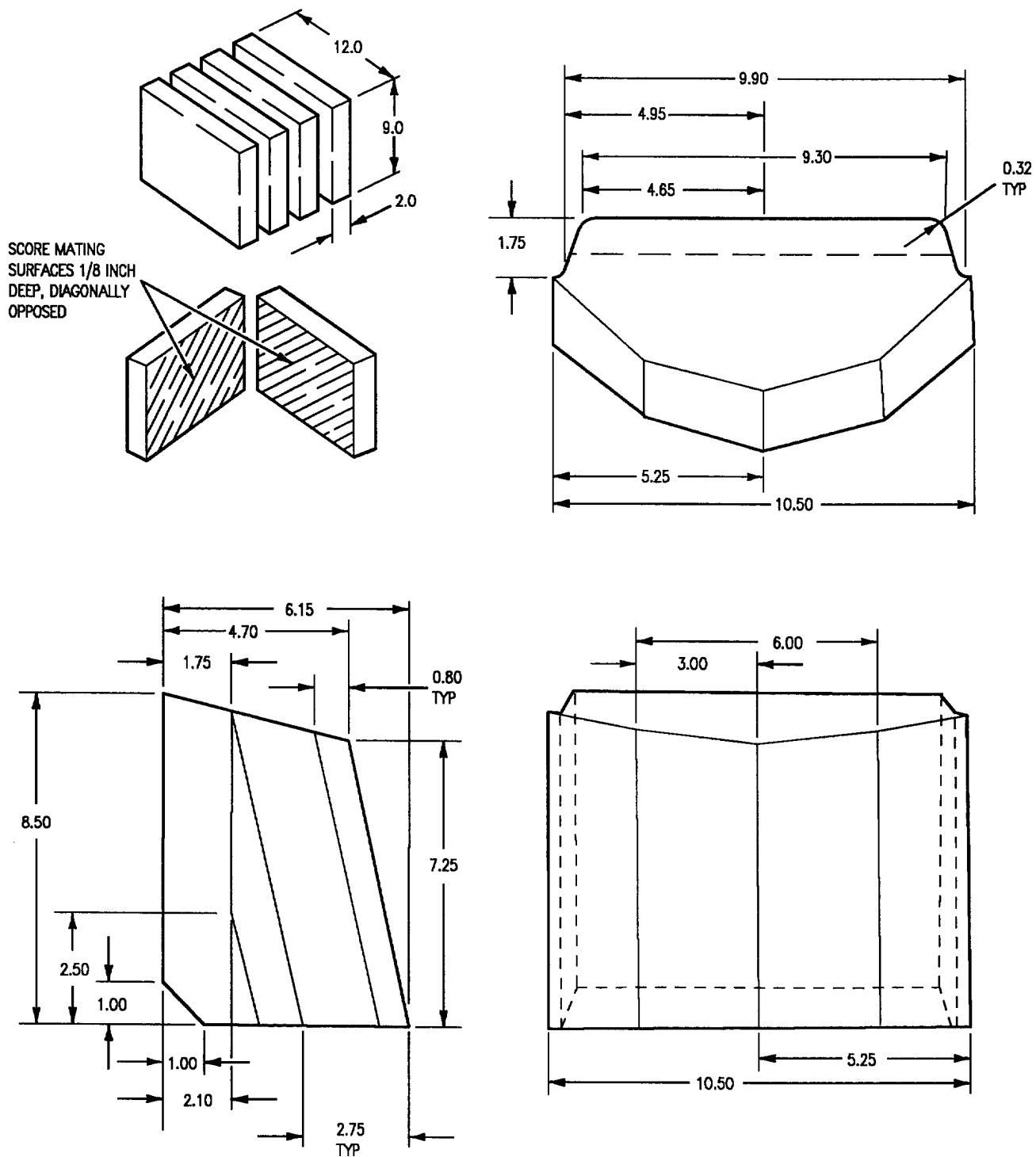


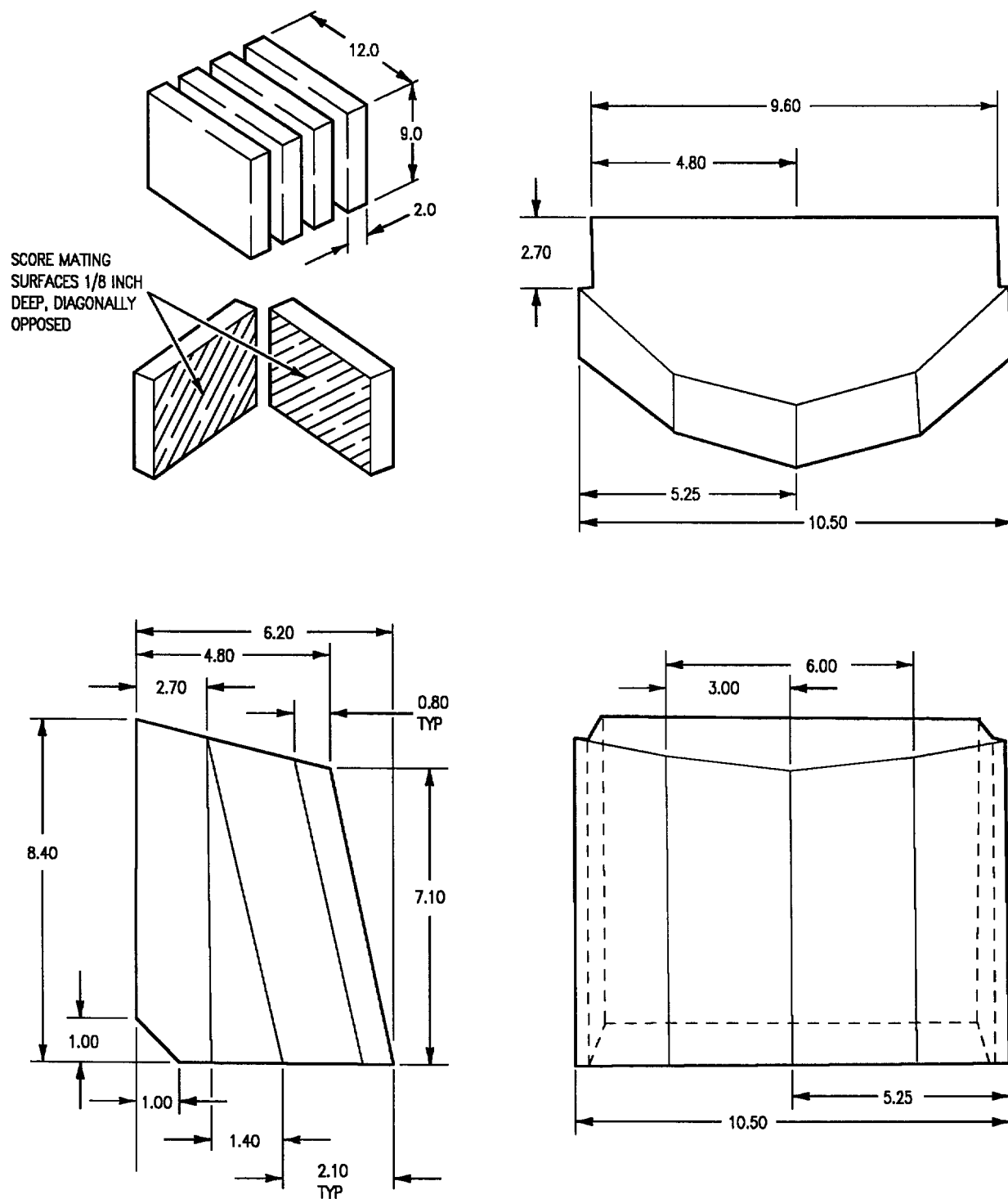
Figure 1. Blocks Fabrication (Sheet 16)



74A582075-2001

18AC-SRM-222-(30-17)01-CAT1

Figure 1. Blocks Fabrication (Sheet 17)



74A582075-2003

18AC-SRM-222-(30-18)01-CATI

Figure 1. Blocks Fabrication (Sheet 18)

INTERMEDIATE MAINTENANCE

STRUCTURE REPAIR

FUEL TANK CAVITY NUMBER 1 FILLER BLOCKS, 74A314857-2001 THRU 74A314857-2088,
FABRICATION

Reference Material

Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Fuel Tank Cavity Number 1 Filler Blocks	WP031 01
Fuel System	A1-F18AC-460-300
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18B	WP017 02

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Record of Applicable Technical Directives

None

Support Equipment Required

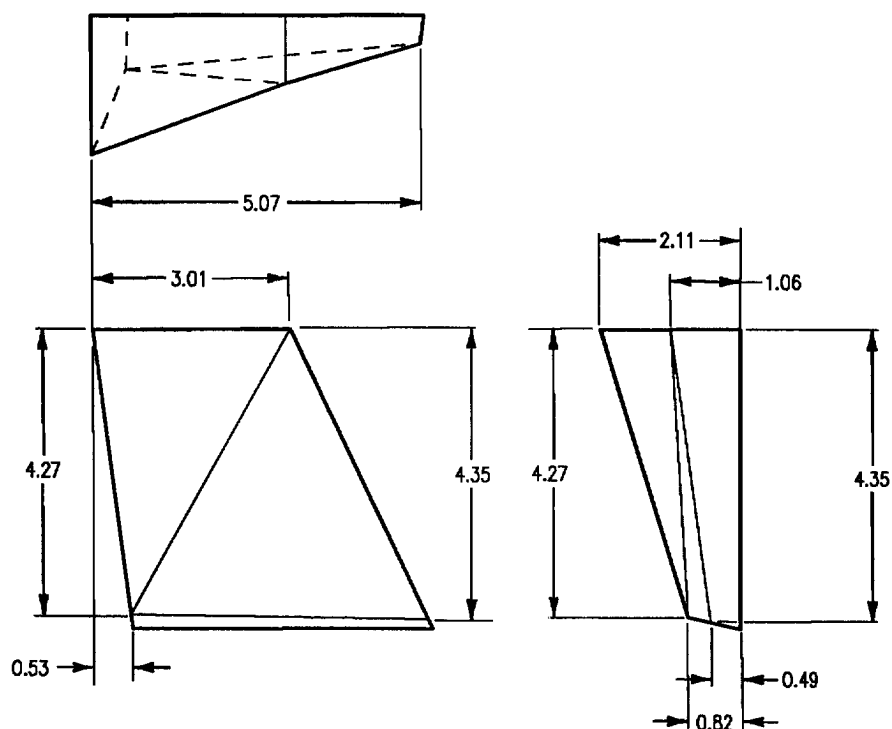
None

Materials Required

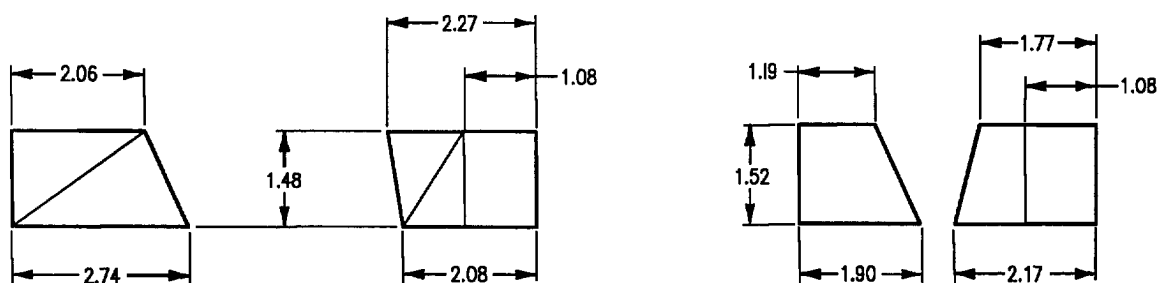
None

1. **FABRICATION.** See figure 1.

2. See figure for block dimensions. For type of material and stock size (WP031 01). For removal and installation of blocks (A1-F18AC-460-300, WP017 02).



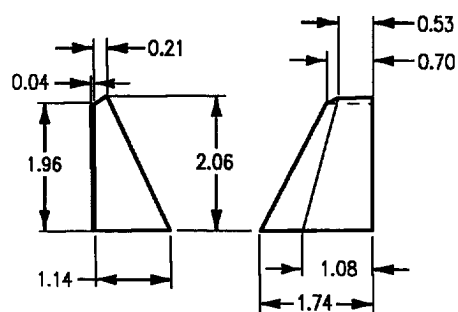
74A314857-2001 LEFT SIDE
74A314857-2002 RIGHT SIDE



74A314857-2003 LEFT SIDE
74A314857-2004 RIGHT SIDE

74A314857-2005 LEFT SIDE
74A314857-2006 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 1)

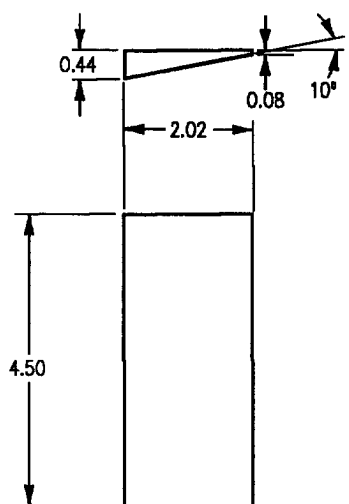


74A314857-2007

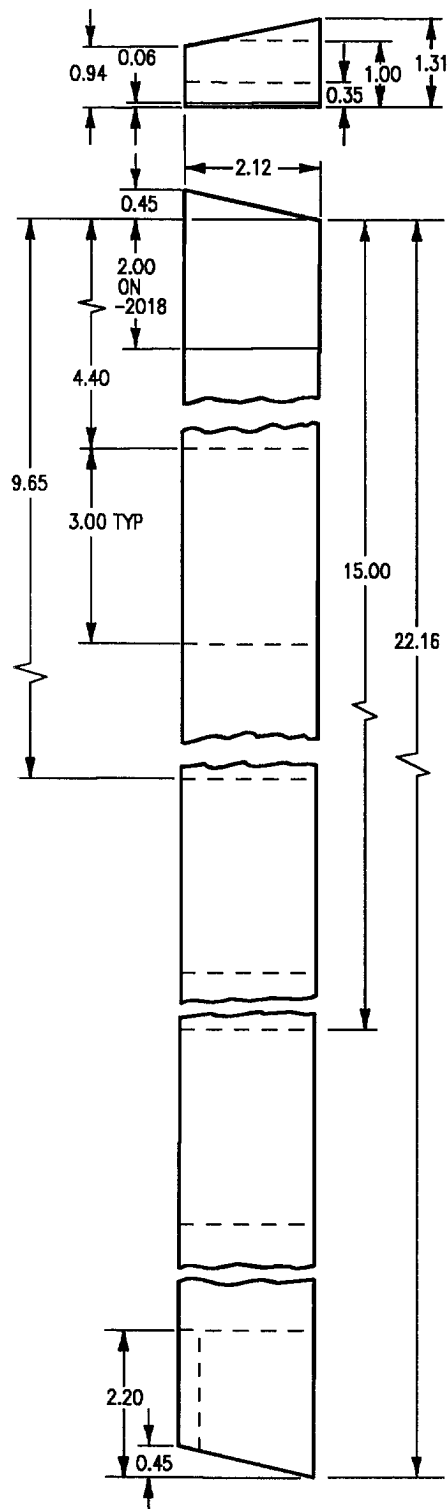
LEFT SIDE

74A314857-2008

RIGHT SIDE



74A314857-2025



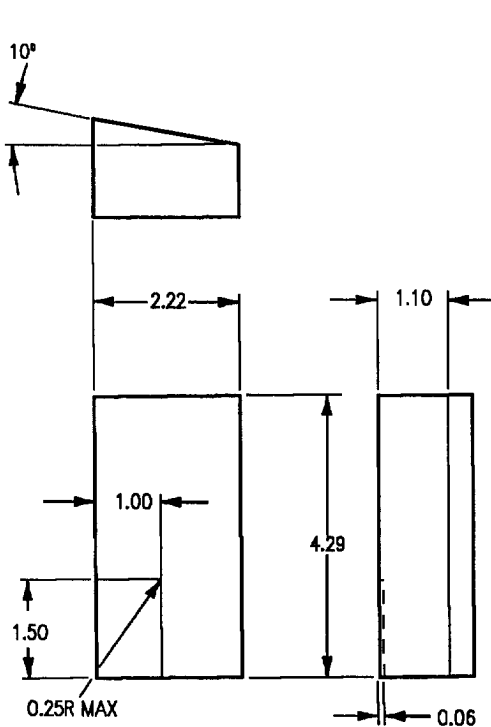
74A314857-2017

LEFT SIDE

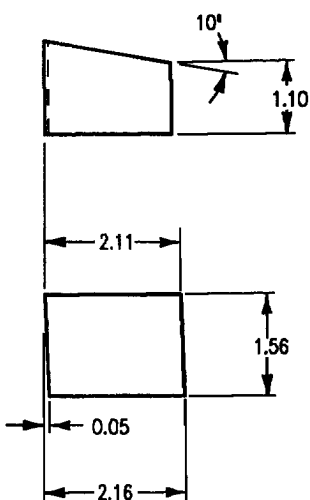
74A314857-2018

RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 2)



74A314857-2027

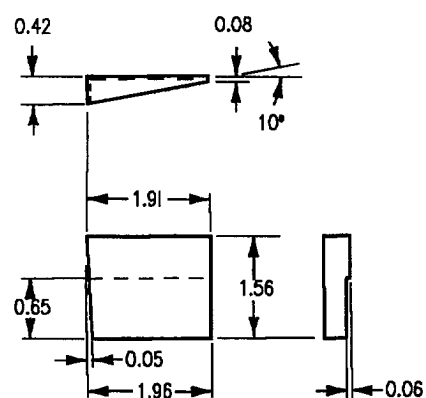


74A314857-2031

74A314857-2032

LEFT SIDE

RIGHT SIDE

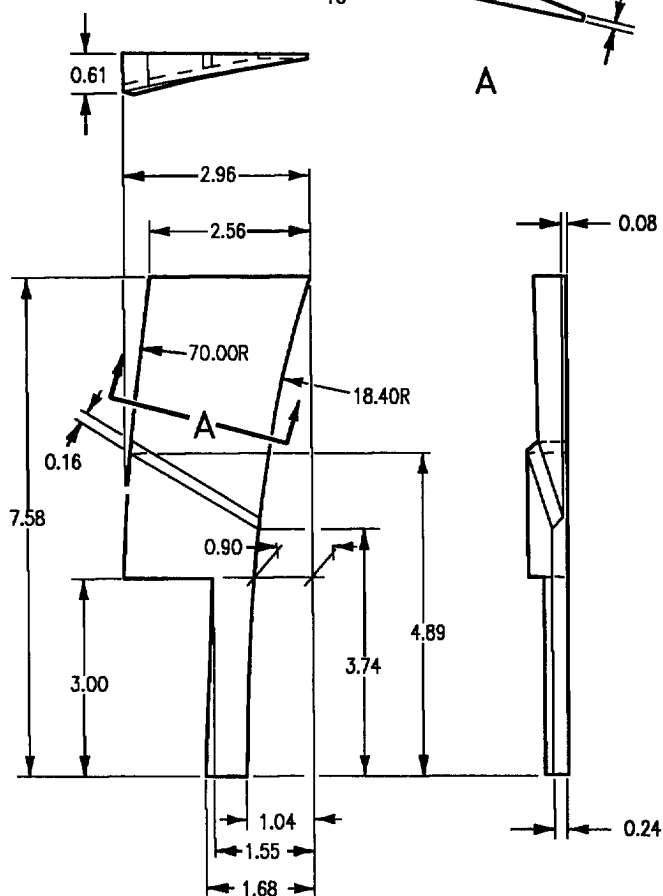
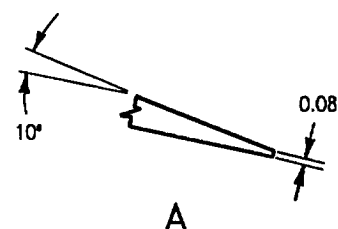


74A314857-2029

LEFT SIDE

74A314857-2029

RIGHT SIDE



74A314857-2037

Figure 1. Blocks Fabrication (Sheet 3)

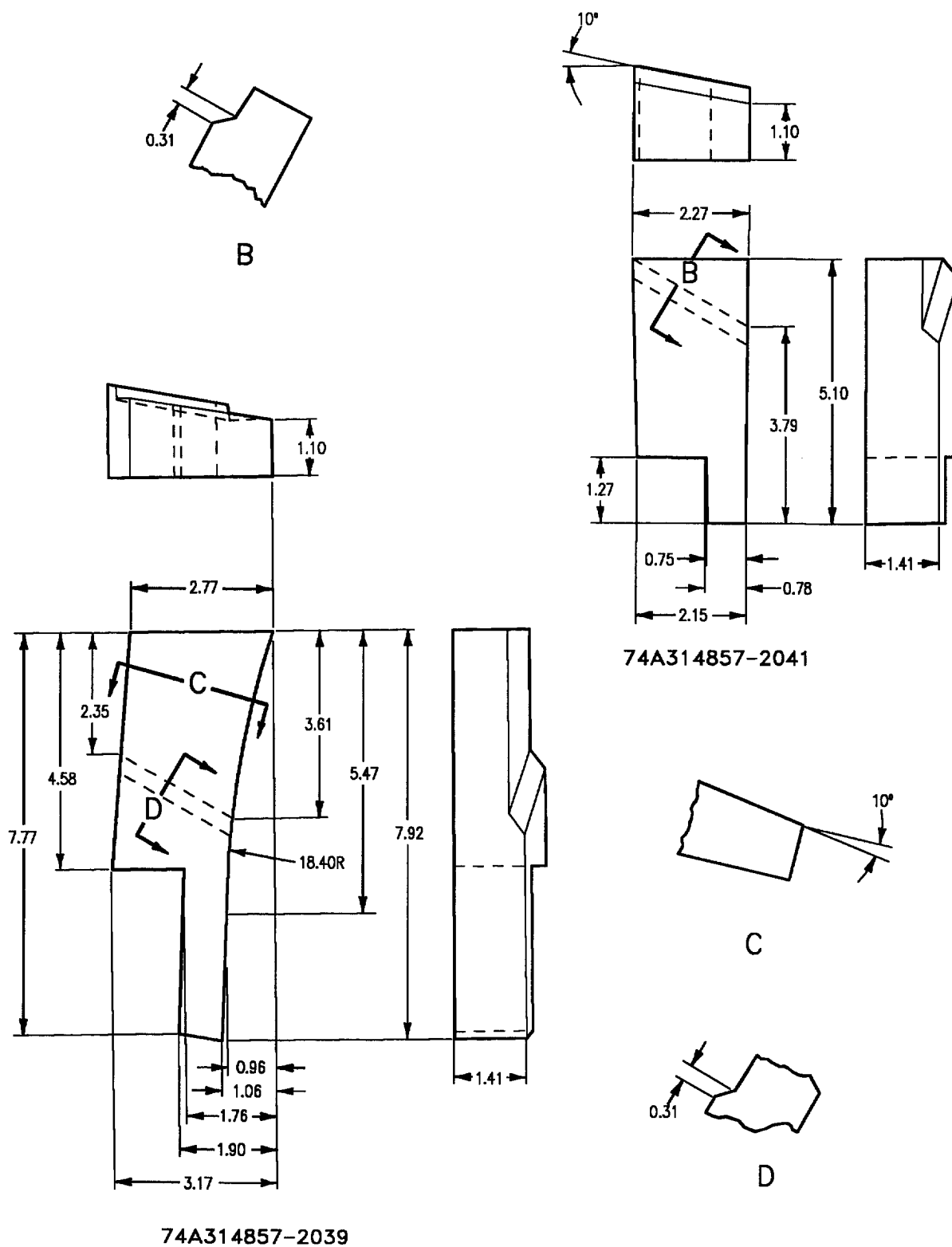


Figure 1. Blocks Fabrication (Sheet 4)

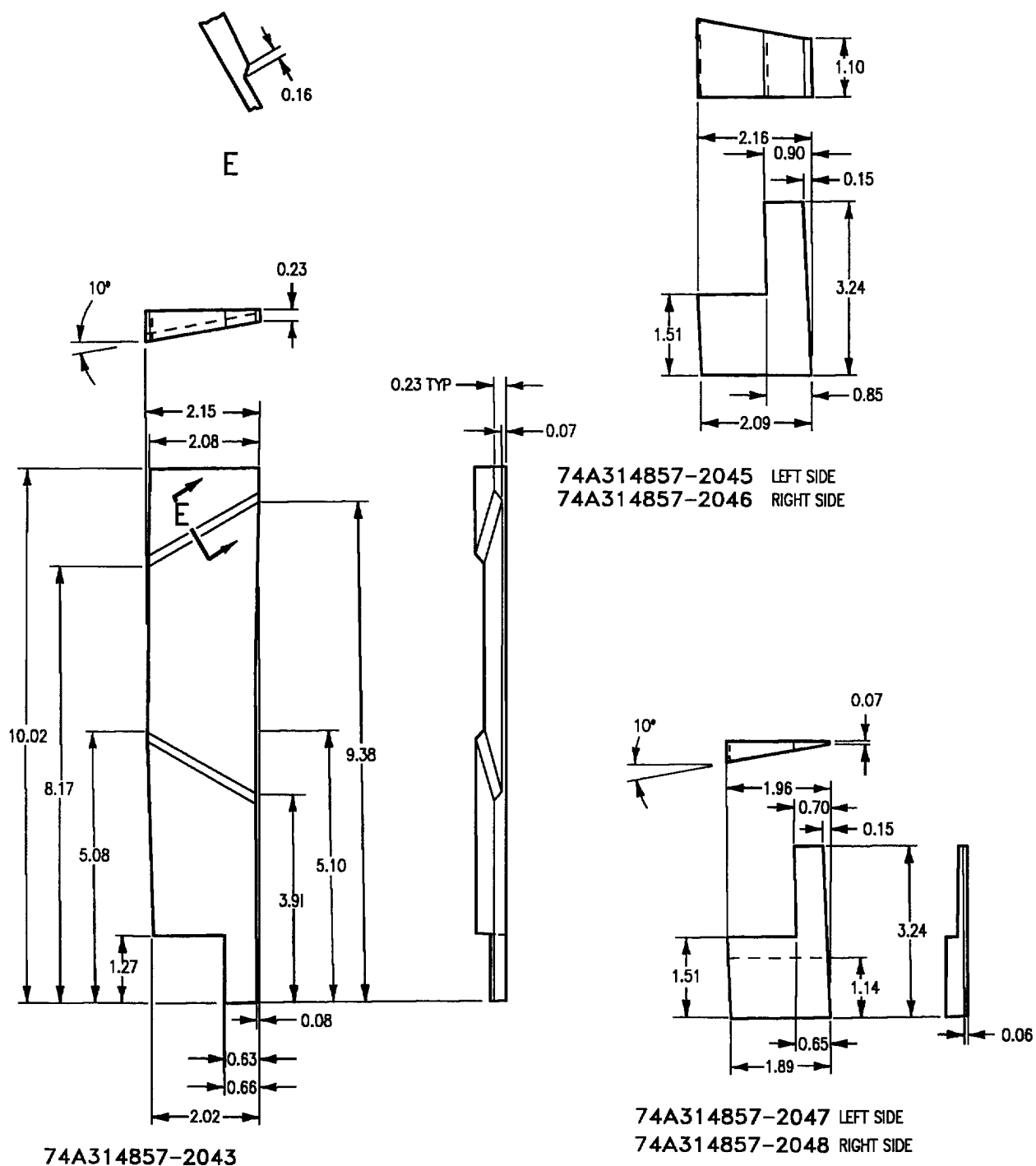
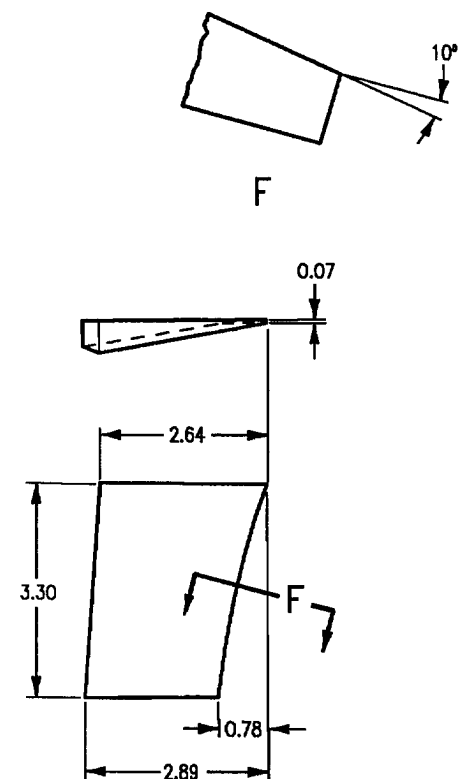
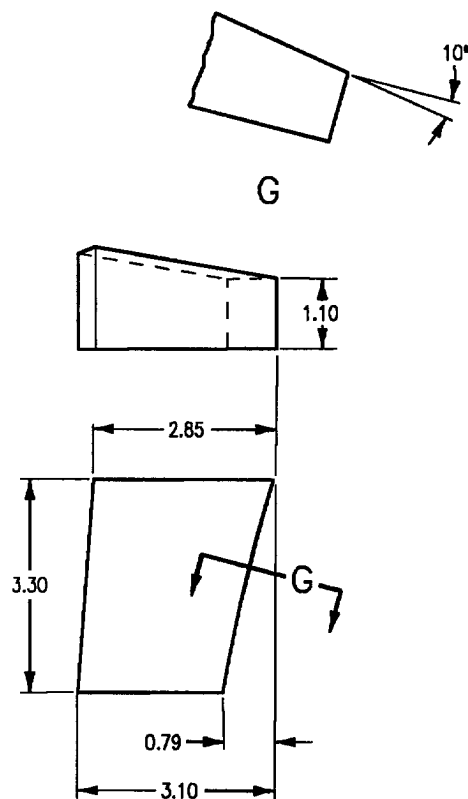


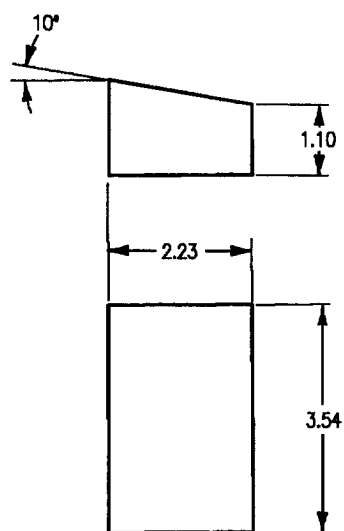
Figure 1. Blocks Fabrication (Sheet 5)



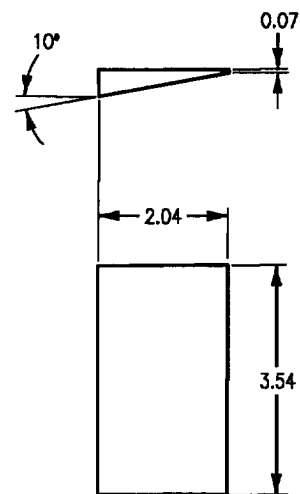
74A314857-2053 LEFT SIDE
74A314857-2054 RIGHT SIDE



74A314857-2055 LEFT SIDE
74A314857-2056 RIGHT SIDE



74A314857-2059



74A314857-2057

Figure 1. Blocks Fabrication (Sheet 6)

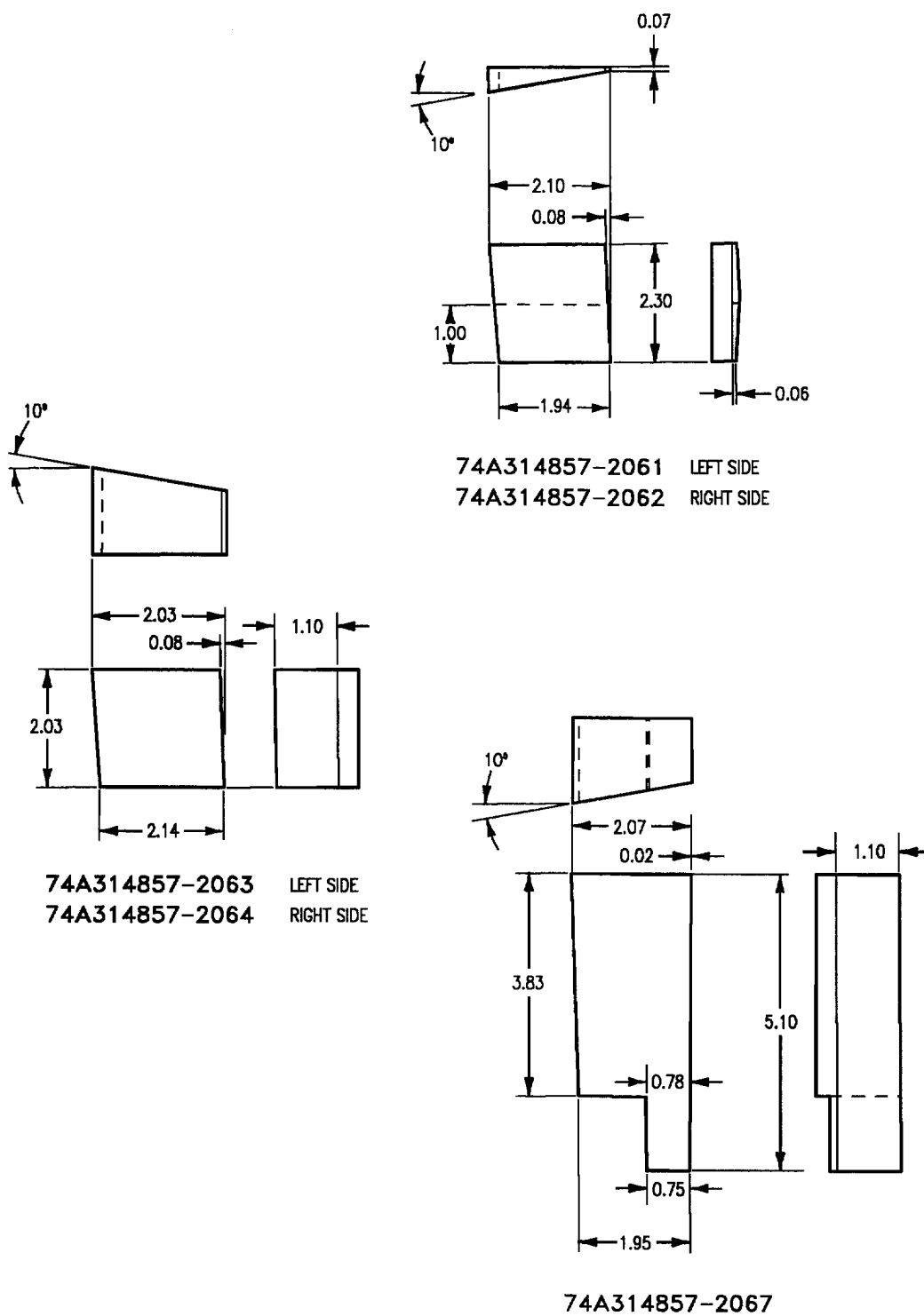


Figure 1. Blocks Fabrication (Sheet 7)

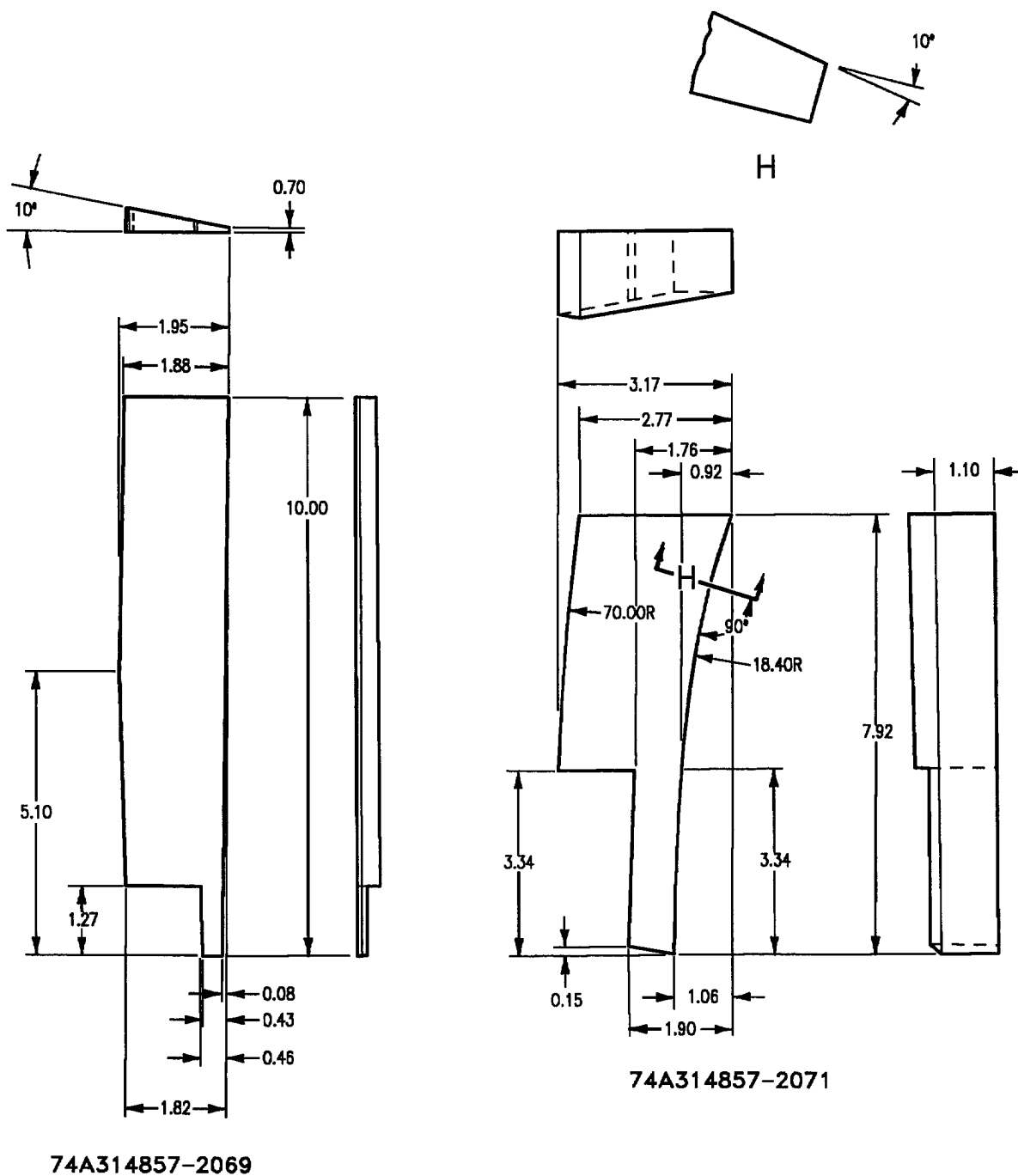
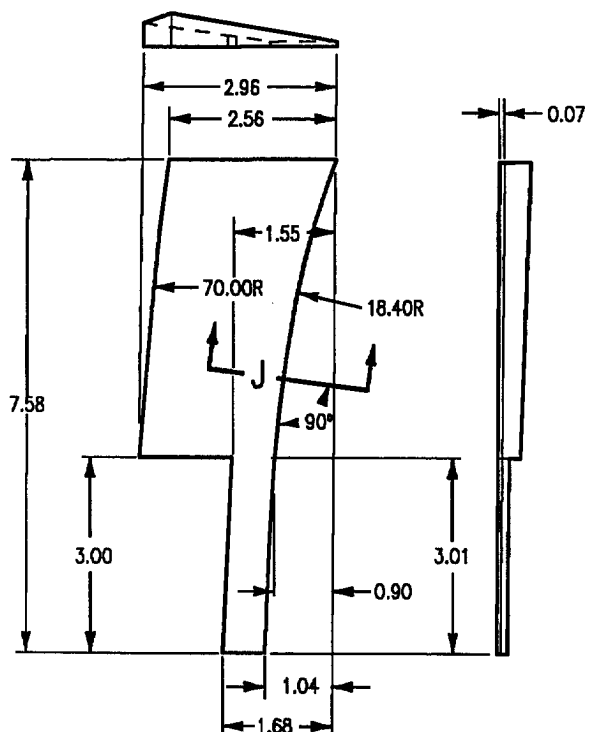
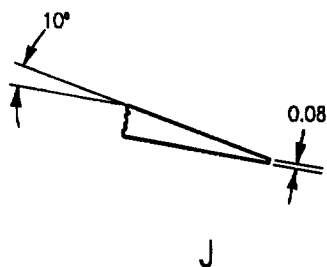


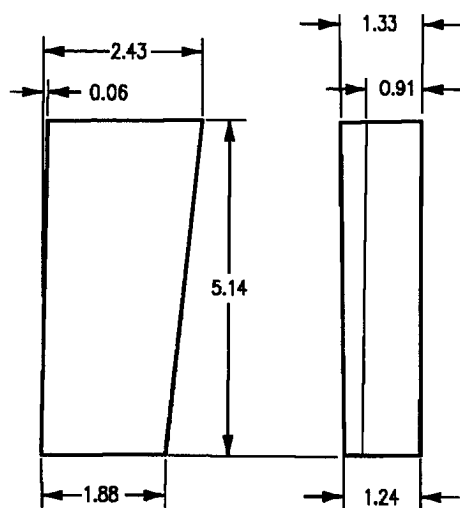
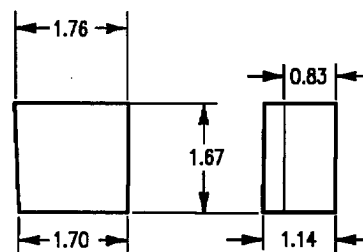
Figure 1. Blocks Fabrication (Sheet 8)



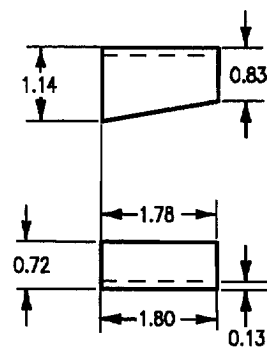
74A314857-2073



74A314857-2075 LEFT SIDE
74A314857-2076 RIGHT SIDE

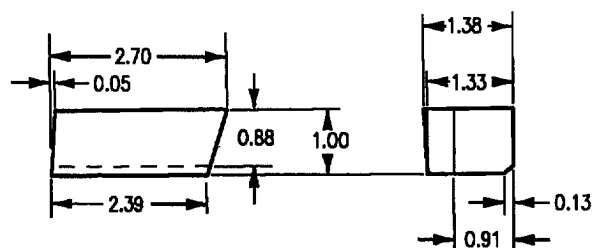


74A314857-2079 LEFT SIDE
74A314857-2080 RIGHT SIDE

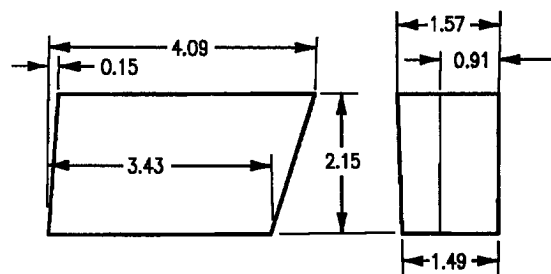


74A314857-2077

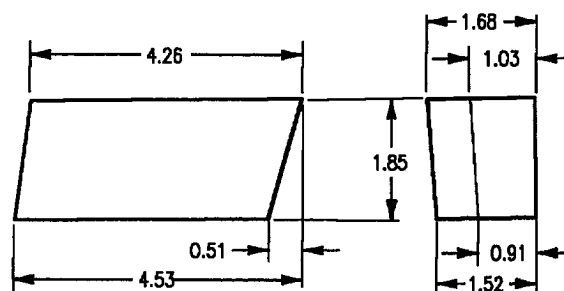
Figure 1. Blocks Fabrication (Sheet 9)



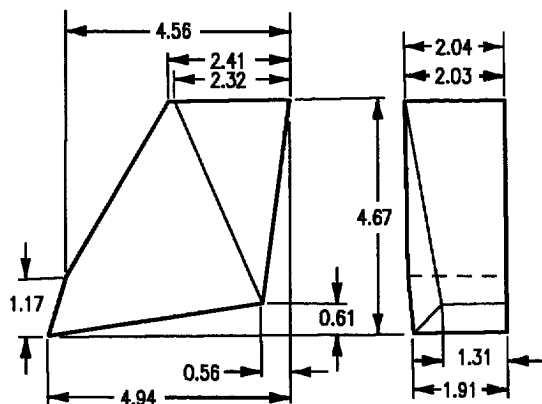
74A314857-2081 LEFT SIDE
74A314857-2082 RIGHT SIDE



74A314857-2083 LEFT SIDE
74A314857-2084 RIGHT SIDE



74A314857-2085 LEFT SIDE
74A314857-2086 RIGHT SIDE



74A314857-2087 LEFT SIDE
74A314857-2088 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 10)

INTERMEDIATE MAINTENANCE

STRUCTURE REPAIR

FUEL TANK CAVITY NUMBER 1 FILLER BLOCKS, 74A314857-2089 THRU 74A314857-2203,
FABRICATION

Reference Material

Structure Repair, Forward Fuselage A1-F18AC-SRM-220
Fuel Tank Cavity Number 1 Filler Blocks WP031 01
Fuel System A1-F18AC-460-300
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18B WP017 02

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Record of Applicable Technical Directives

None

Support Equipment Required

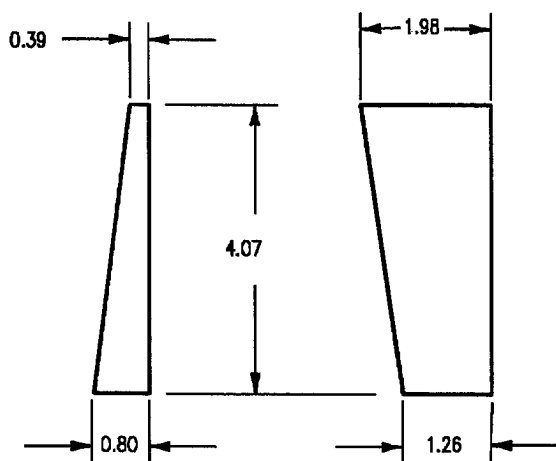
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Materials Required

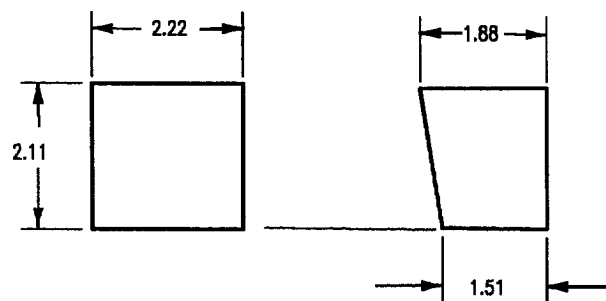
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1. **FABRICATION.** See figure 1.

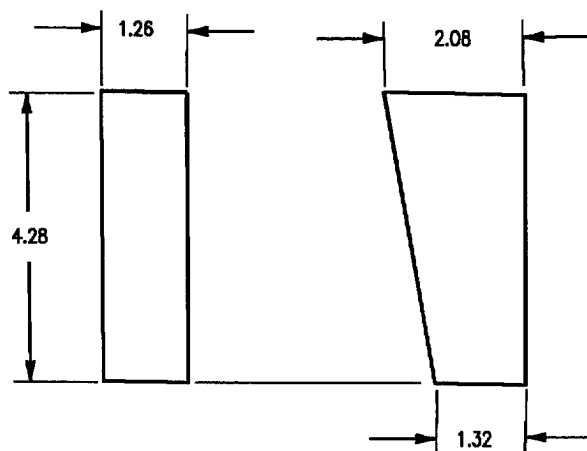
2. See figure for block dimensions. For type of material and stock size (WP031 01). For removal and installation of blocks (A1-F18AC-460-300, WP017 02).



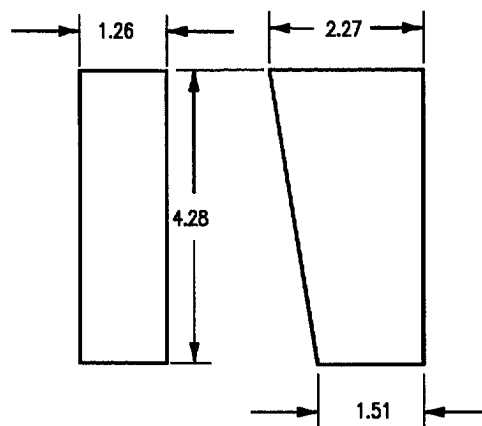
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74A314857-2090 RIGHT SIDE



74A314857-2091

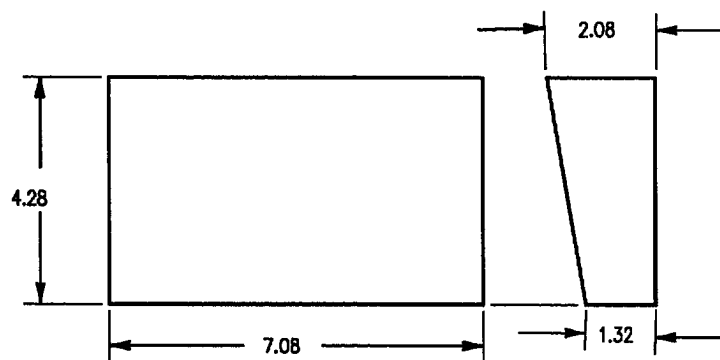


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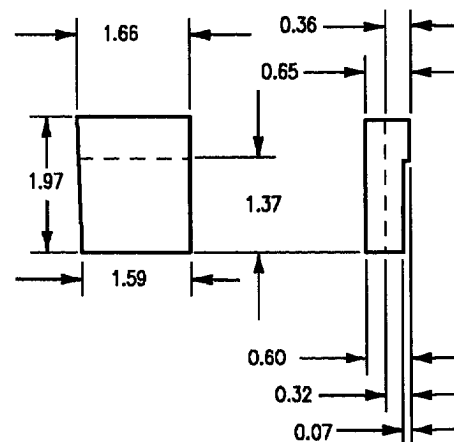


74A314857-2093

Figure 1. Blocks Fabrication (Sheet 1)

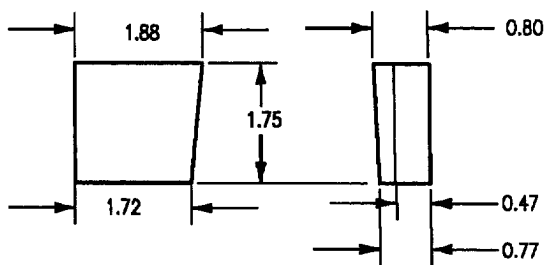


74A314857-2097



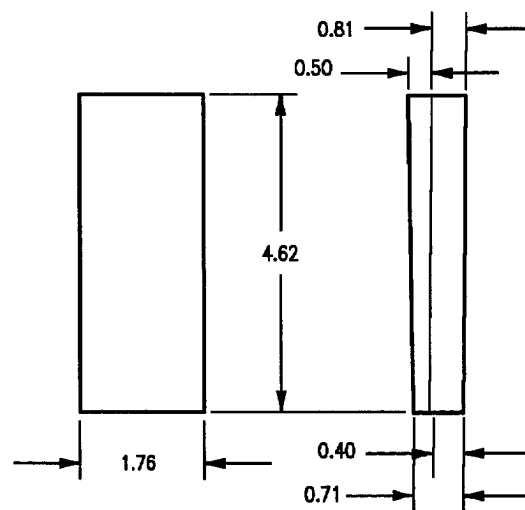
74A314857-2099 LEFT SIDE

74A314857-2100 RIGHT SIDE



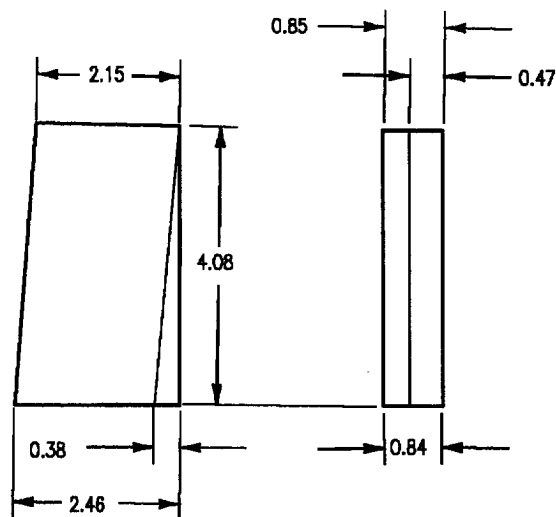
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74A314857-2104 RIGHT SIDE

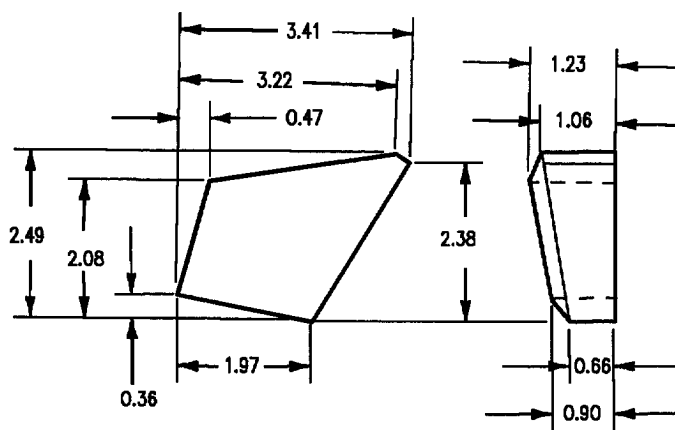


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Figure 1. Blocks Fabrication (Sheet 2)

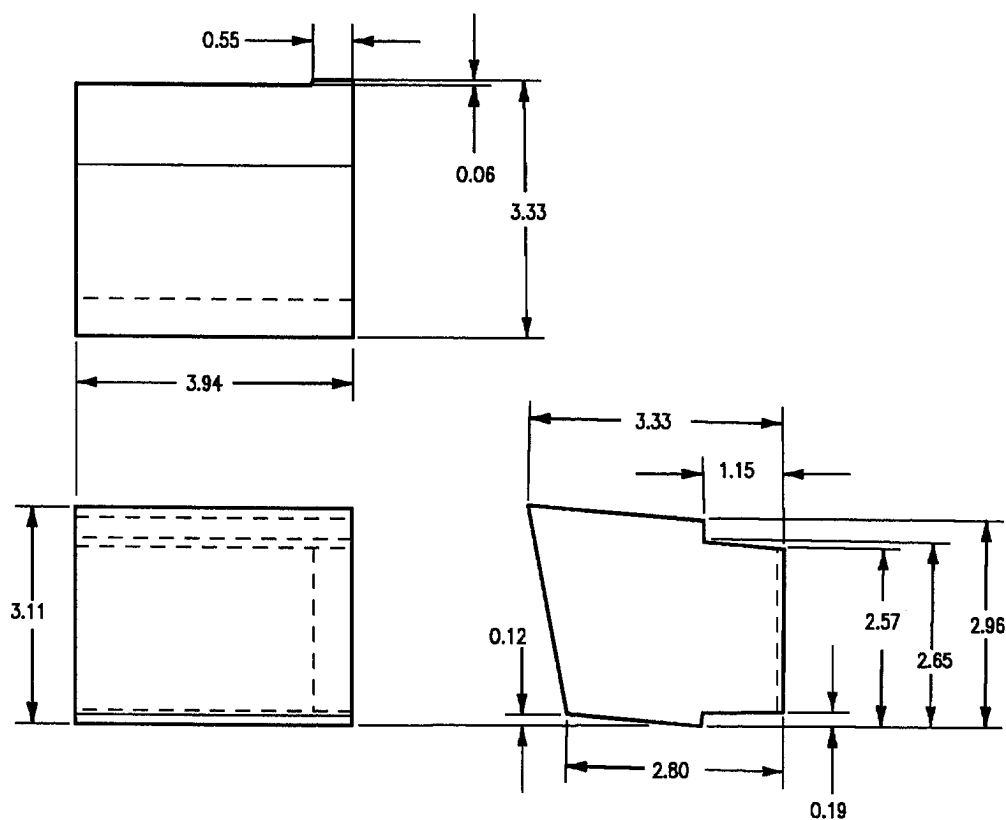


74A314857-2105 LEFT SIDE
74A314857-2106 RIGHT SIDE

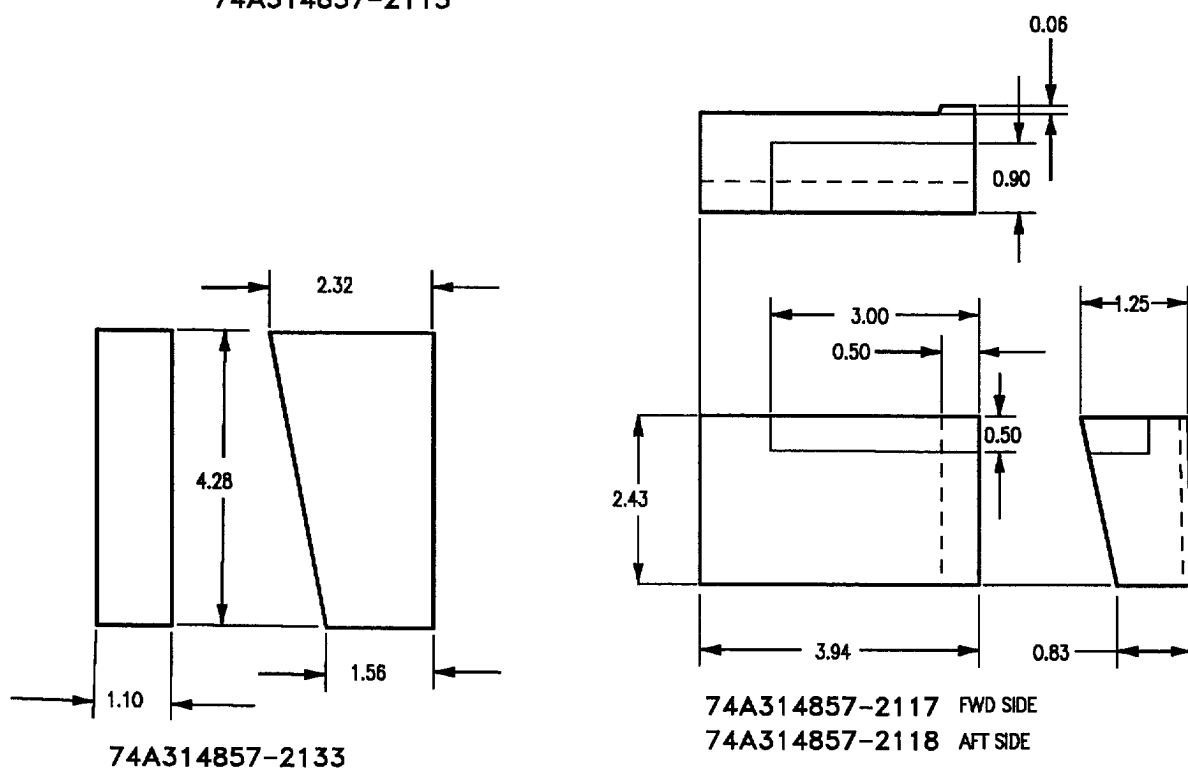


74A314857-2107 LEFT SIDE
74A314857-2108 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 3)



74A314857-2115

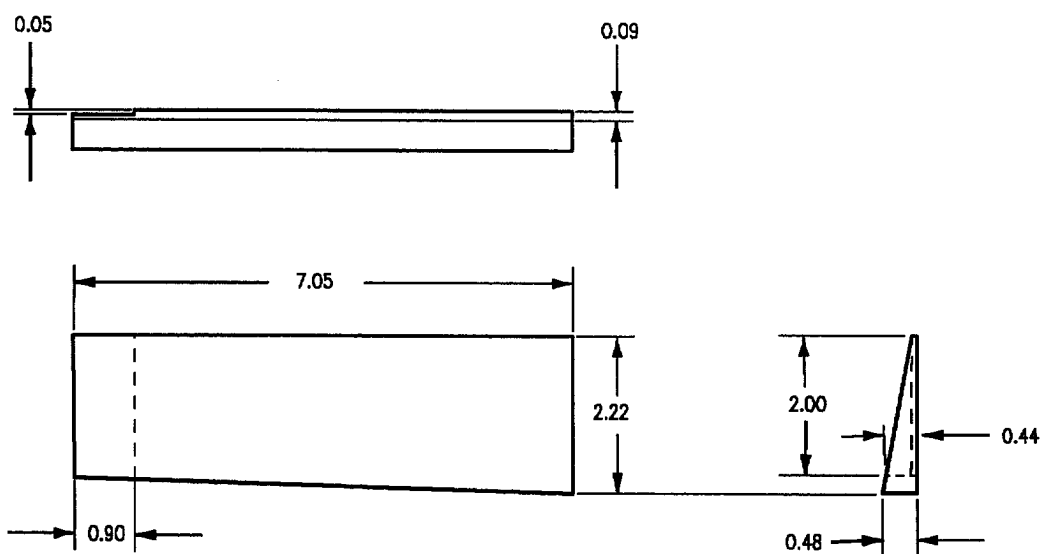


74A314857-2117 FWD SIDE

74A314857-2118 AFT SIDE

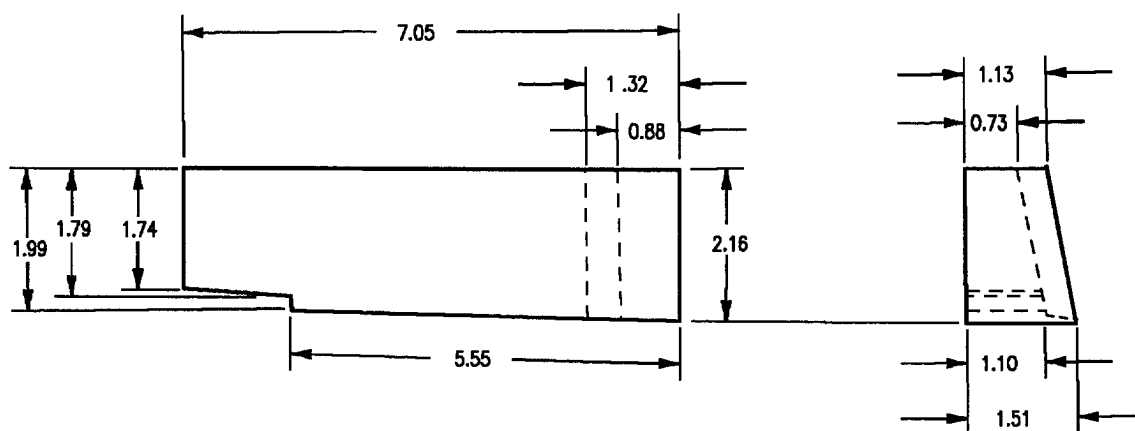
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Figure 1. Blocks Fabrication (Sheet 4)



74A314857-2135 LEFT SIDE

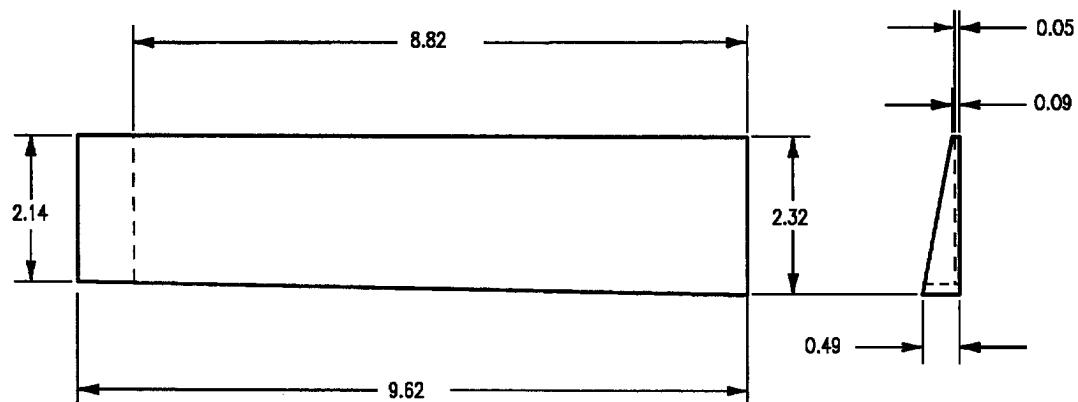
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74A314857-2137 LEFT SIDE

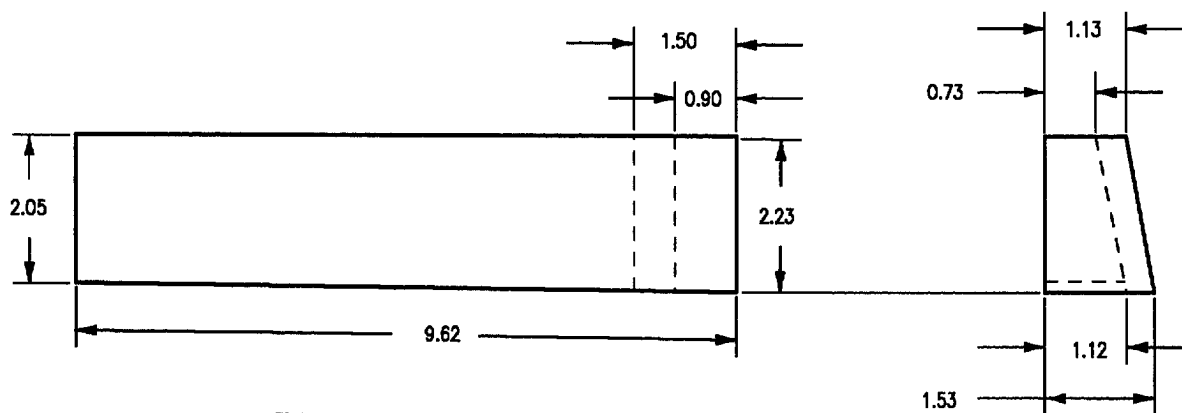
74A314857-2138 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 5)



74A314857-2139 LEFT SIDE

74A314857-2140 RIGHT SIDE



74A314857-2141 LEFT SIDE

74A314857-2142 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 6)

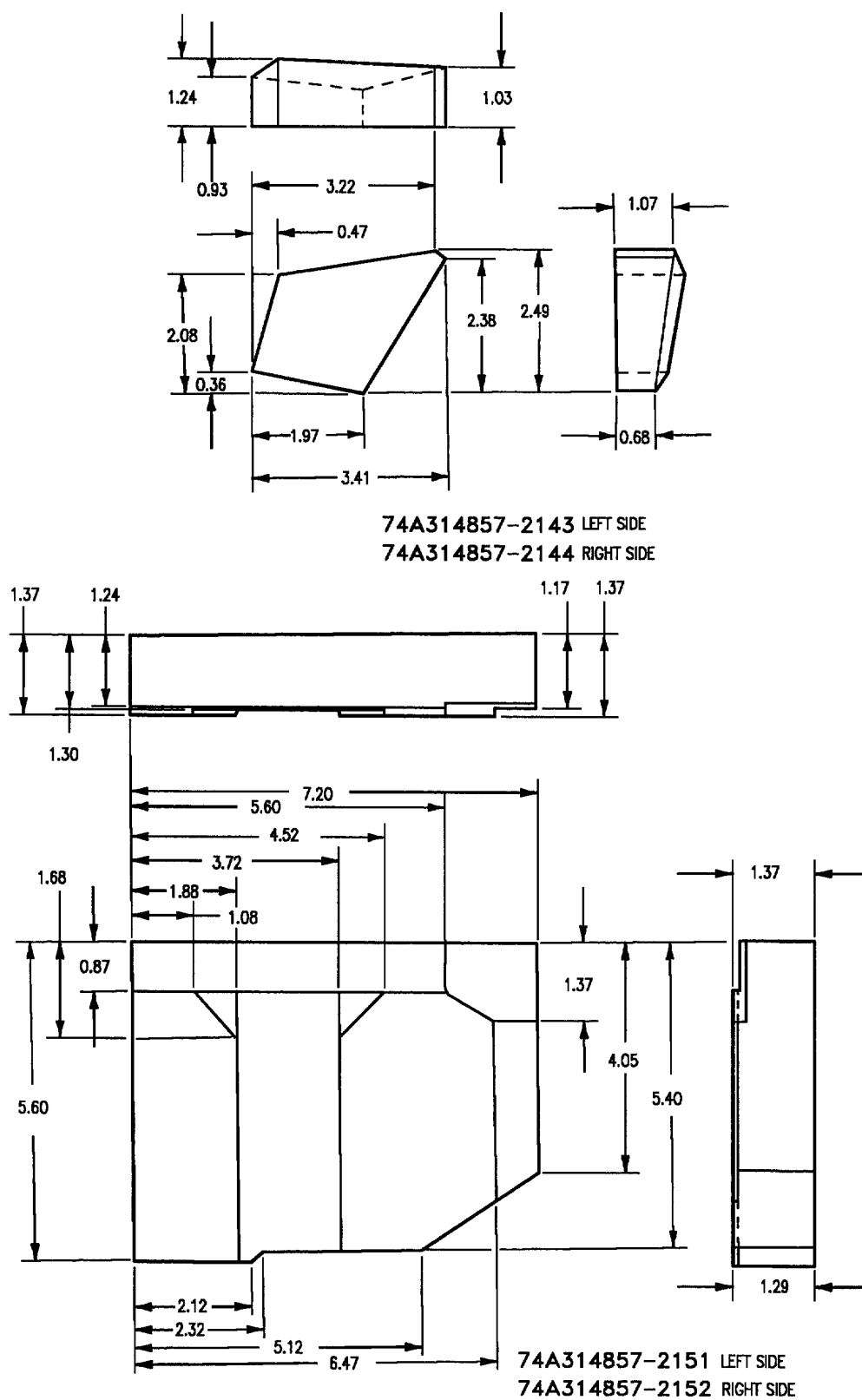
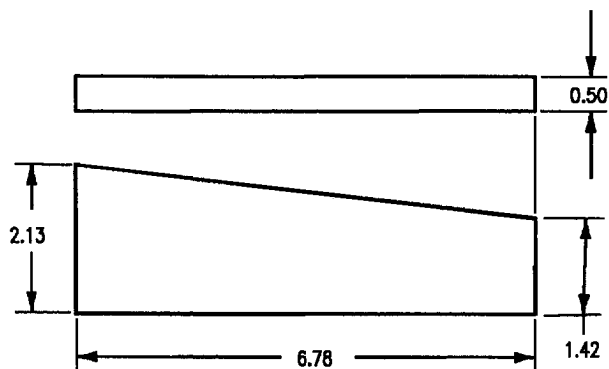
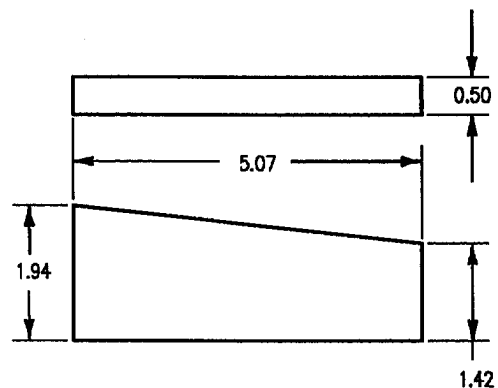


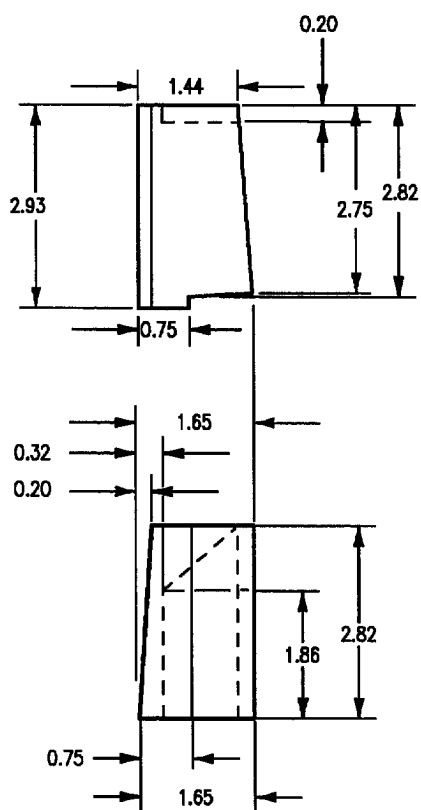
Figure 1. Blocks Fabrication (Sheet 7)



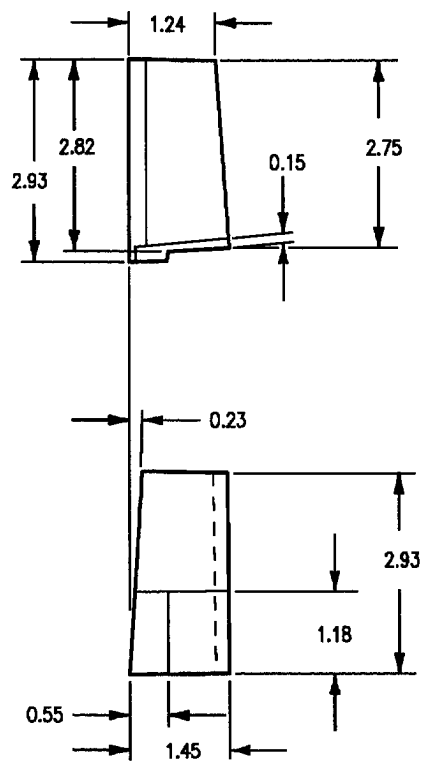
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74A314857-2155



74A314857-2159



74A314857-2157

Figure 1. Blocks Fabrication (Sheet 8)

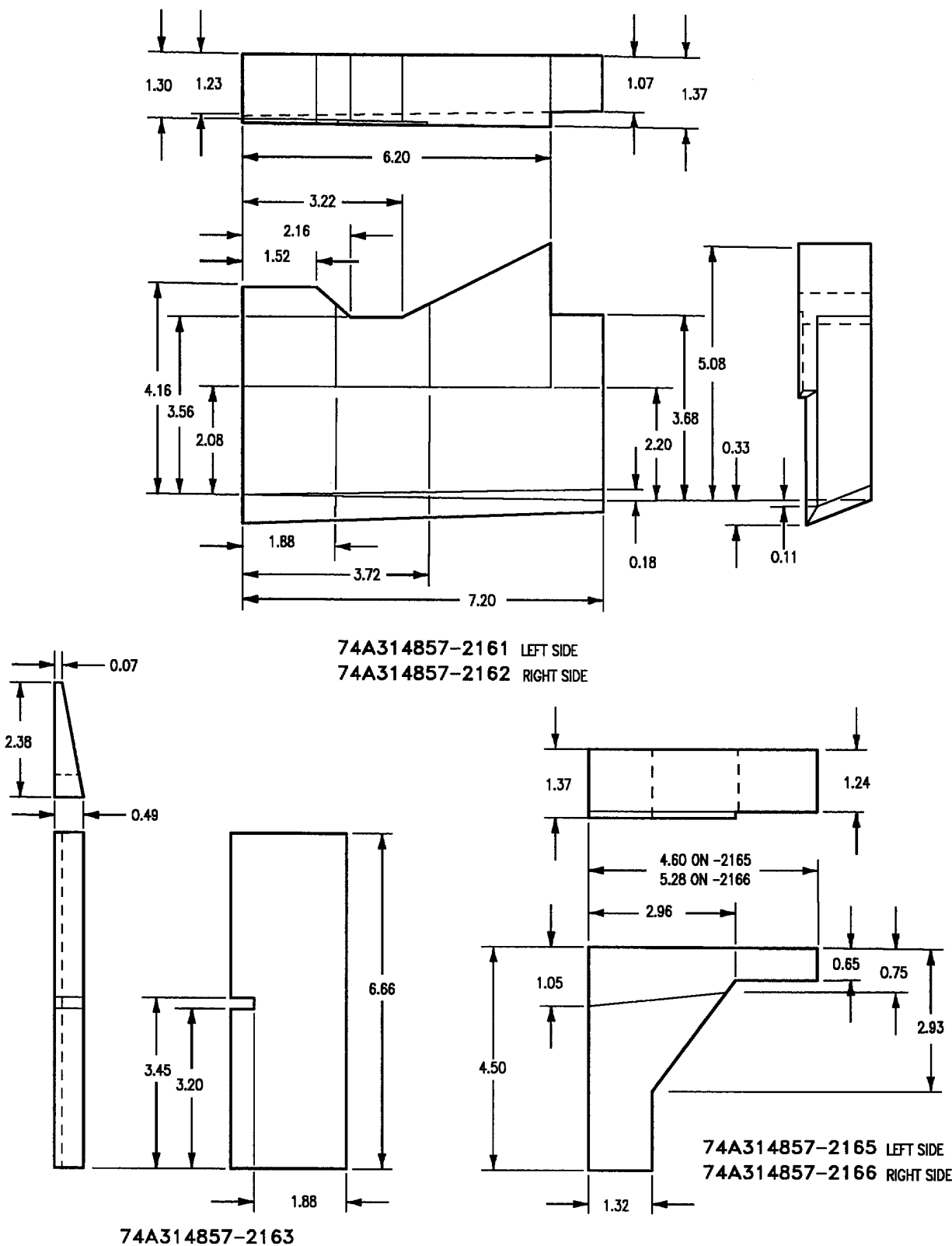
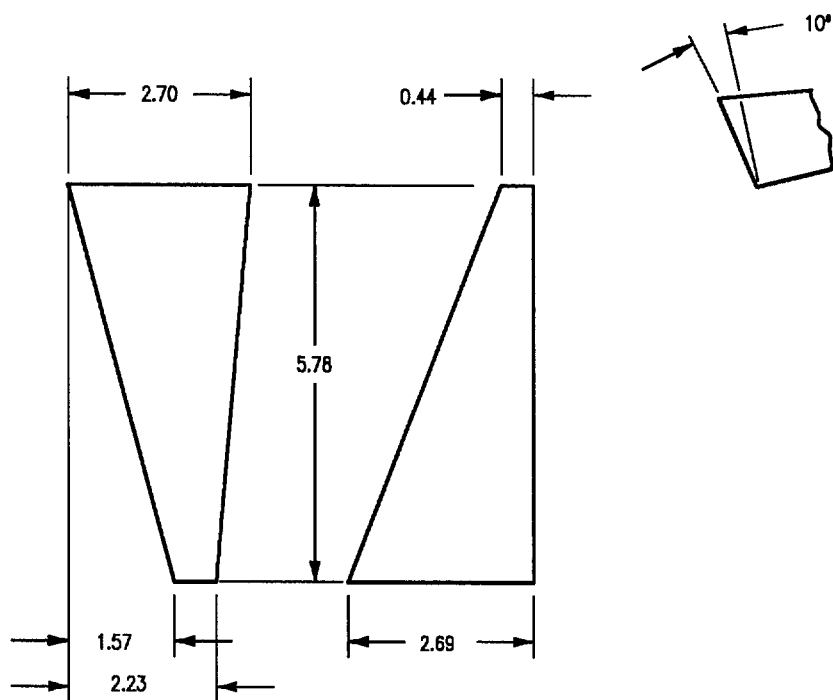
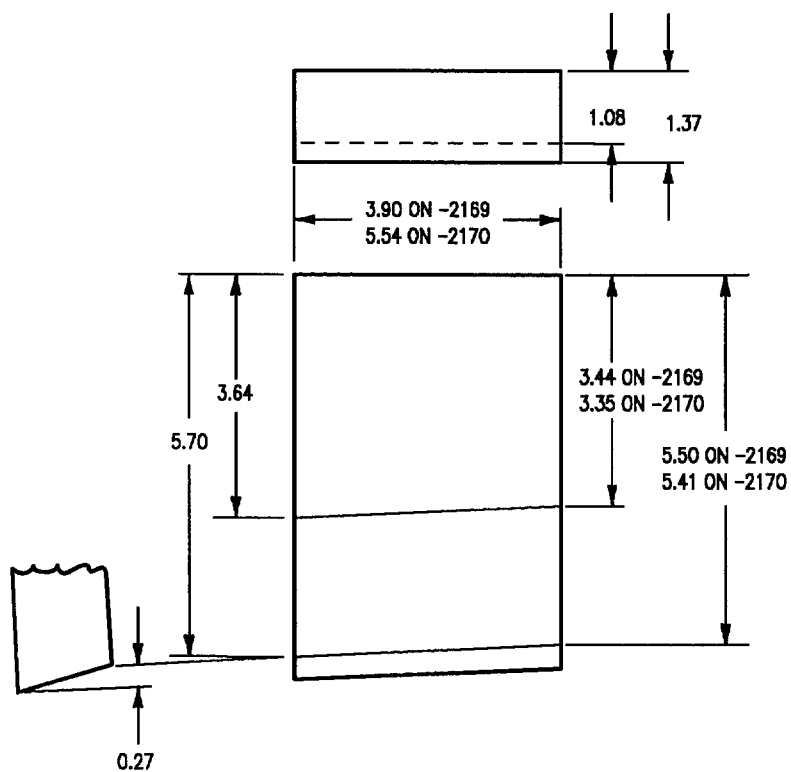


Figure 1. Blocks Fabrication (Sheet 9)



74A314857-2167



74A314857-2169 LEFT SIDE

74A314857-2170 RIGHT SIDE

18AC-SRM-222-(32-10)01-CATI

Figure 1. Blocks Fabrication (Sheet 10)

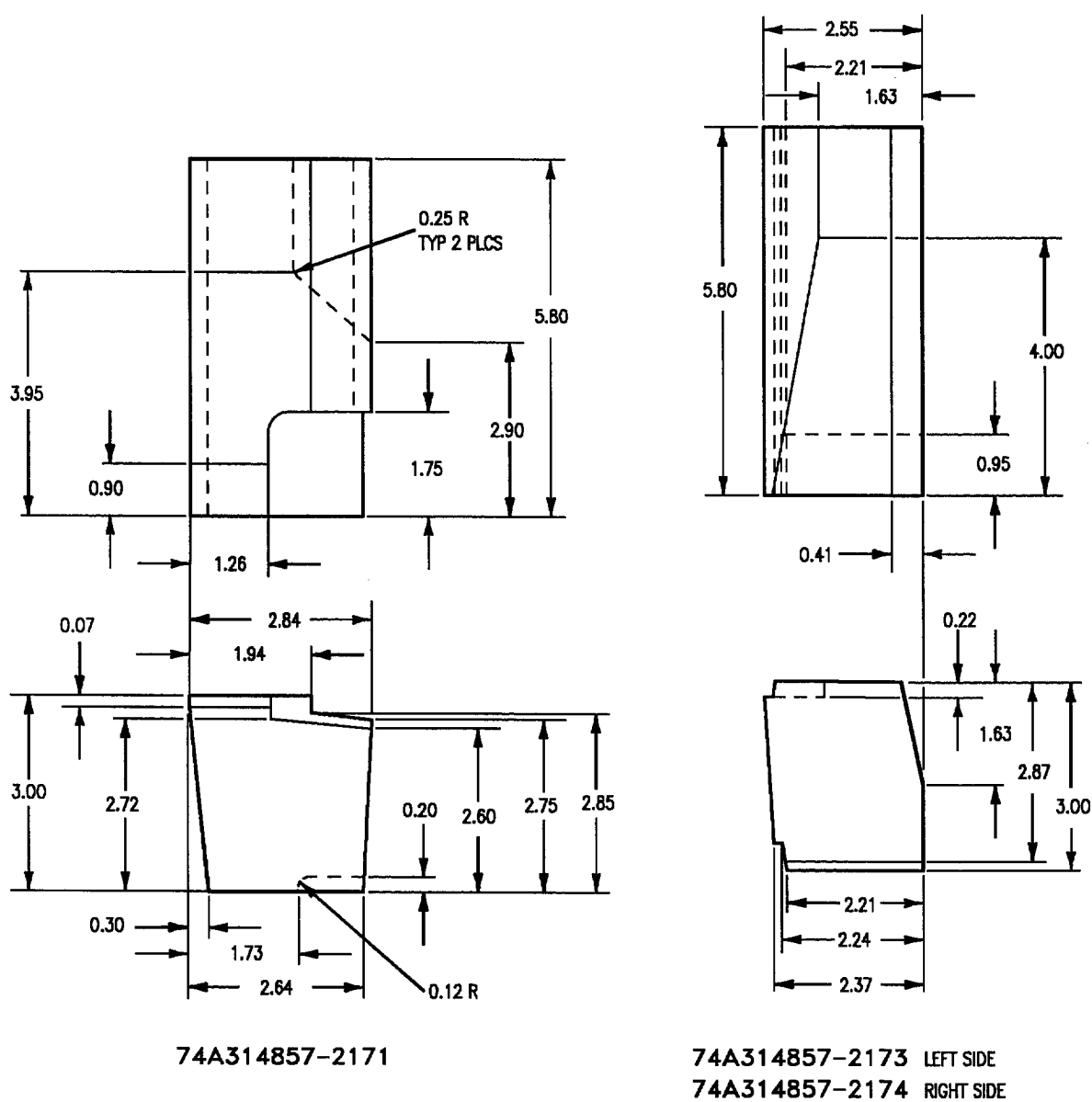


Figure 1. Blocks Fabrication (Sheet 11)

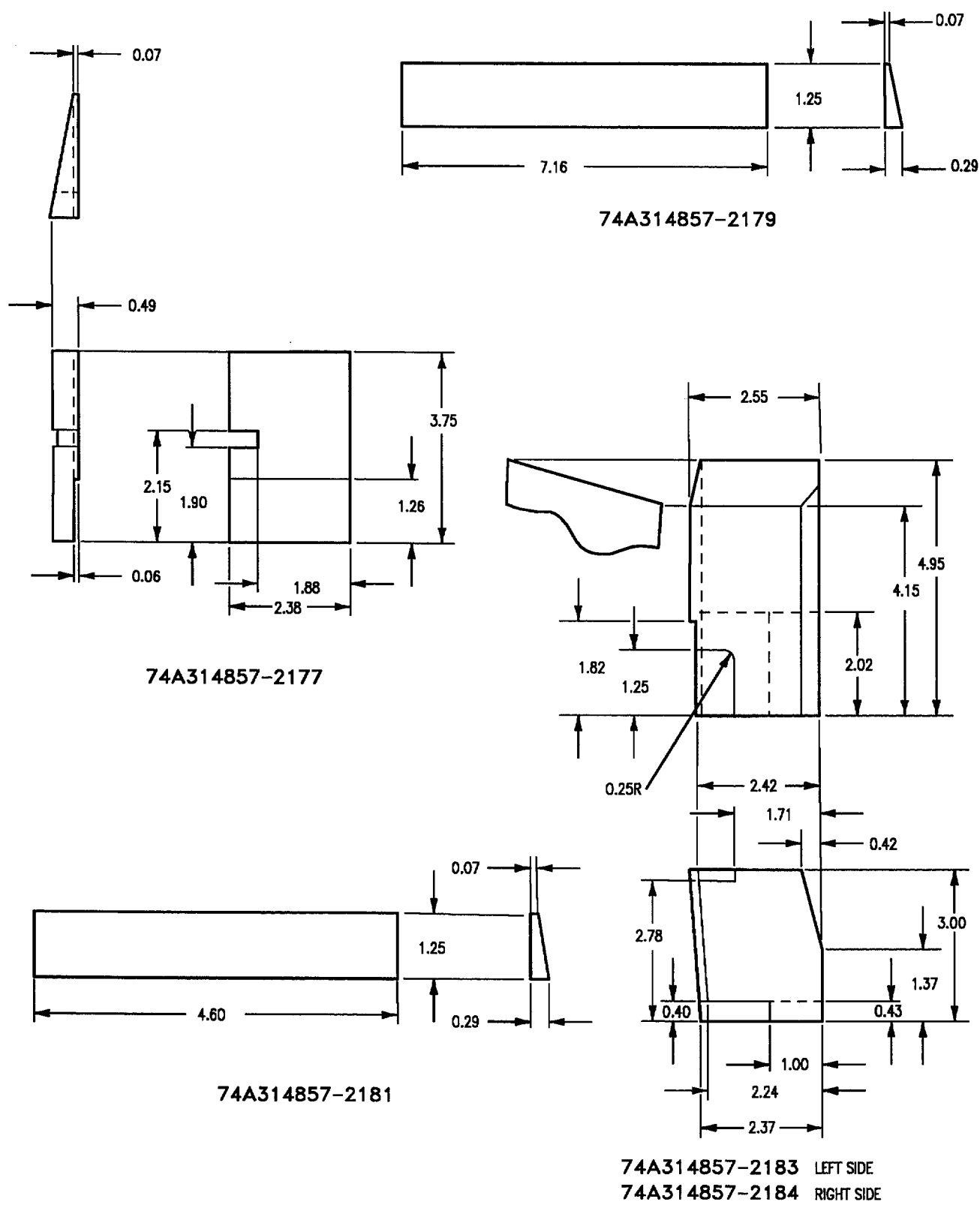


Figure 1. Blocks Fabrication (Sheet 12)

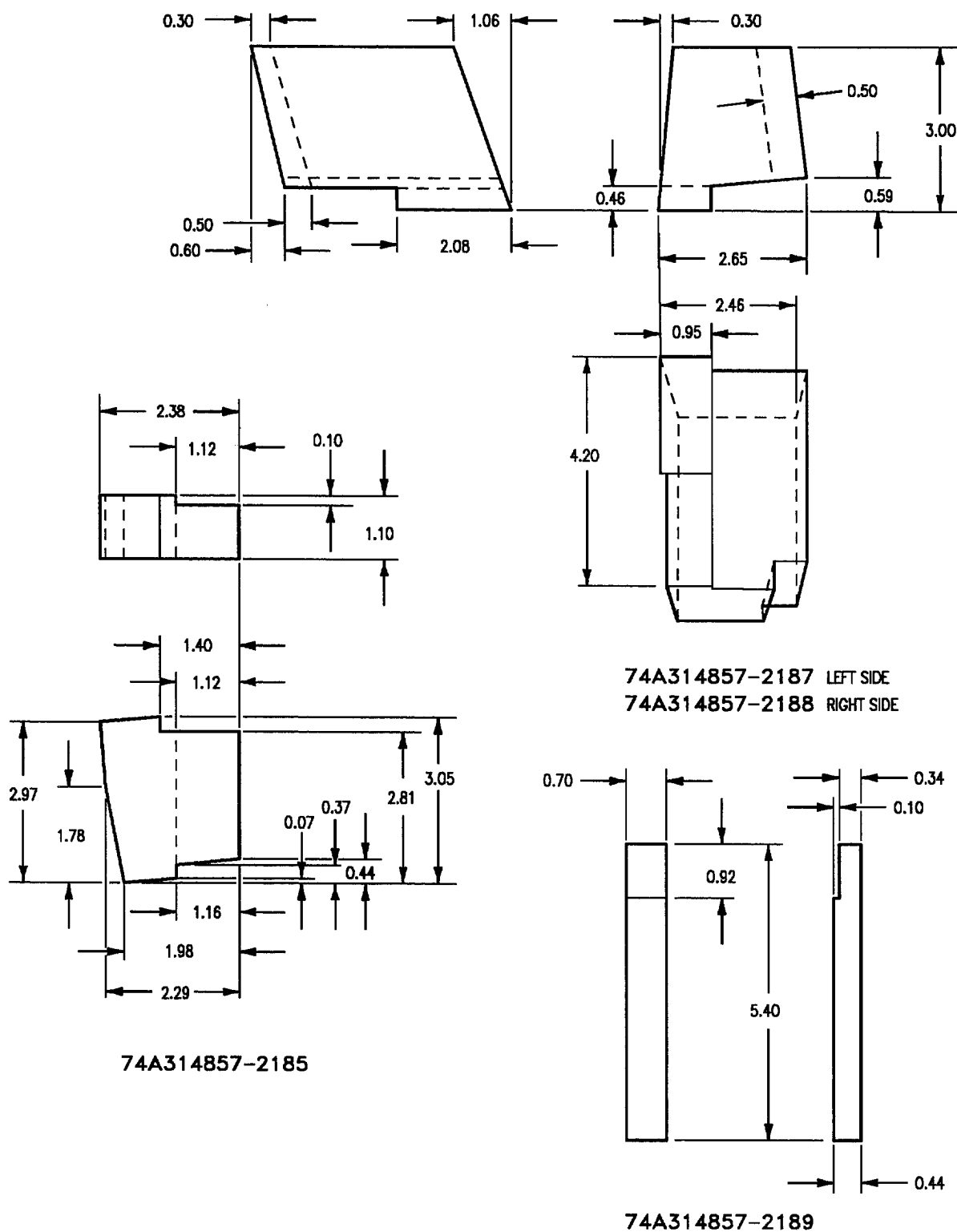
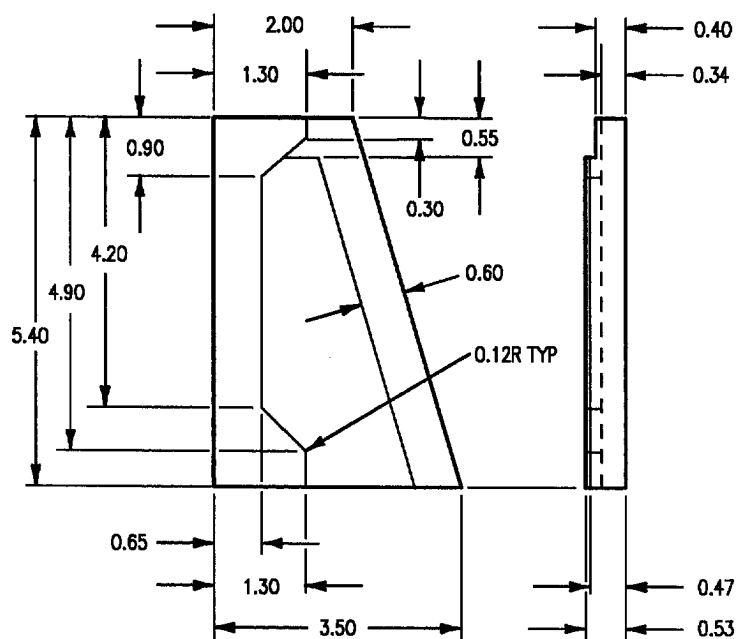
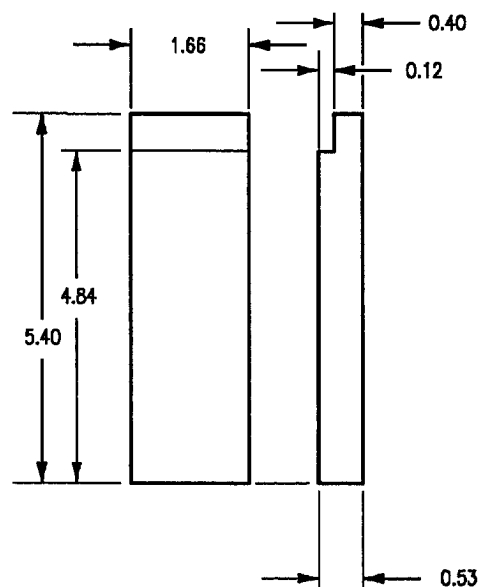


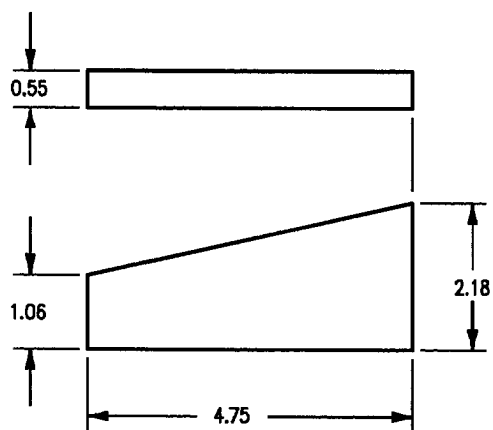
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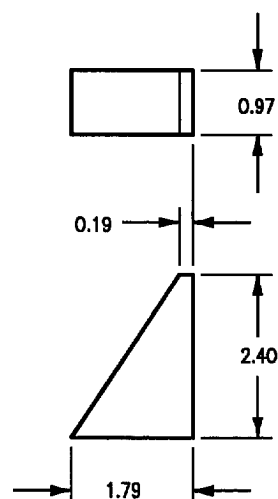
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74A314857-2193

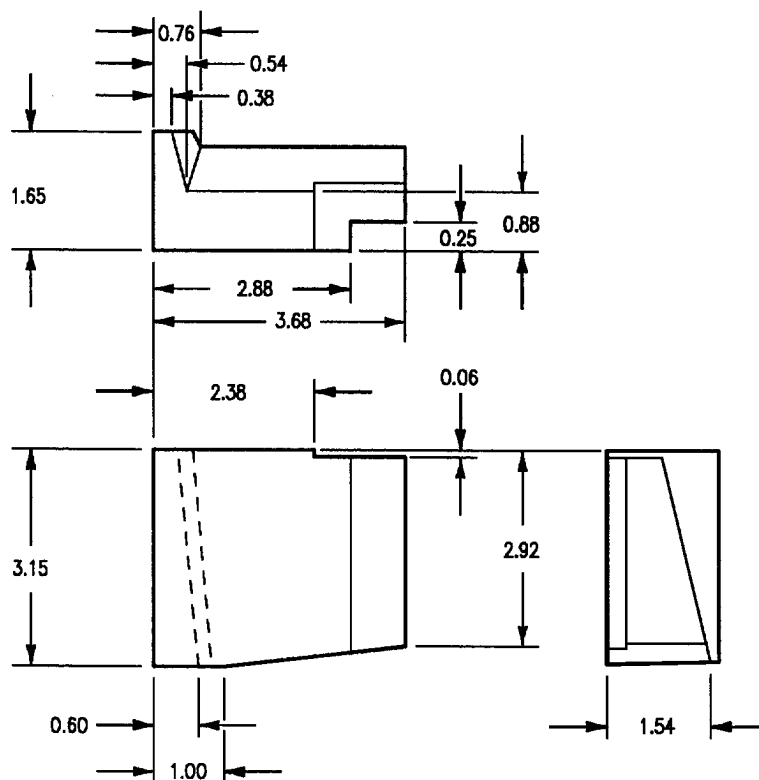


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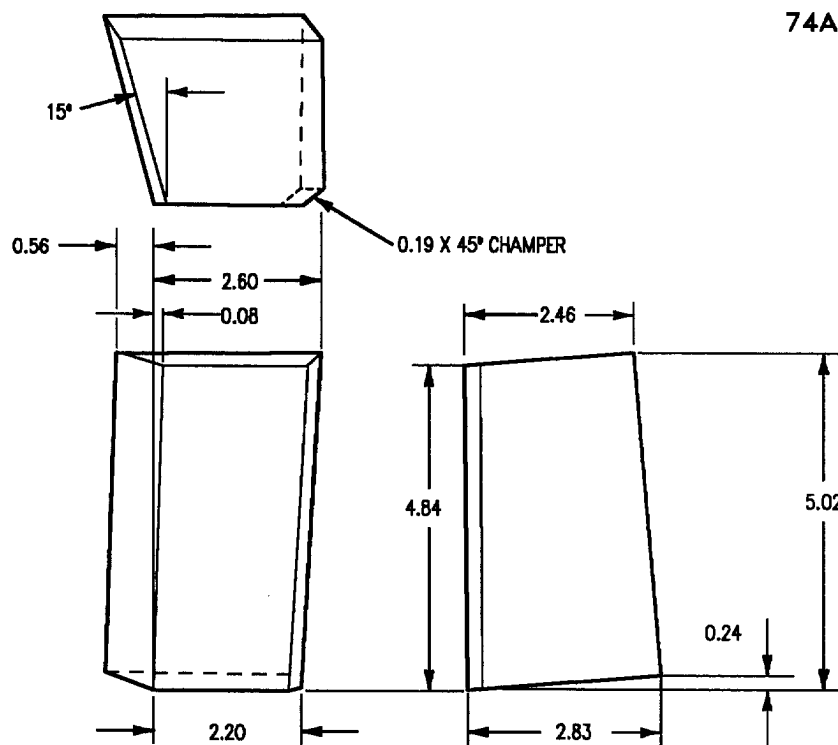


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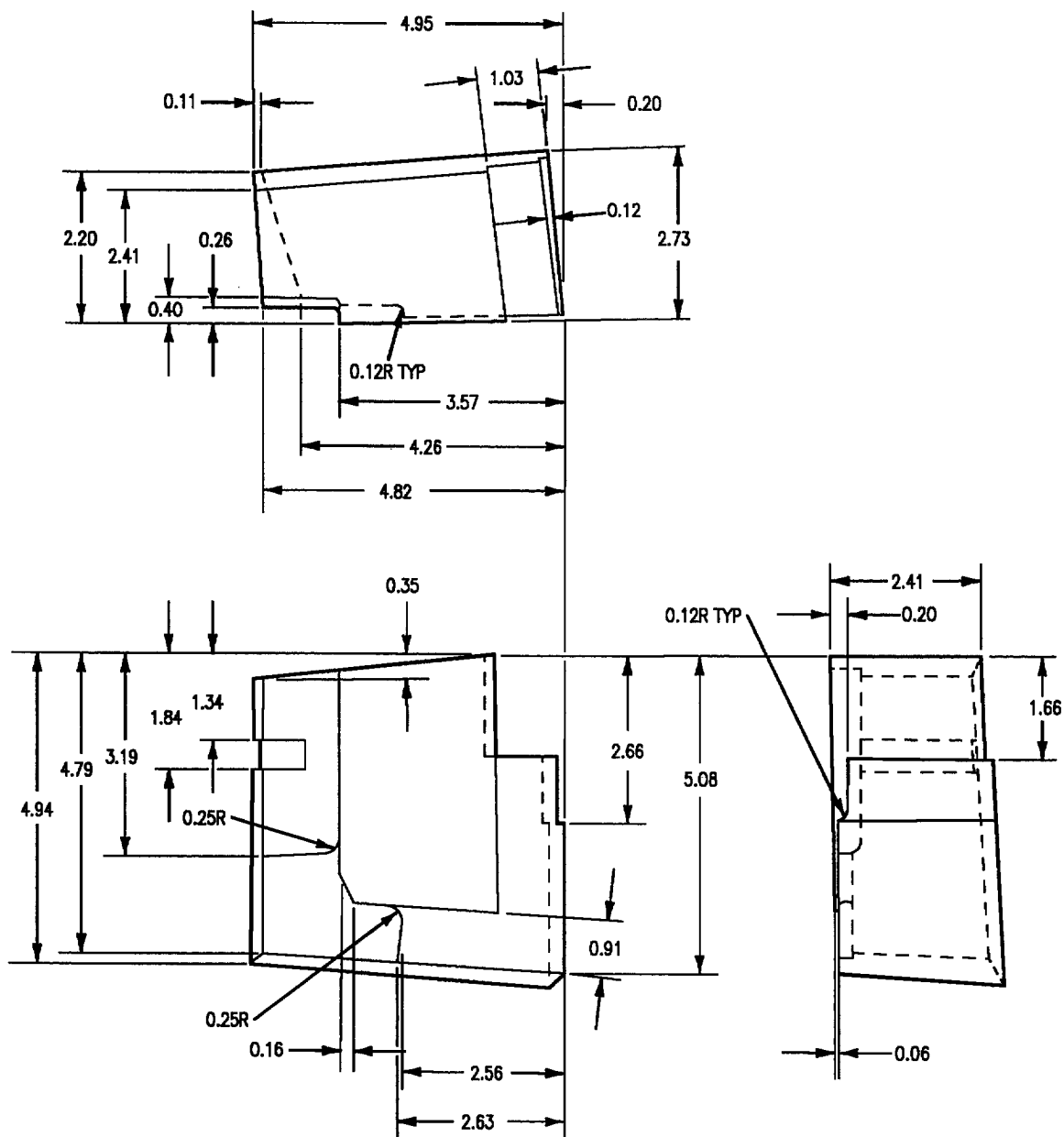


74A314857-2199



74A314857-2201

Figure 1. Blocks Fabrication (Sheet 15)



74A314857-2203

Figure 1. Blocks Fabrication (Sheet 16)

INTERMEDIATE MAINTENANCE

STRUCTURE REPAIR

FUEL TANK CAVITY NUMBER 1 FILLER BLOCKS, 74A314B57-2205 THRU 74A314857-2311, FABRICATION

Reference Material

Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Fuel Tank Cavity Number 1 Filler Blocks	WP031 01
Fuel System	A1-F18AC-460-300
No. 1 Fuel Tank Cavity Foam/Honeycomb Filler, F/A-18B	WP017 02

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Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

None

1. **FABRICATION.** See figure 1.

2. See figure for block dimensions. For type of material and stock size (WP031 01). For removal and installation of blocks (A1-F18AC-460-300, WP017 02).

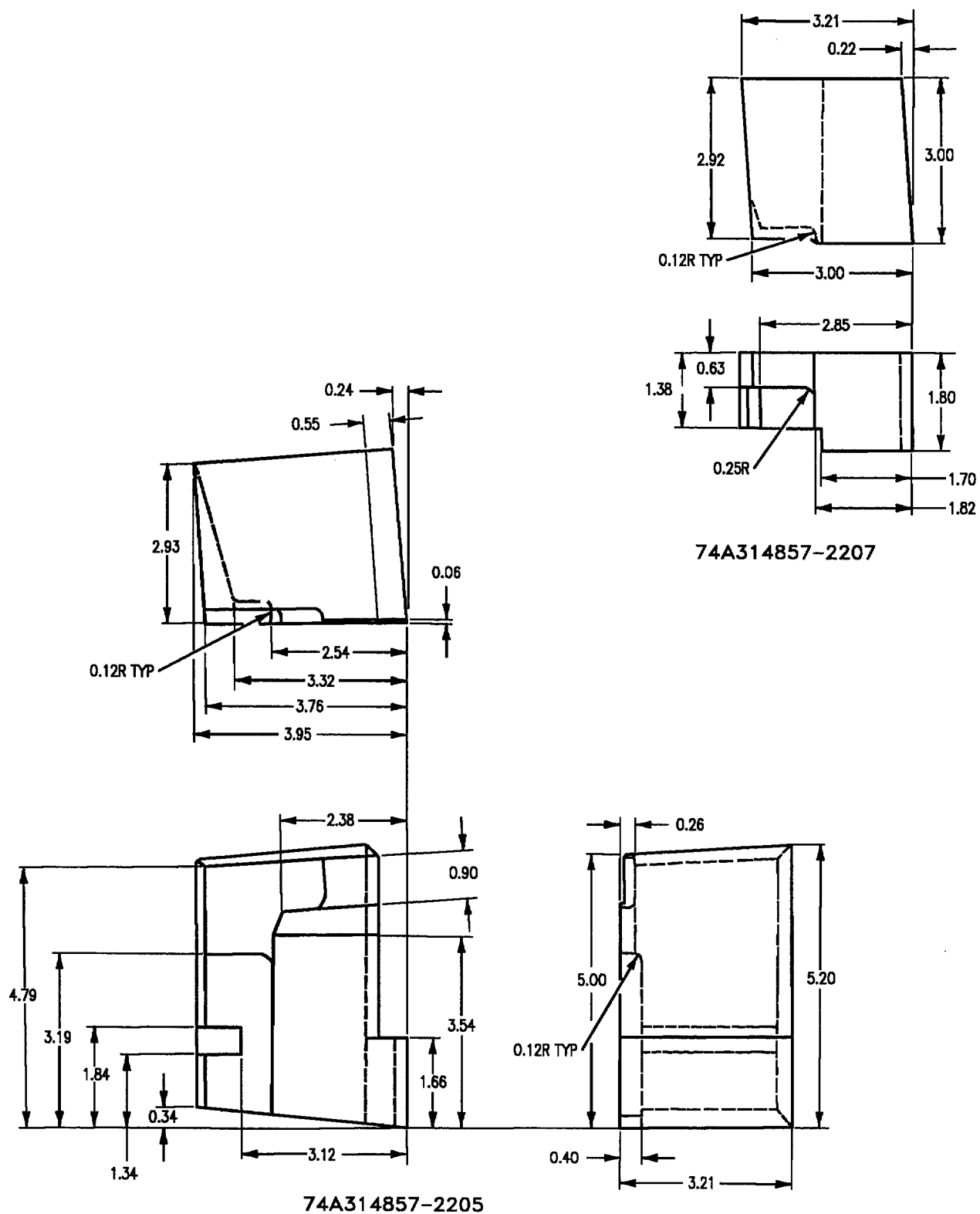


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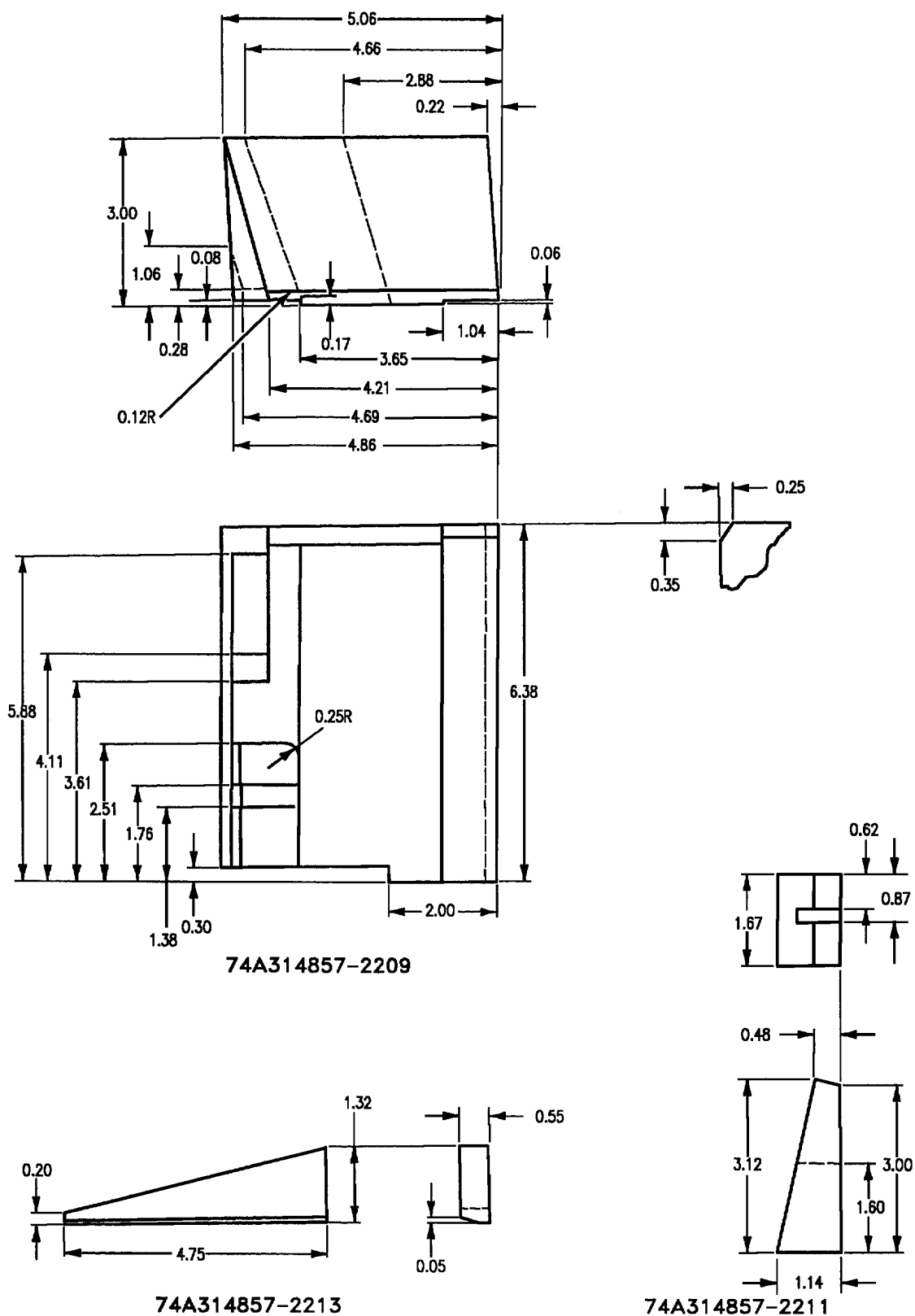


Figure 1. Blocks Fabrication (Sheet 2)

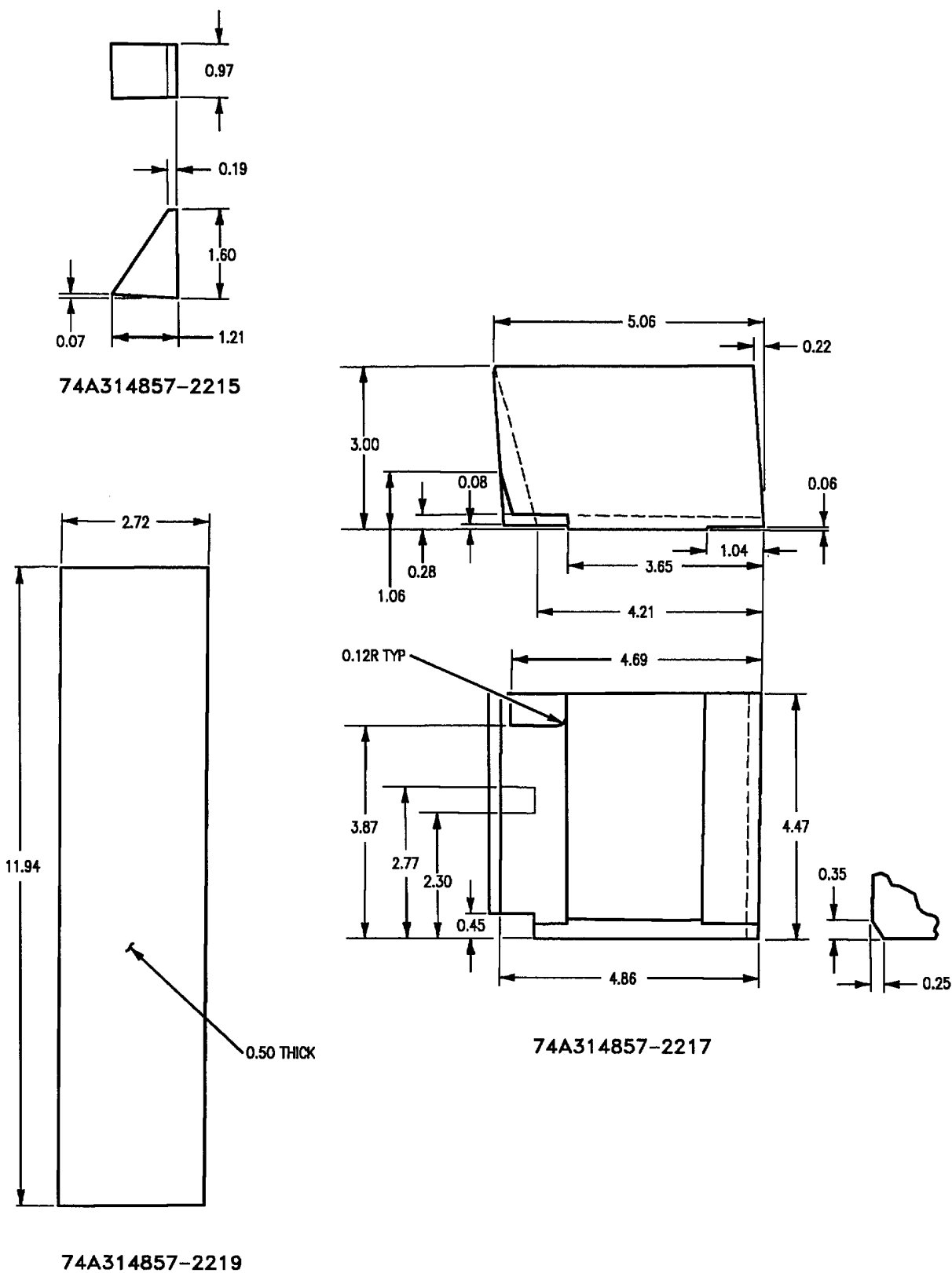


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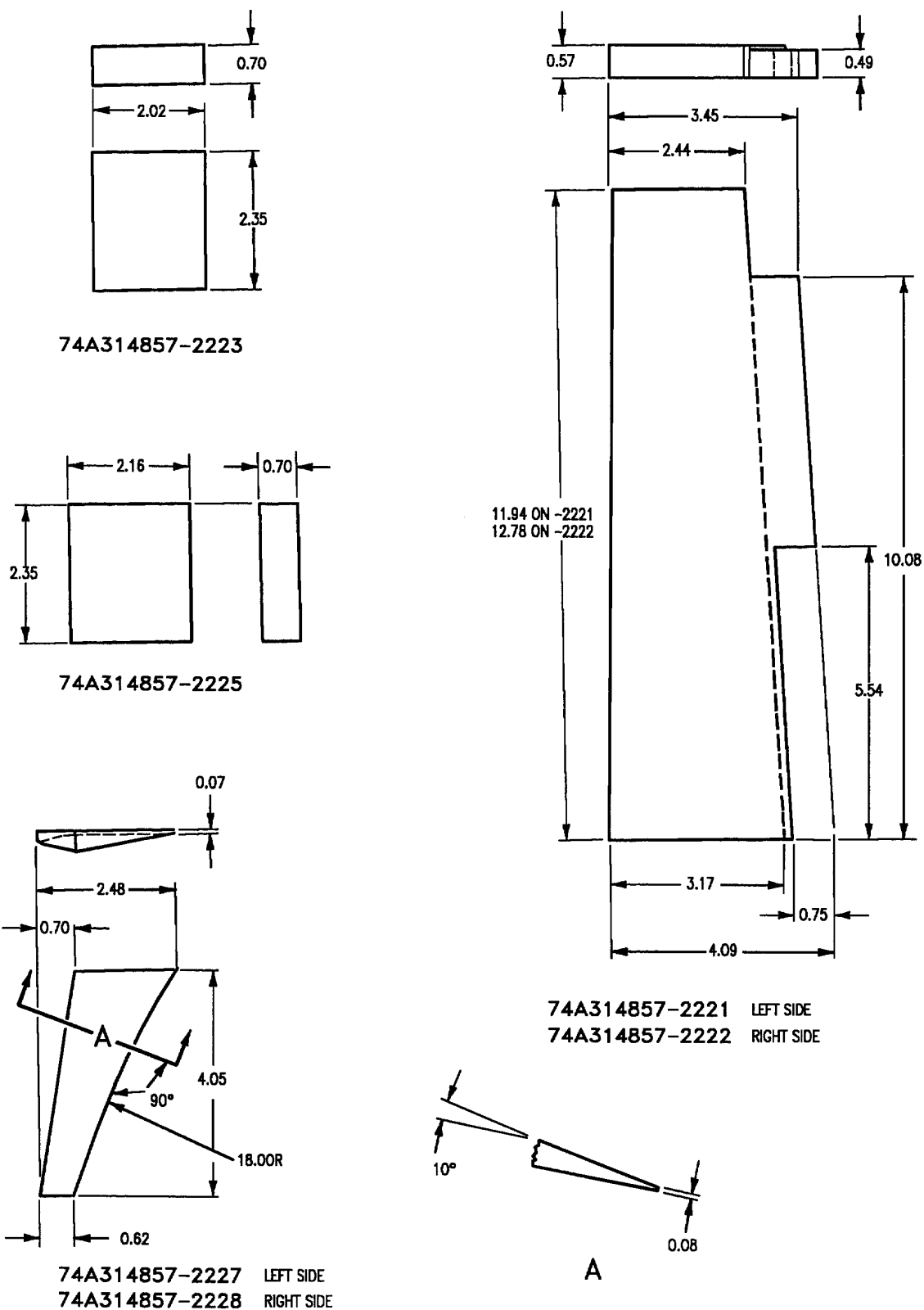


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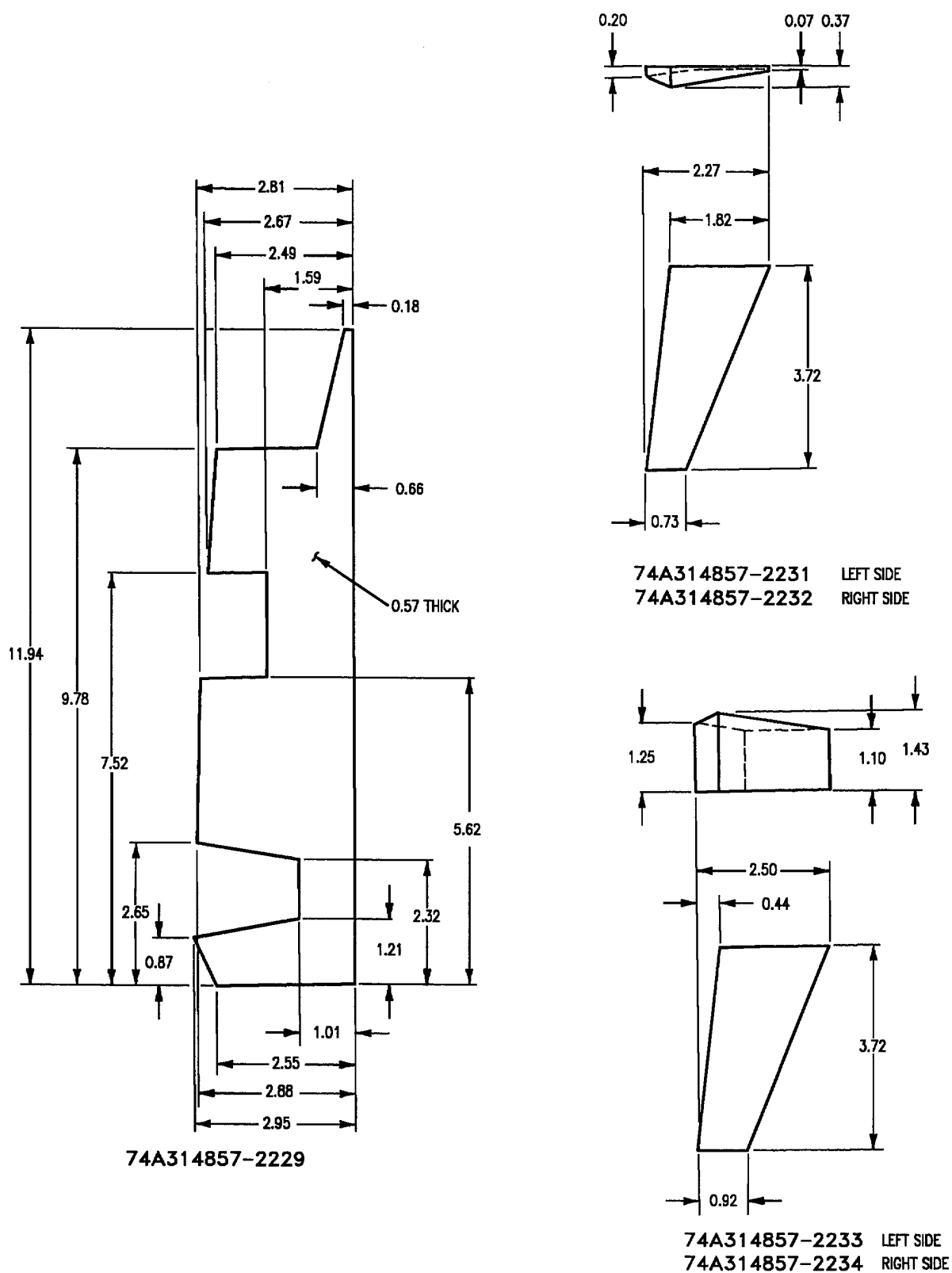


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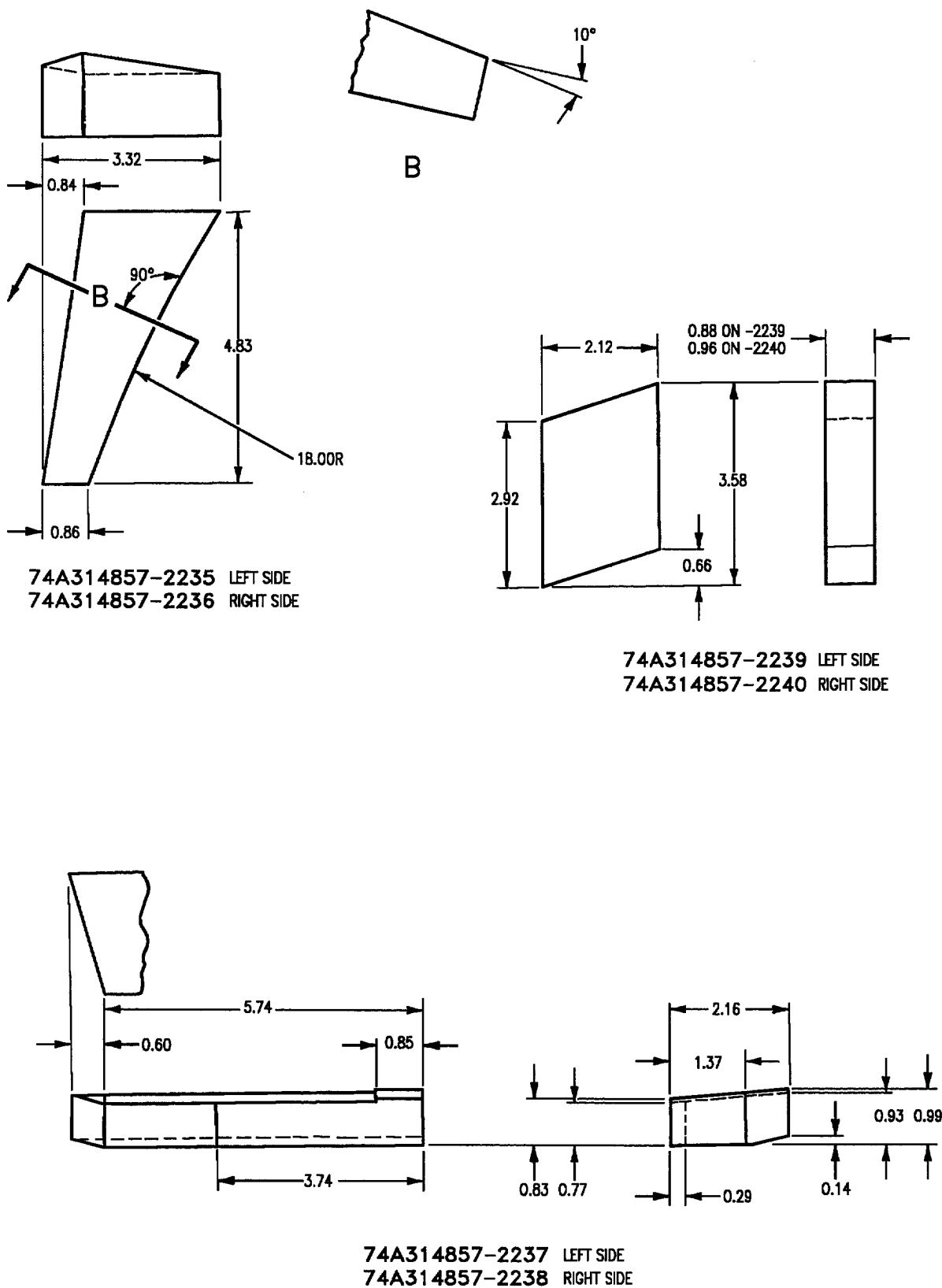
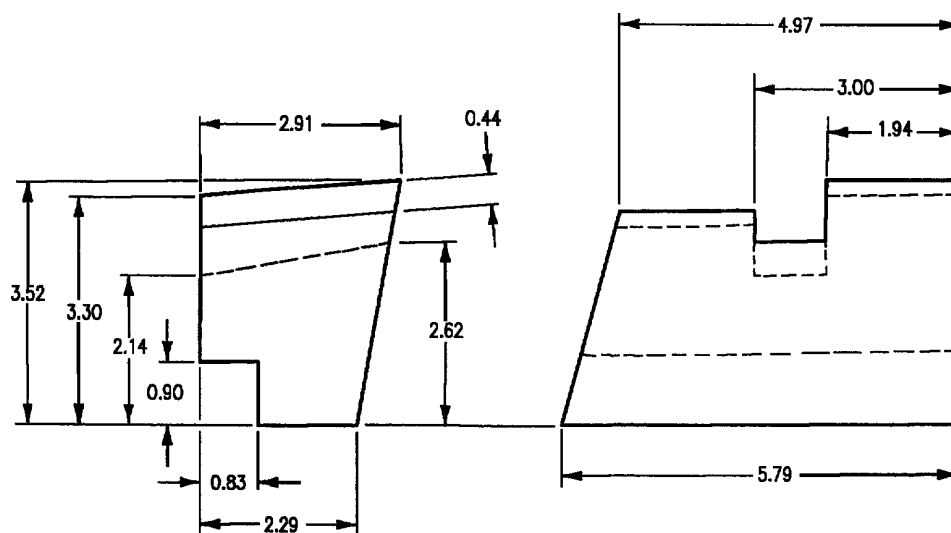
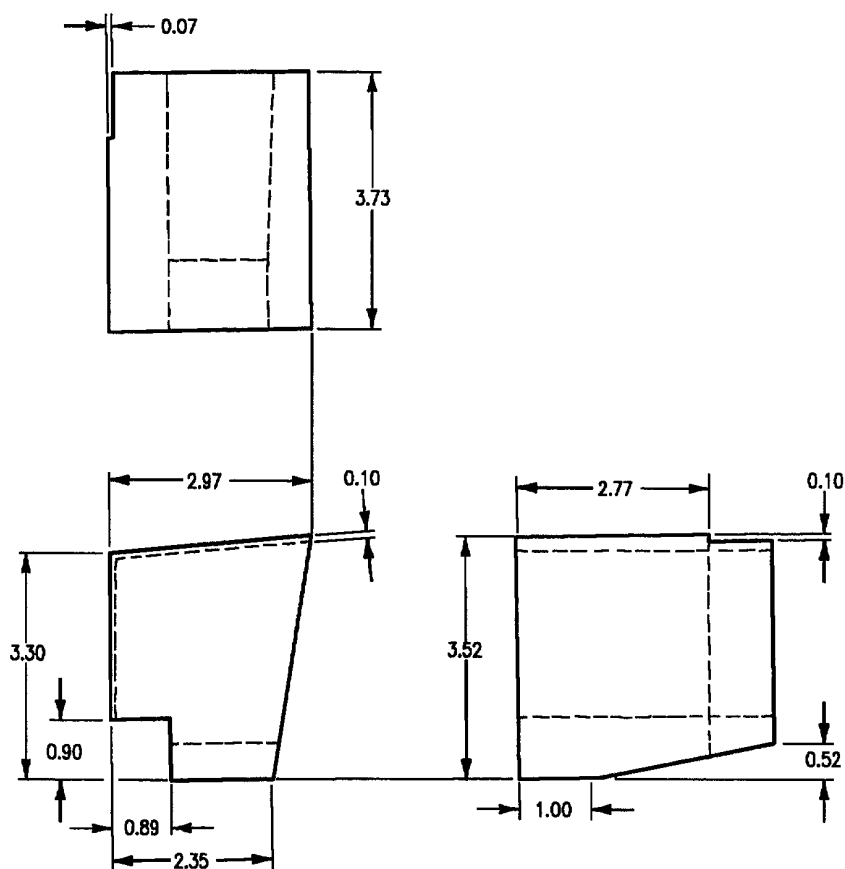


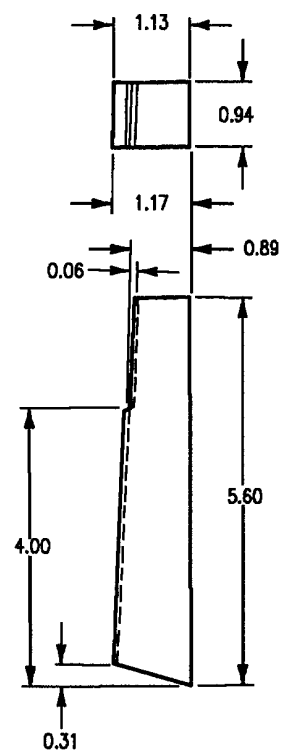
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74A314857-2241

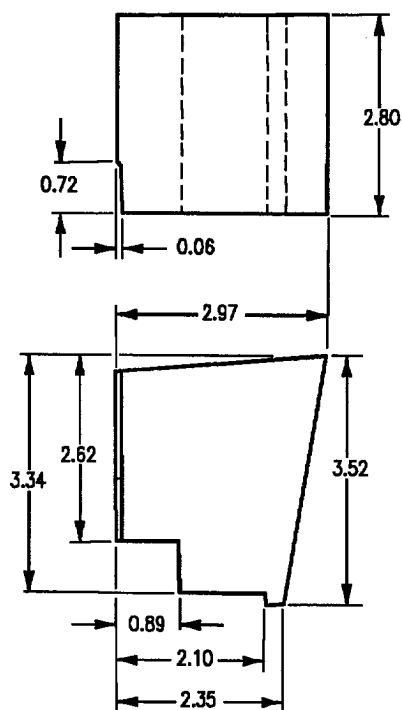


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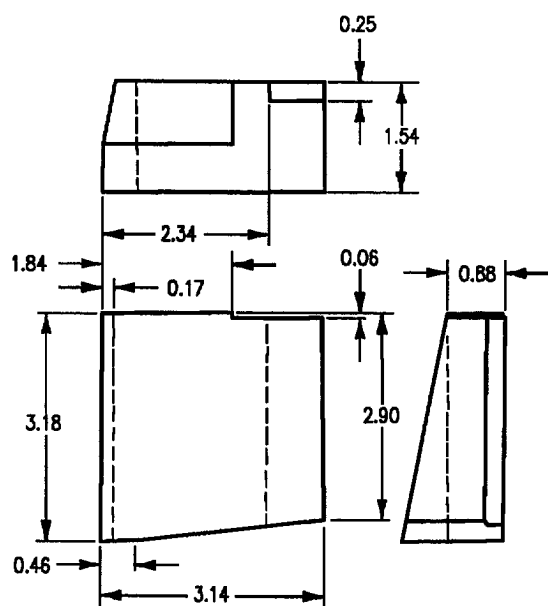


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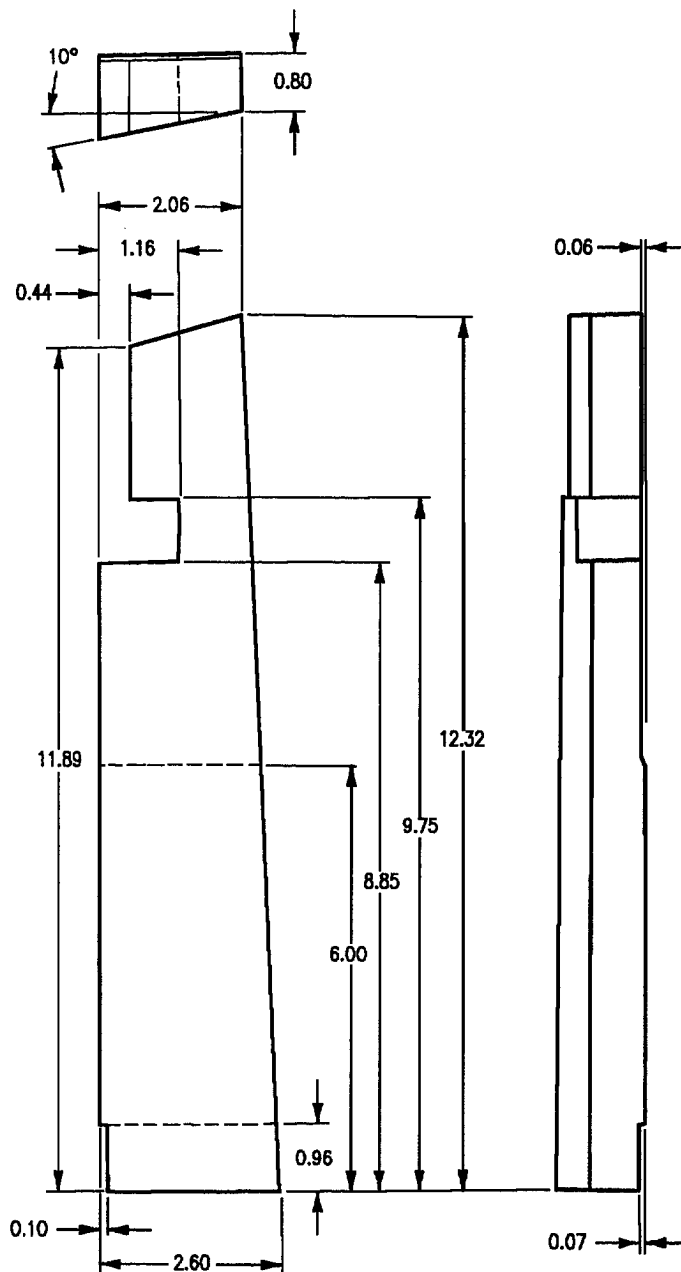
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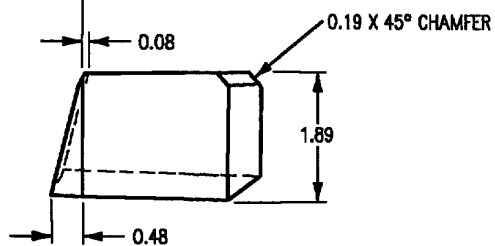
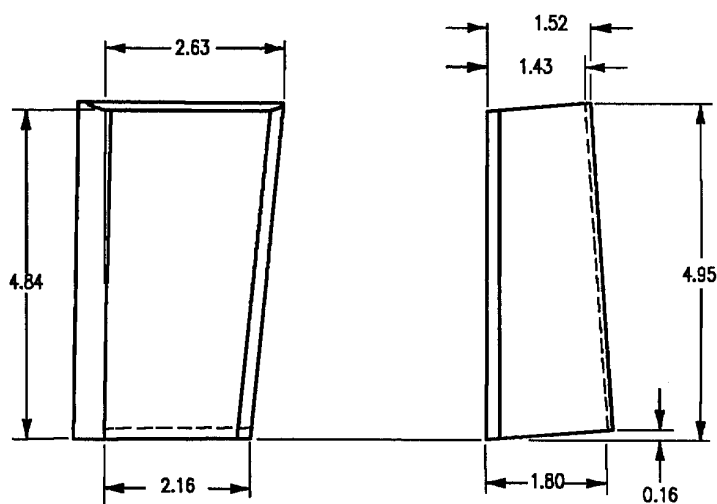


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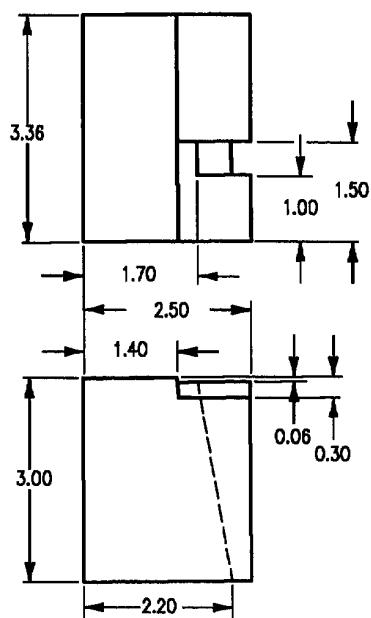


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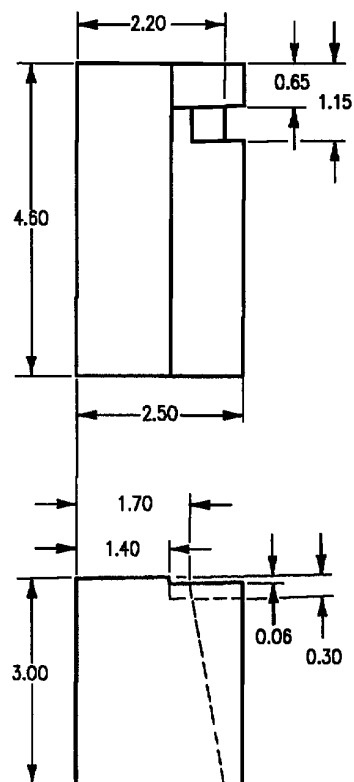
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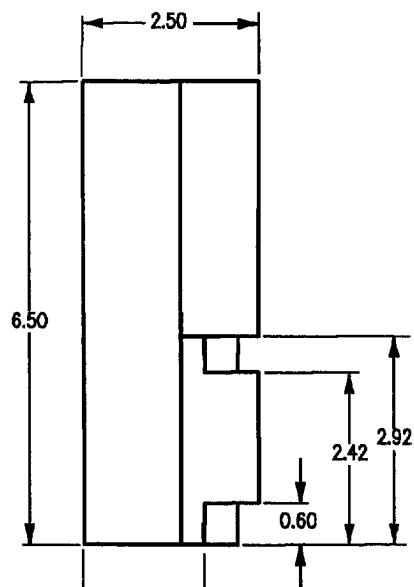


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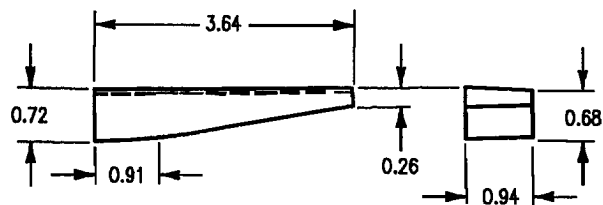
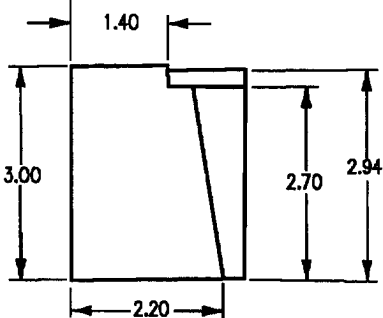


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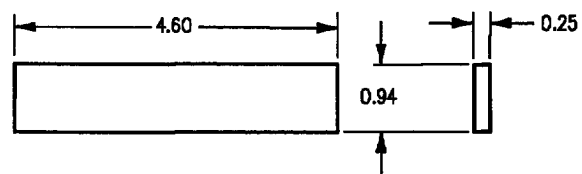
Figure 1. Blocks Fabrication (Sheet 9)



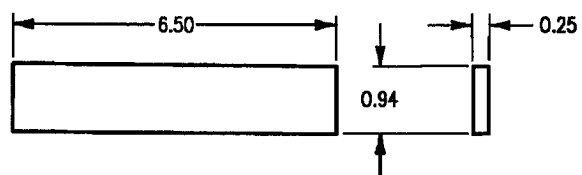
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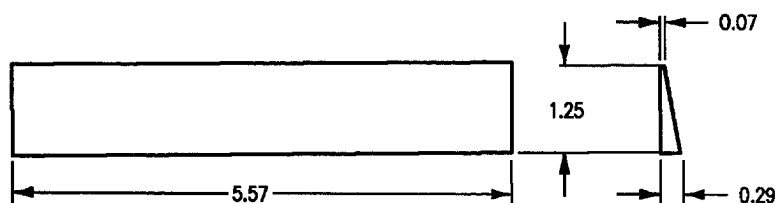
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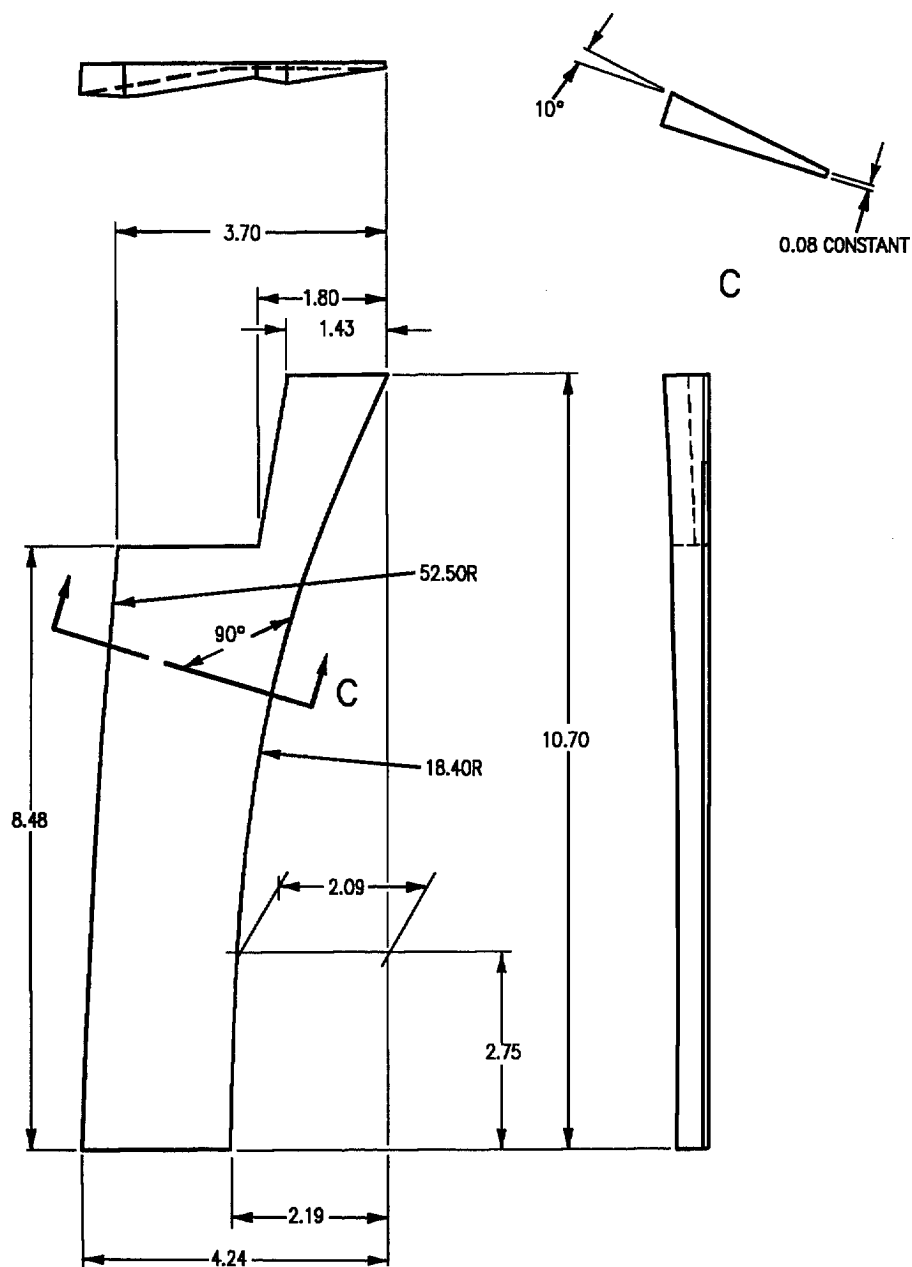


74A314857-2265



74A314857-2267

Figure 1. Blocks Fabrication (Sheet 10)



74A314857-2269 LEFT SIDE
74A314857-2270 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 11)

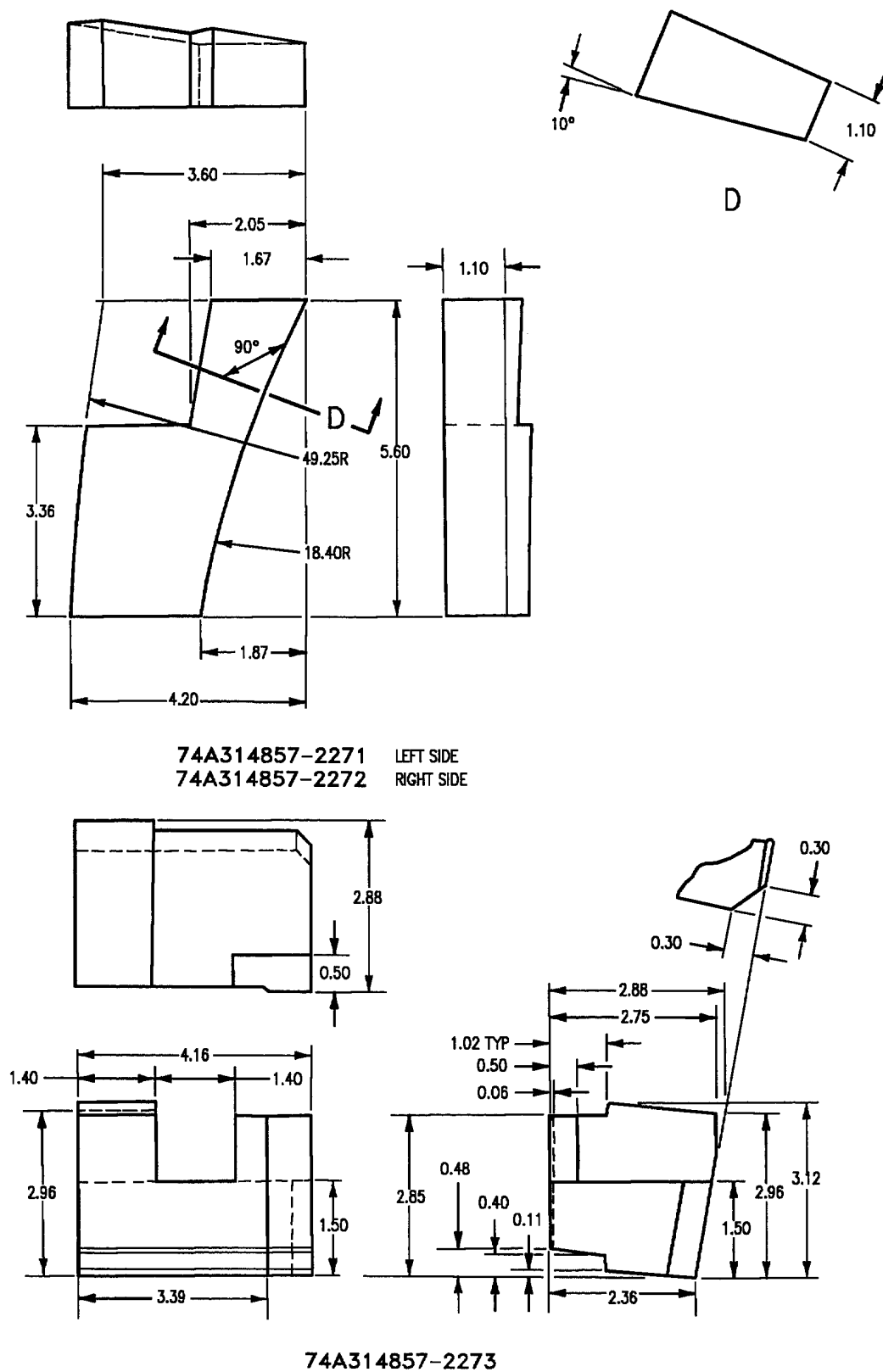
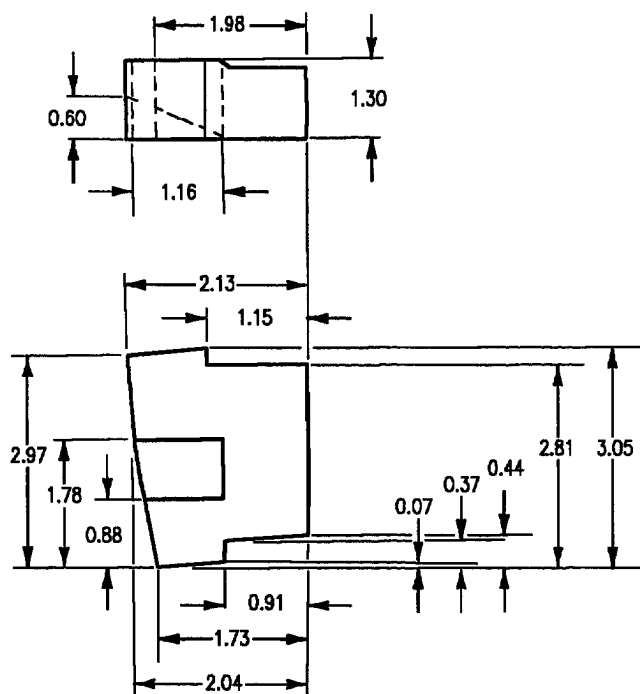
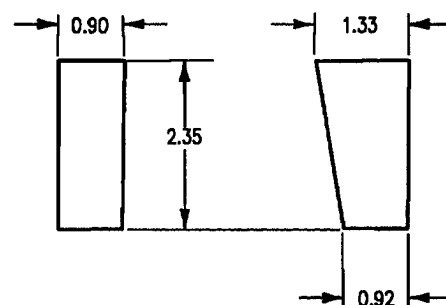


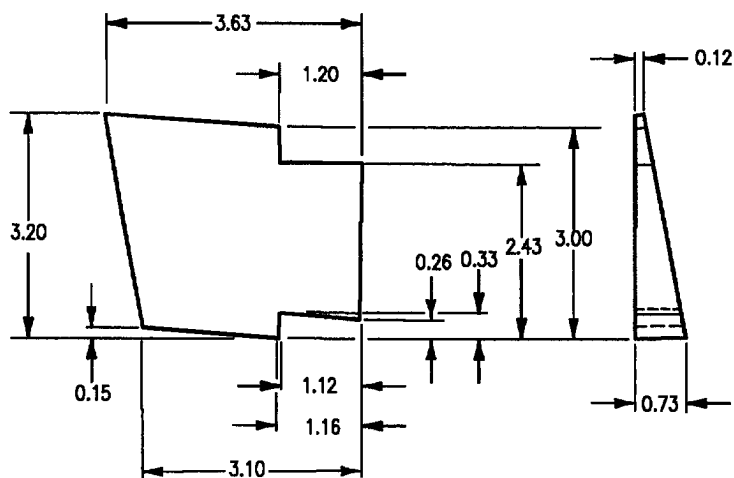
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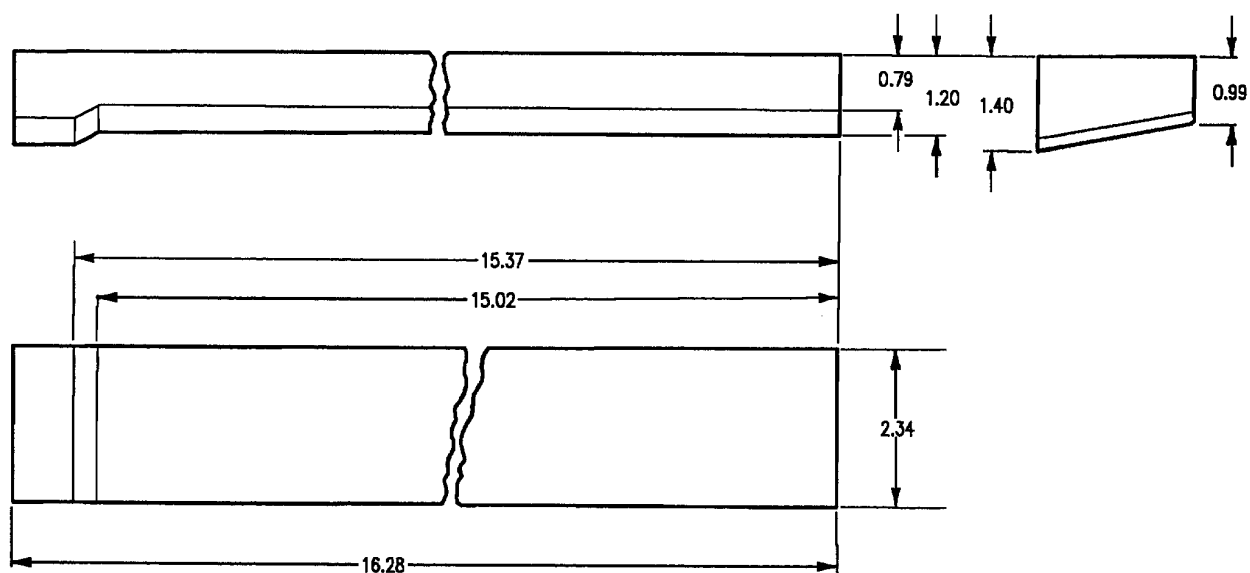


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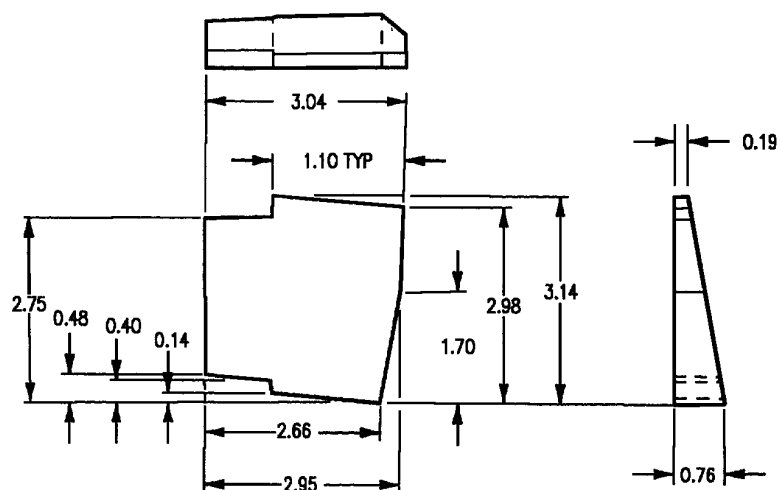


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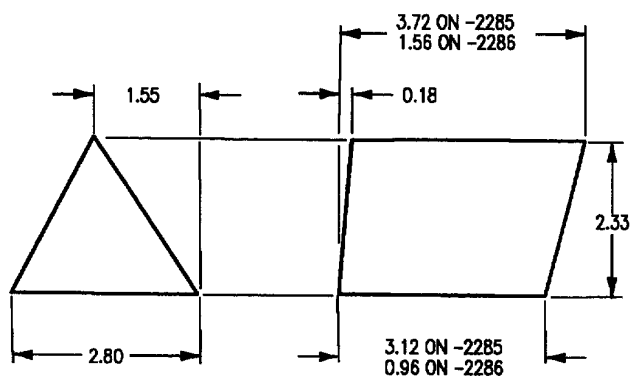
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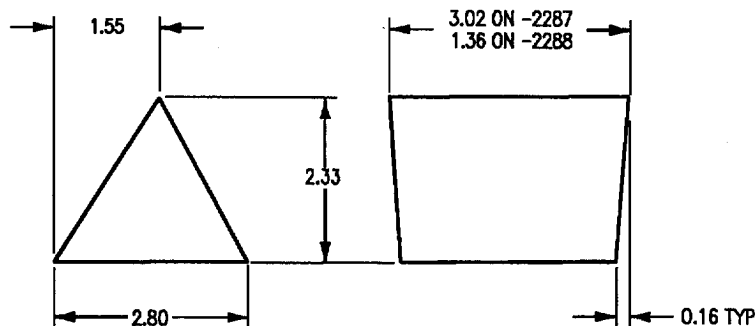


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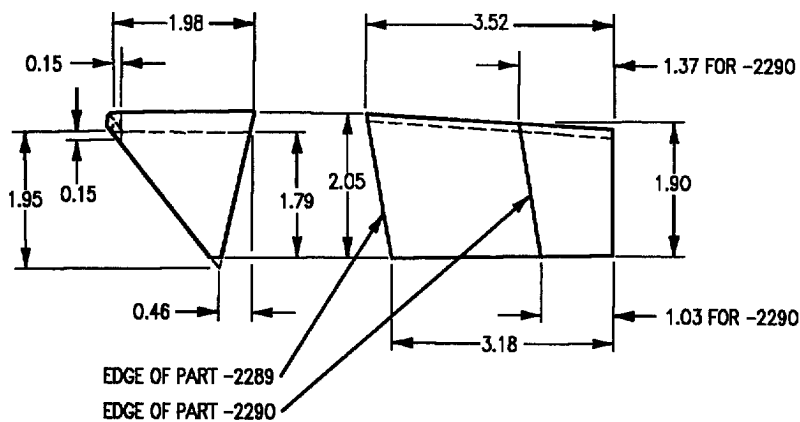


74A314857-2285 LEFT SIDE
74A314857-2286 RIGHT SIDE

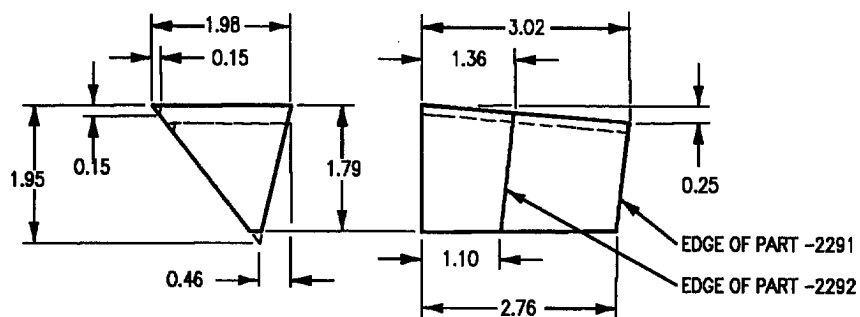
Figure 1. Blocks Fabrication (Sheet 14)



74A314857-2287 LEFT SIDE
74A314857-2288 RIGHT SIDE



74A314857-2289 LEFT SIDE
74A314857-2290 RIGHT SIDE



74A314857-2291 LEFT SIDE
74A314857-2292 RIGHT SIDE

Figure 1. Blocks Fabrication (Sheet 15)

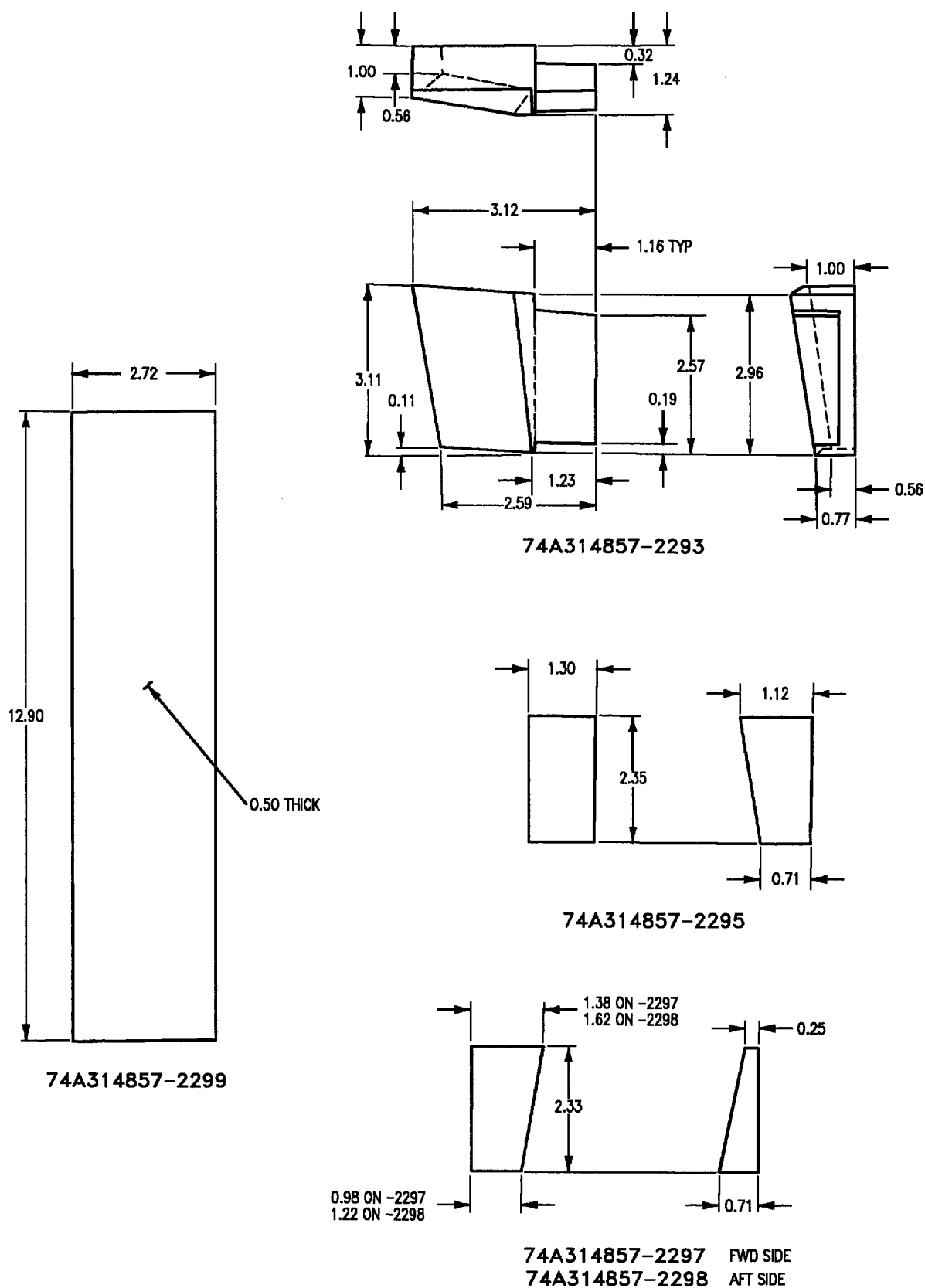
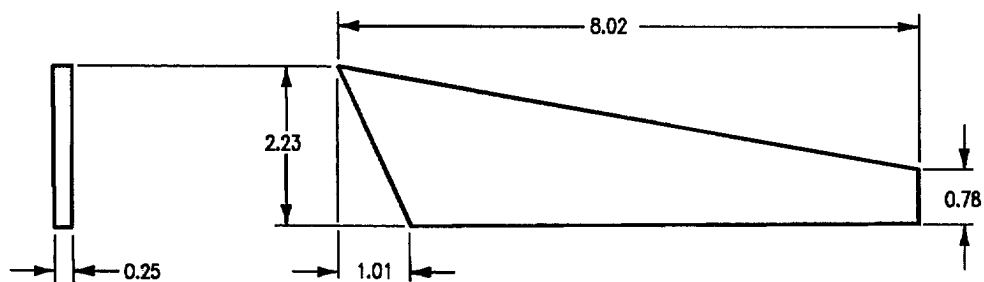
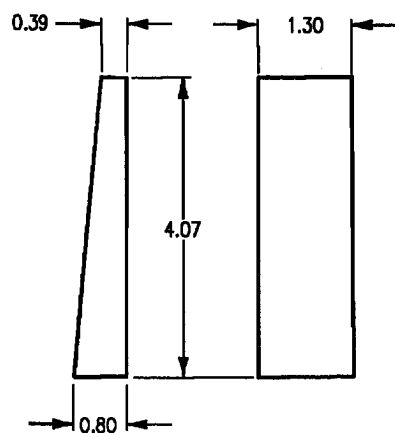


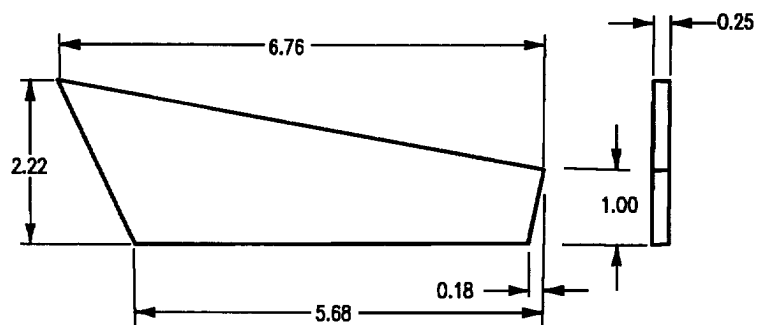
Figure 1. Blocks Fabrication (Sheet 16)



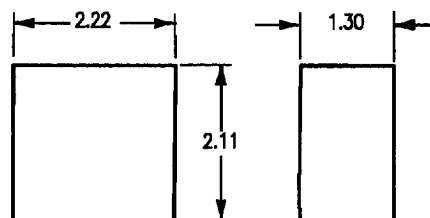
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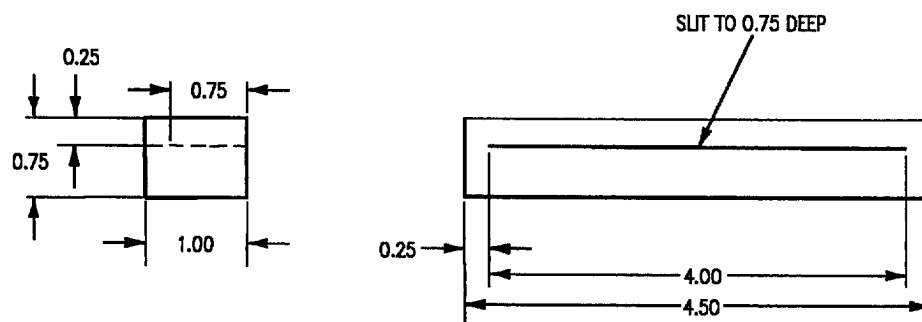


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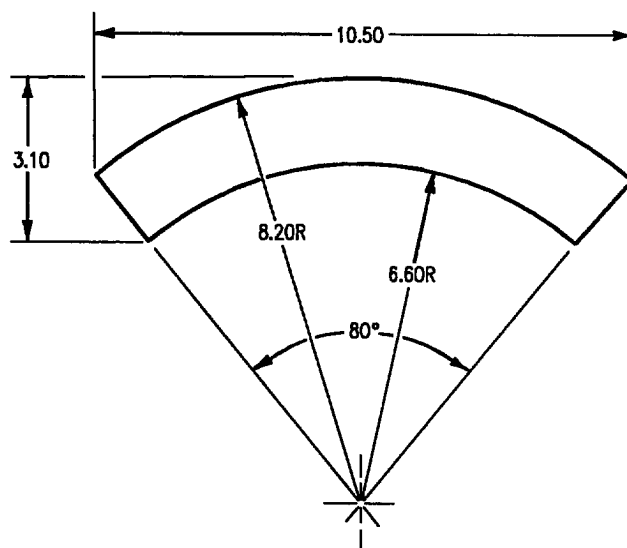


74A314857-2305

Figure 1. Blocks Fabrication (Sheet 17)



74A314857-2309



74A314857-2311

Figure 1. Blocks Fabrication (Sheet 18)

ORGANIZATIONAL AND DEPOT MAINTENANCE**STRUCTURE REPAIR****FORWARD FUSELAGE EXTERNAL NUMBERED METAL DOORS**

Reference Material

Aircraft Corrosion Control	A1-F18AC-SRM-500
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Aluminum Patch Fabrication	WP006 01
Aluminum, Graphite Epoxy, or Titanium Patch Installation and Removal	WP007 00
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Titanium Sheet, Free of Structure and Land Areas	WP032 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Aluminum Sheet Edge Repair	WP034 00
Titanium Sheet Edge Repair	WP035 00
Aluminum Sheet Repairs, Across Structure and Lands	WP036 00
Titanium Sheet Repairs, Across Structure and Lands	WP037 00
Blending	WP038 00
Structure Repair, General Information	A1-F18AC-SRM-200
Introduction	WP002 00
Cold Working Fastener Holes	WP004 10
Fasteners	WP004 06
Oversize Fasteners	WP004 07

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Record of Applicable Technical Directives

None

Support Equipment Required

None

Materials Required

None

1. DAMAGE EVALUATION. See figures 1 and 2.

2. Damage is classified as negligible and repairable. The types of materials used are shown on figure 1. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Repair to aluminum or titanium sheet across structure or land areas, 0.063 inch material or thicker, in zone B2 is depot maintenance. Damage not listed or exceeding the following limits require a depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

4. **REPAIRABLE DAMAGE.** The types and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with figure and index numbers in the material index, figure 1.

NOTE

The limits in table 2 apply after blending the damage.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and land must have edge cleanup hole at least eight repair fasteners diameters from any land, internal structure or existing row of fasteners.

(2) Damage to land, over structure, only repair per land.

e. Dents exceeding the limits in table 1 must be repaired.

5. REPAIRS.

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definitions are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

7. PERMANENT REPAIRS.

8. Scratches, Nicks, Gouges, or Corrosion.

Blend scratches, nicks, gouges, or corrosion (A1-F18AC-SRM-250, WP038 00). If, after blending, the damage limits of table 2 are exceeded, repair aluminum sheet as below. Refinish blended area (A1-F18AC-SRM-500, WP024 00).

a. Scratches - make crack or edge repairs.

b. Nicks, gouges, or corrosion - make hole or edge repair.

9. Cracks.

a. In zones A1, B1, and B2 repair cracks free of structure or land areas in aluminum (A1-F18AC-SRM-250, WP031 00) or in titanium (A1-F18AC-SRM-250, WP032 00) as below:

(1) Stop drill ends of crack in repair zone A1. Completely cut out crack in smallest diameter circle possible in repair zones B1 and B2.

(2) In repair zone A1, install a lap patch.

(3) In repair zones B1 and B2, install a type two flush or lap patch.

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In zone B3 repair cracks free of structure or land areas in aluminum as below:

(1) Cut out damage.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In zones A1, B1, and B2 repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00) or titanium sheet (A1-F18AC-SRM-250, WP037 00) as below:

(1) Cut out damage.

NOTE

When making a repair in zone B2, to 0.063 inch or thicker material, all fastener holes shall be cold worked (A1-F18AC-SRM-200, WP004 10) or drilled to an interference fit (A1-F18AC-SRM-200, WP004 06) for standard fasteners or (WP004 07) for oversize fastener. Cold working or drilling interference fit holes is depot maintenance.

(2) In repair zones A1, A2, B1 and B2, make repairs as below:

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

d. In repair zones A1, A2, B1, or B2 repair cracks to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zones A1, A2, B1, or B2, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

10. Holes.

a. In zones A1, B1, and B2 repair holes free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00) or in titanium sheet (A1-F18AC-SRM-250, WP032 00) as below:

(1) Cut out damage.

(2) In repair zone A1, install a type one flush or lap patch. In repair zones B1 and B2, install a type two flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In zone B3 repair holes free of structure or land areas in aluminum as below:

(1) Cut out damage.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In zones A1, B1, and B2 repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00) or in titanium sheet (A1-F18AC-SRM-250, WP037 00) as below:

(1) Cut out damage.

NOTE

When making a repair in zone B2, to 0.063 inch or thicker material, all fastener holes shall either be cold worked (A1-F18AC-SRM-200, WP004 10) or drilled to an interference fit (A1-F18AC-SRM-200, WP004 06) for standard fasteners or (WP004 07) for oversize fastener. Cold working or drilling interference fit holes is depot maintenance.

(2) In repair zones A1, B1, or B2, make repairs as below:

(a) Damage to Bay Requiring Repair
A cross Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

d. In repair zones A1, B1, and B2, repair holes to aluminum formed structure (A1-F18AC-SRM-250, WP033 00) as below:

(1) Cut out damage.

(2) In repair zones A1, B1, or B2, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

11. **Edge.** In zones A1, B1, and B2 repair edge damage in aluminum sheet A1-F18AC-SRM-250, WP034 00) or in titanium sheet (A1-F18AC-SRM-250, WP035 00) as below:

a. Cut out damage.

b. Select and install repair patch as below:

(1) Corner damage to Lands.

(2) Corner damage to Lands and Bays.

(3) Edge damage to Lands.

(4) Edge damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

12. Dents.

a. In zones A1, B1 and B2, repair dents free of structure or land areas aluminum sheet (A1-F18AC-SRM-250, WP031 00) or in titanium sheet (A1-F18AC-SRM-250, WP032 00) as below:

(1) Cut out damage.

(2) In repair zones A1, install a type one flush or lap patch. In zone B1 or B2, install a type two flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In zone B3 repair dents free structure or land areas in aluminum as below:

(1) Cut out damage.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In zones A1, B1 and B2, repair dents across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00) or in titanium sheet (A1-F18AC-SRM-250, WP037 00) as below:

(1) Cut out damage.

NOTE

When making a repair in zone B2, to 0.063 inch or thicker material, all fastener holes shall be cold worked (A1-F18AC-SRM-200, WP004 10) or drilled to an interference fit (A1-F18AC-SRM-200, WP004 06) for standard or (WP004 07) for oversize fastener. Cold working or drilling interference fit holes is depot maintenance.

(2) In repair zones A1, B1, or B2, make repairs as below:

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP024 00).

d. In repair zones A1, B1, and B2, repair dents to
aluminum formed structure (A1-F18AC-SRM-250,
WP033 00) as below:

(1) Cut out damage.

(2) In repair zones A1, B1, and B2, install repair
one through six. Select the repair that can be adapted to the
damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500,
WP024 00).

Table 1. Negligible Damage Limits






























































Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Door 24 Zone A1	0.063	0.002	0.002	100%	0.031	
Fig 1 (2)	Door 11 Zone B2	0.045	0.0006	0.0006	100%		
		0.063	0.0006	0.0006	100%		
Fig 1 (3)	Door 25 Zone B3	0.046	0.0006	0.0006	100%		
		0.063	0.0006	0.0006	100%		
Fig 1 (4)	Door 30 Zone B3	0.045	0.0006	0.0006	100%		
		0.063	0.0006	0.0006	100%		
Fig 1 (5)	Door 141 Zone A1	0.080	0.002	0.002	100%	0.031	
Fig 1 (6)	Door 96 Zone B1	0.042	0.0006	0.0006	100%	0.021	
		0.063	0.0006	0.0006	100%		10%
Fig 1 (7)	Door 7 Zone B1	0.020	0.0006	0.0006	100%		
		0.040	0.0006	0.0006	100%	0.020	
		0.080	0.0006	0.0006	100%		
Fig 1 (10)	Door 17 Zone B1	0.039	0.0006	0.0006	100%	0.019	
		0.080	0.0006	0.0006	100%		

Table 1. Negligible Damage Limits (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (11)	Door 9 Zone A1	0.060	0.002	0.002	100%		
		0.070	0.002	0.002	100%		
		0.090	0.002	0.002	100%	0.045	
		0.150	0.002	0.002	100%	0.075	
			0.250	0.002	100%		
			0.250	0.002	100%		
Fig 1 (12)	Door 16 Zone B1	0.050	0.0006	0.0006	100%	0.025	
		0.080	0.0006	0.0006	100%	0.040	
Fig 1 (13)	Door 108 Zone B2	0.040	0.0006	0.0006	100%	0.020	
		0.100	0.0006	0.0006	100%		
		0.180	0.0006	0.0006	100%		
Fig 1 (14)	Door 33 Zone B2	0.031	0.0006	0.0006	100%	0.015	
		0.070	0.0006	0.0006	100%		
		0.075	0.0006	0.0006	100%	0.037	
		0.100	0.0006	0.0006	100%		
		0.125	0.0006	0.0006	100%		
		0.170	0.0006	0.0006	100%		10%
Fig 1 (15)	Door 35 Zone C2	0.031	0.0006	0.0006	100%	0.015	
		0.100	0.0006	0.0006	100%		
		0.125	0.0006	0.0006	100%		
	Zone B2	0.070	0.0006	0.0006	100%		
		0.100	0.0006	0.0006	100%		

NOTES




-  Mold line surface of ribs.
-  Inboard ribs.
-  None allowed.

Table 2. Repairable Damage Limits After Blending




Fig No Idx No	Nomen/ Repair Zone	Thickness	Edge Nicks Depth	Scratch Depth	Nicks Gouges		Corrosion	
					Depth	Area	Depth	Area
Fig 1 (1)	Door 24 Zone A1	0.063	0.060	0.012	0.012	50%	0.012	50%
Fig 1 (2)	Door 11 Zone B2	0.045	N/A	0.009	0.009	10%	0.009	10%
		0.063	0.035	0.012	0.012	10%	0.012	10%
Fig 1 (3)	Door 25 Zone B3	0.046	N/A	0.009	0.009	10%	0.009	10%
		0.063	0.0006	0.012	0.012	10%	0.012	10%
Fig 1 (4)	Door 30 Zone B3	0.045	N/A	0.009	0.009	10%	0.009	10%
		0.063	0.0006	0.012	0.012	10%	0.012	10%
Fig 1 (5)	Door 141 Zone A1	0.080	0.008	0.016	0.016	50%	0.016	50%
Fig 1 (6)	Door 96 Zone B1	0.042	N/A	0.008	0.008	10%	0.008	10%
		0.063	0.035	0.012	0.012	10%	0.012	10%
Fig 1 (7) 	Door 7 Zone B1	0.020	N/A	0.004	0.004	10%	0.004	10%
		0.040	N/A	0.008	0.008	10%	0.008	10%
		0.080	0.050	0.016	0.016	50%	0.016	50%
Fig 1 (10)	Door 17 Zone B1	0.039	N/A	0.007	0.007	10%	0.007	10%
		0.080	0.050	0.016	0.016	50%	0.016	50%
Fig 1 (11)	Door 9 Zone A1	0.060	N/A	0.012	0.012	15%	0.012	15%
		0.070	N/A	0.014	0.014	15%	0.012	15%
		0.090	N/A	0.018	0.018	15%	0.018	15%
		0.150	N/A	0.018	0.018	15%	0.018	15%
		0.250	0.010	0.018	0.018	15%	0.018	15%
		0.250	0.040	0.030	0.030	15%	0.030	15%
								
Fig 1 (12)	Door 16 Zone B1	0.050	N/A	0.010	0.010	10%	0.010	10%
		0.080	0.075	0.016	0.016	10%	0.016	10%
Fig 1 (13)	Door 108 Zone B2	0.040	N/A	0.008	0.008	10%	0.008	10%
		0.100	0.020	0.020	0.020	10%	0.020	10%
		0.180	0.035	0.020	0.020	10%	0.020	10%

Table 2. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Edge Nicks Depth	Scratch Depth	Nicks Gouges		Corrosion	
					Depth	Area	Depth	Area
Fig 1 (14)	Door 33 Zone B2	0.031	N/A	0.006	0.006	10%	0.006	10%
		0.070	0.050	0.014	0.014	10%	0.014	10%
		0.075	N/A	0.015	0.015	10%	0.015	10%
		0.100	0.035	0.020	0.020	10%	0.020	10%
		0.125	0.035	0.025	0.025	10%	0.025	10%
		0.170	N/A	0.034	0.034	10%	0.034	10%
Fig 1 (15)	Door 35 Zone C2	0.031	N/A	0.006	0.006	10%	0.006	10%
		0.100	0.0006	0.020	0.020	10%	0.020	10%
		0.125	0.0006	0.025	0.025	10%	0.025	10%
	Zone B2	0.070	0.035	0.014	0.014	10%	0.014	10%
		0.100	0.035	0.020	0.020	10%	0.020	10%

NOTES

- 1 No minor damage allowed.
- 2 Mold line surface of ribs.
- 3 Inboard ribs.

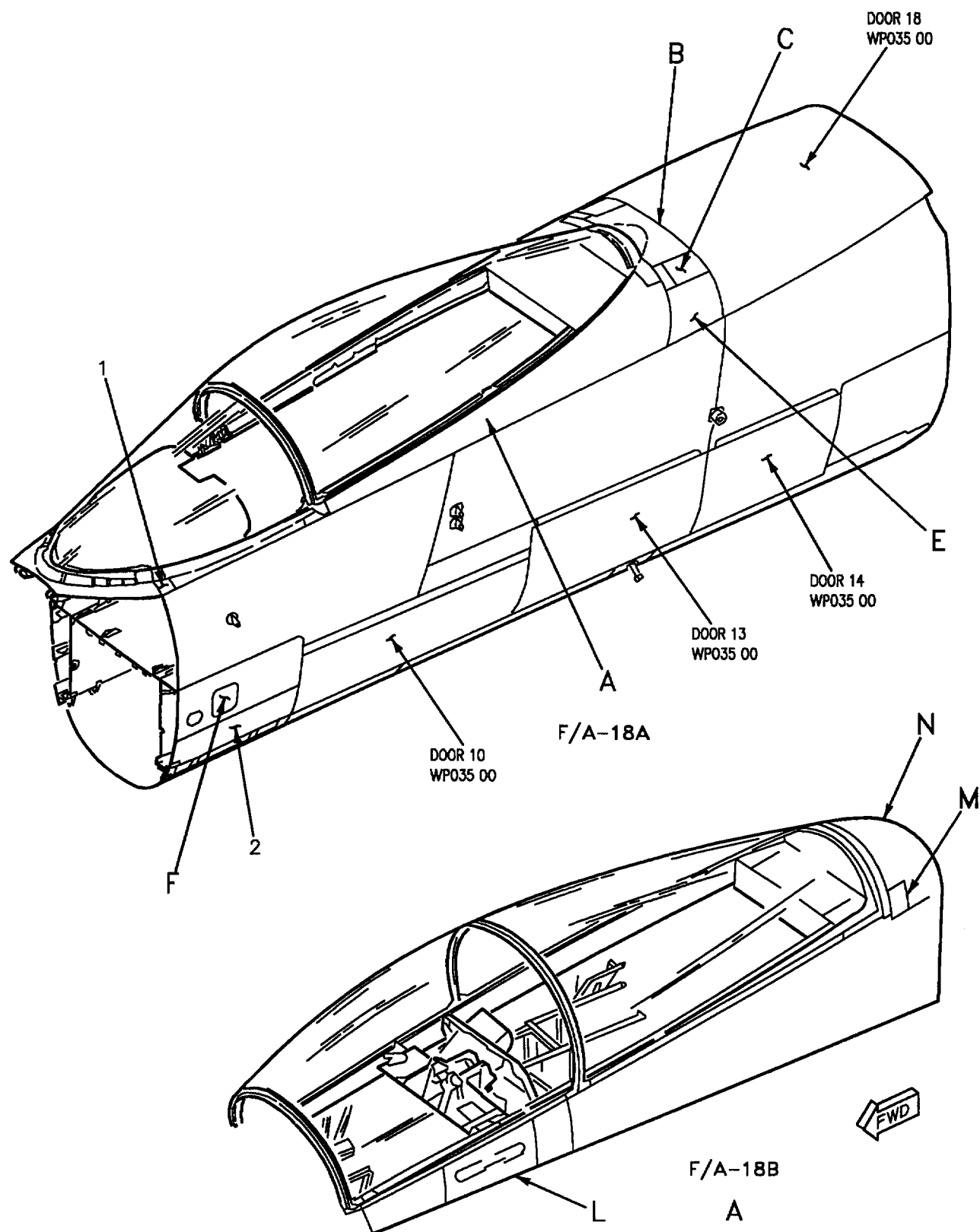


Figure 1. Material Index (Sheet 1)

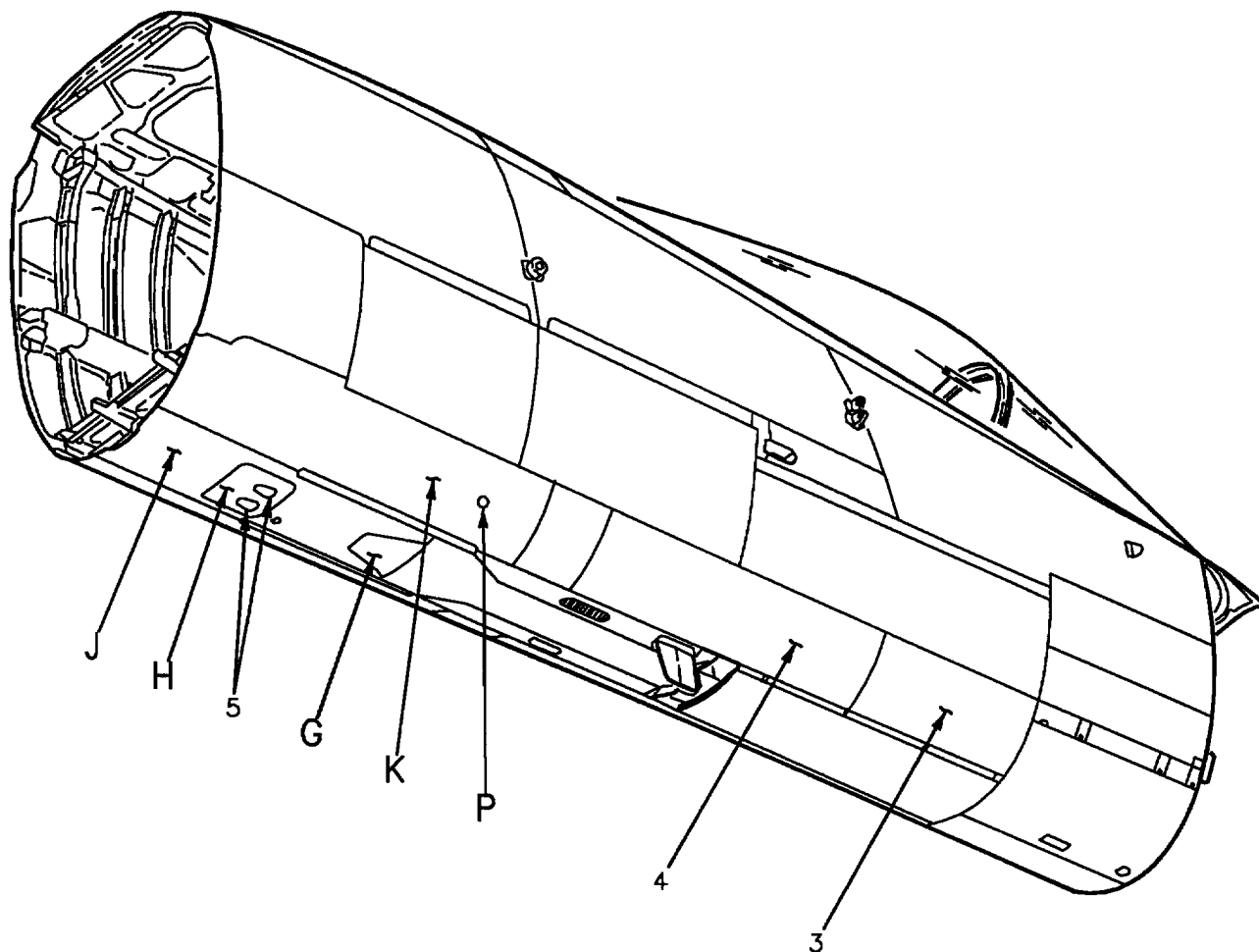


Figure 1. Material Index (Sheet 2)

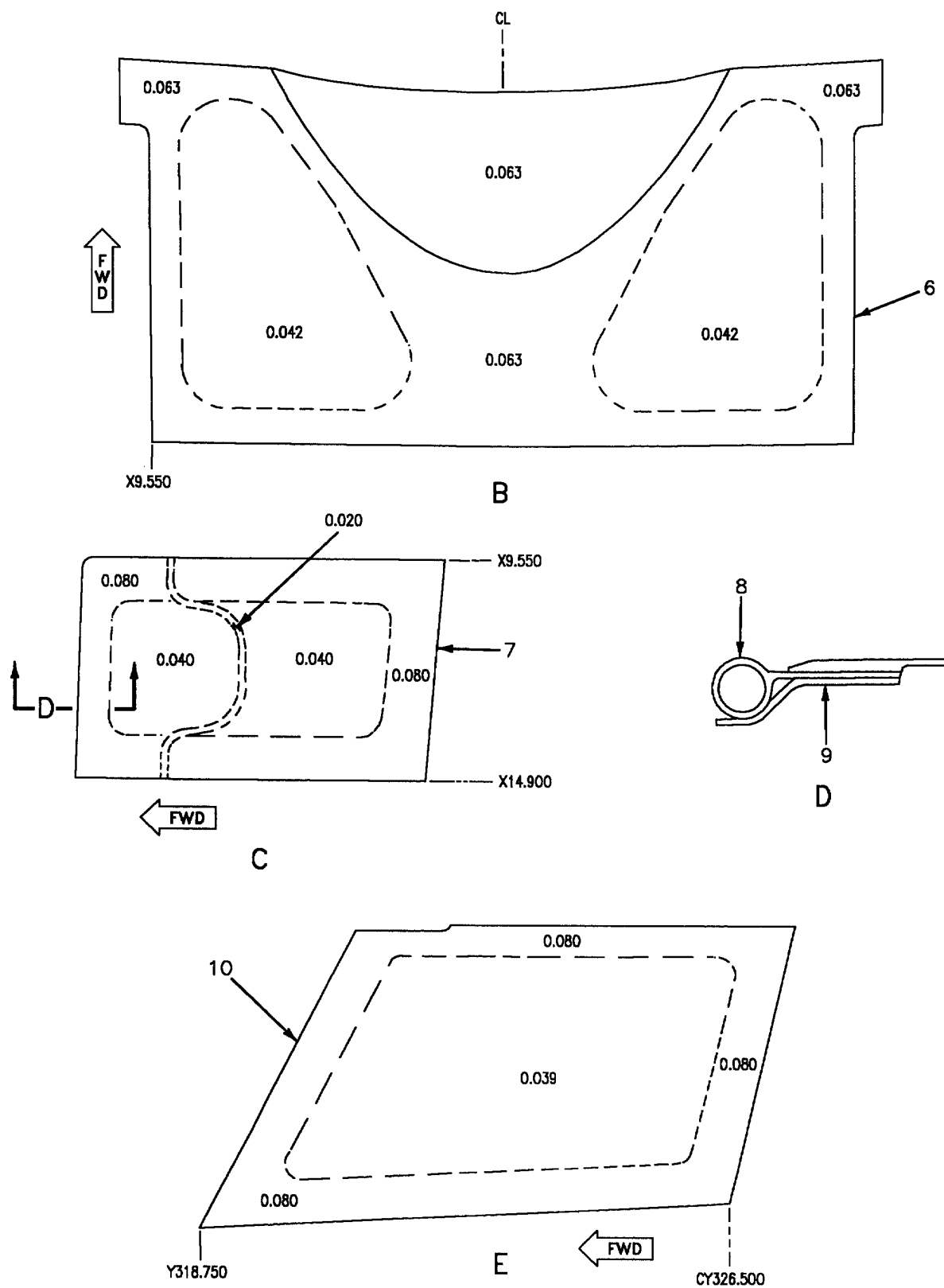


Figure 1. Material Index (Sheet 3)

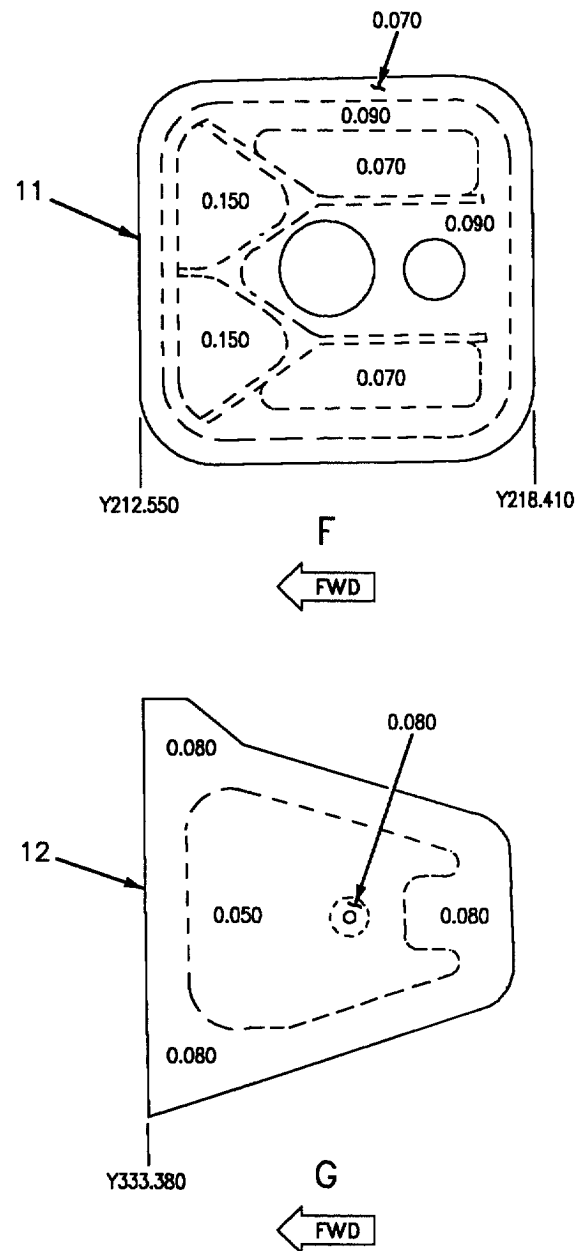


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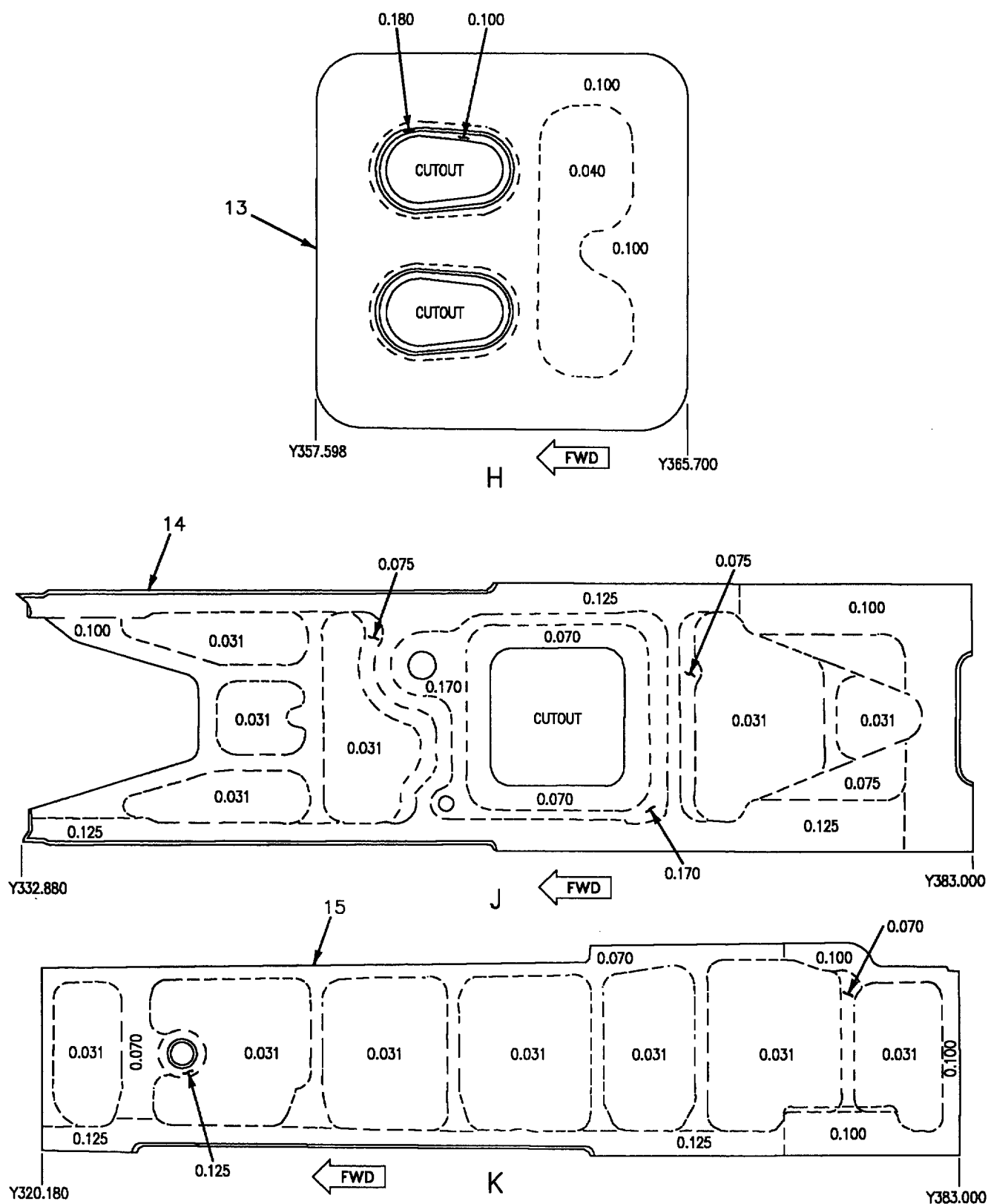


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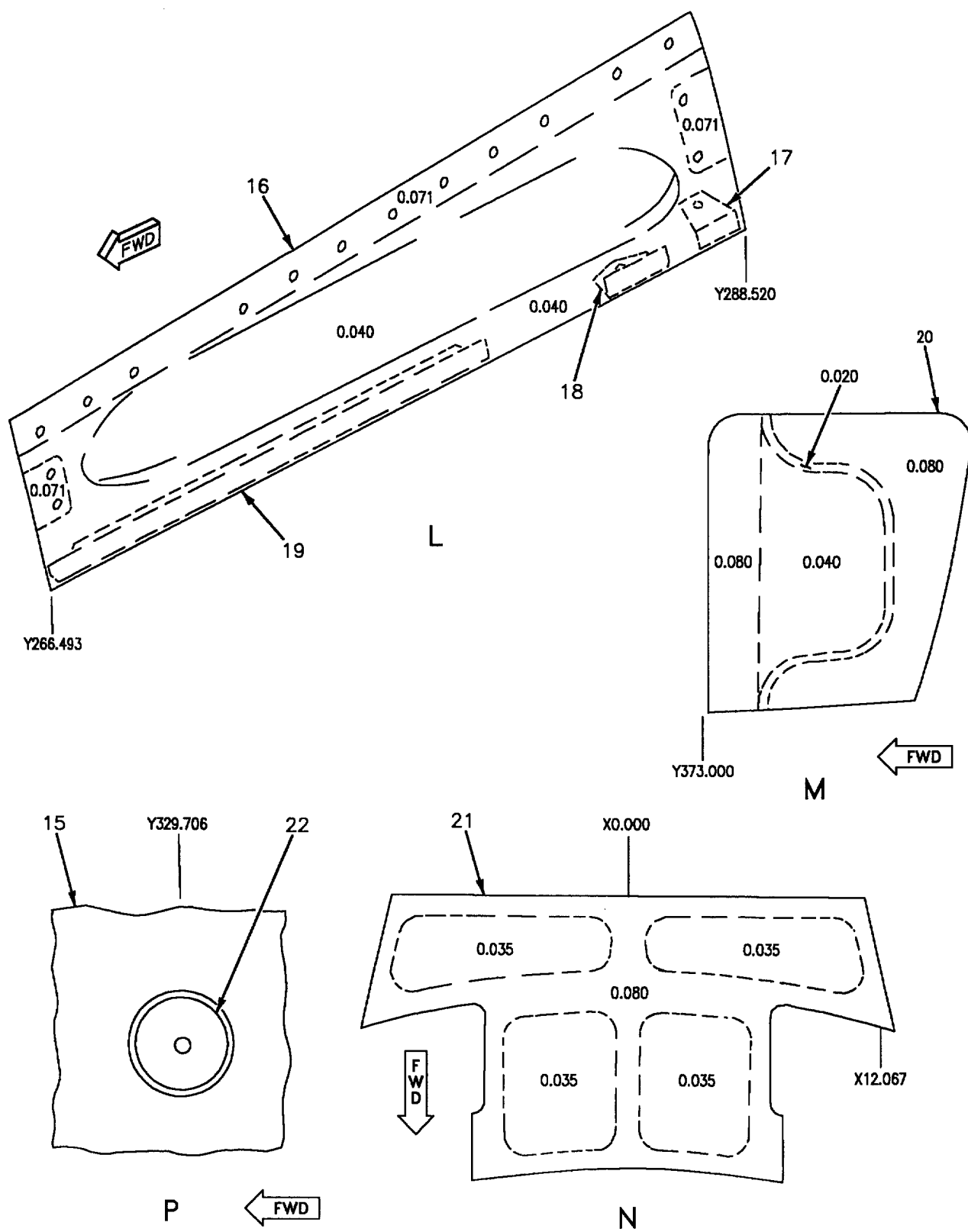


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
















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Cover (Door 24) 74A350617-2005, -2006	0.063 Sheet	7075-T6 Alclad
2		Skin (Door 11) 74A314392-2001, -2002	 Sheet	7075-T6 Alclad
3		Skin (Door 25) 74A314218-2005, -2006	 Sheet	7075-T6 Alclad
4		Skin (Door 30) 74A314219-2007, -2008	 Sheet	7075-T6 Alclad
5		Cover (Door 141) 74A314359-2009	0.080 Sheet	7075-T6 Alclad
6		Skin (Door 96) 74A314075-2003	 Sheet	7075-T6 Alclad
7		Cover (Door 7) 74A314074-2011, -2012	 Sheet	7075-T6 Alclad
8		Seal 74A314074-2003	11M932-1 Extr.	Silicon Rubber
9		Retainer 74A314074-2021, -2022	0.040 Sheet	7075-T6 Alclad
10		Cover (Door 17) 74A314074-2023, -2024	 Sheet	7075-T6 Alclad
11		Door 9 74A315025-2007	 Plate	7075-T7651 Alclad
12		Cover (Door 16) 74A314636-2009	 Sheet	7075-T6 Alclad
13		Cover (Door 108) 74A314635-2005	 Sheet	6AL-4V Ti Anl
14		Skin (Door 33) 74A314282-2007	 Sheet	6AL-4V Ti Anl
15		Skin (Door 35) 74A314312-2009, -2012	 Sheet	6AL-4V Ti Anl
16	 	Cover (Door 85) 74A350865-2003, -2004 74A350865-2013, -2014	 Sheet	7075-T6 Alclad
17		Angle 74A350865-2007	0.040 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
18		Angle 74A350865-2009	HLT313DL-10-17 0.040 Sheet	7075-T6 Alclad
19		Angle 74A350865-2005, -2006	0.040	7075-T6 Alclad
20	6	Cover (Door 7) 74A314854-2017 -2018	Sheet	6061-T6 Alclad
21	6	Faring (Door 96) 74A314854-2003	Sheet	7075-T6 Al Aly
22	8	Cover (Door 130) 9M789M181-5	0.051 Sheet	7075-T6 Alclad
<p style="text-align: center;">LEGEND</p> <p>1 Lands are 0.063 and bays are 0.046.</p> <p>2 F/A-18B 161354 THRU 161360.</p> <p>3 F/A-18B 161704 AND UP.</p> <p>4 Lands are 0.063 and bays are 0.045.</p> <p>5 F/A-18A.</p> <p>6 F/A-18B.</p> <p>7 Skin thickness as shown on Figure 1.</p> <p>8 163119 AND UP ONLY. Covers prior to 163119 have no assigned designation.</p>				

Figure 1. Material Index (Sheet 8)

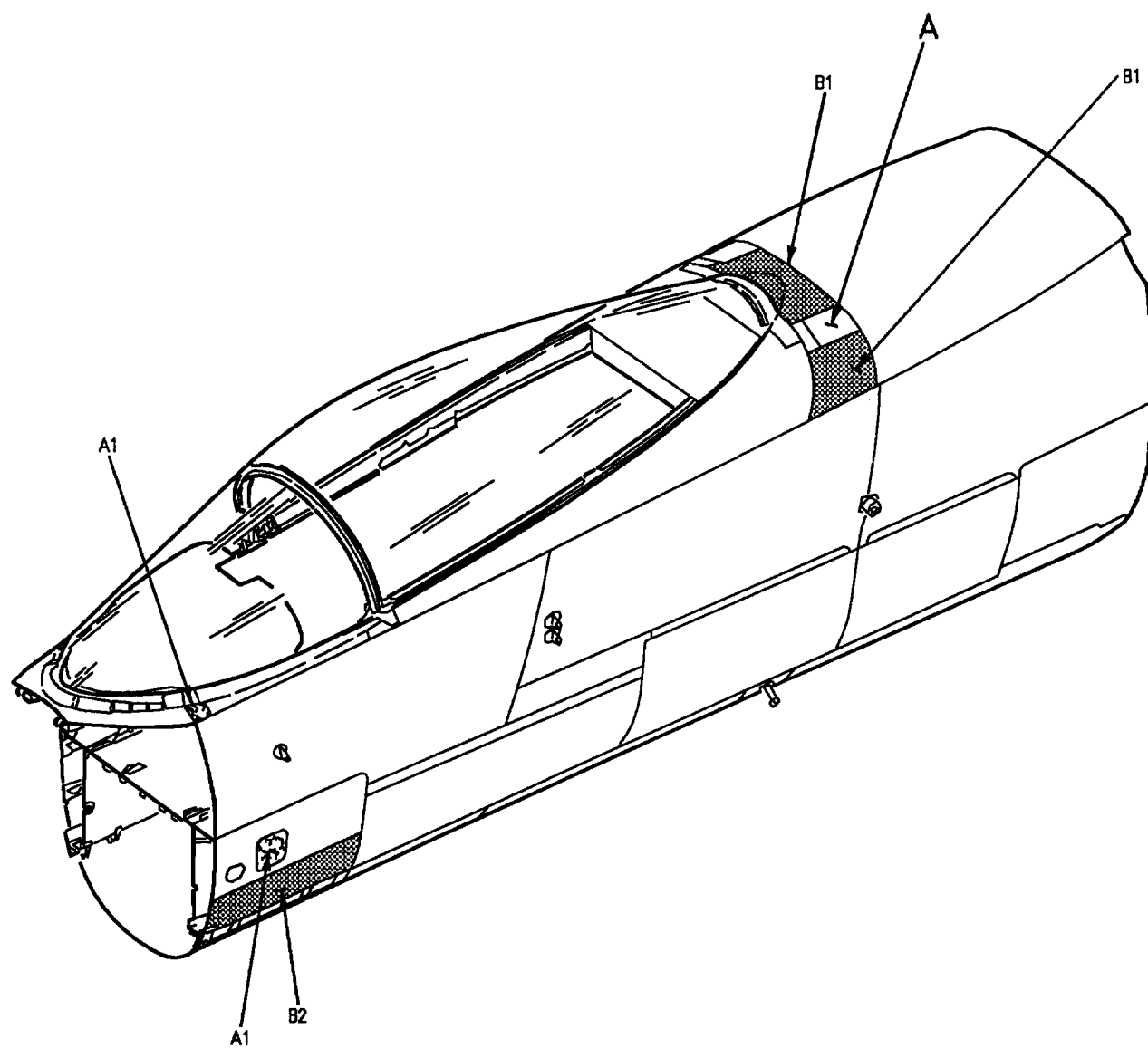


Figure 2. Repair Zones (Sheet 1)

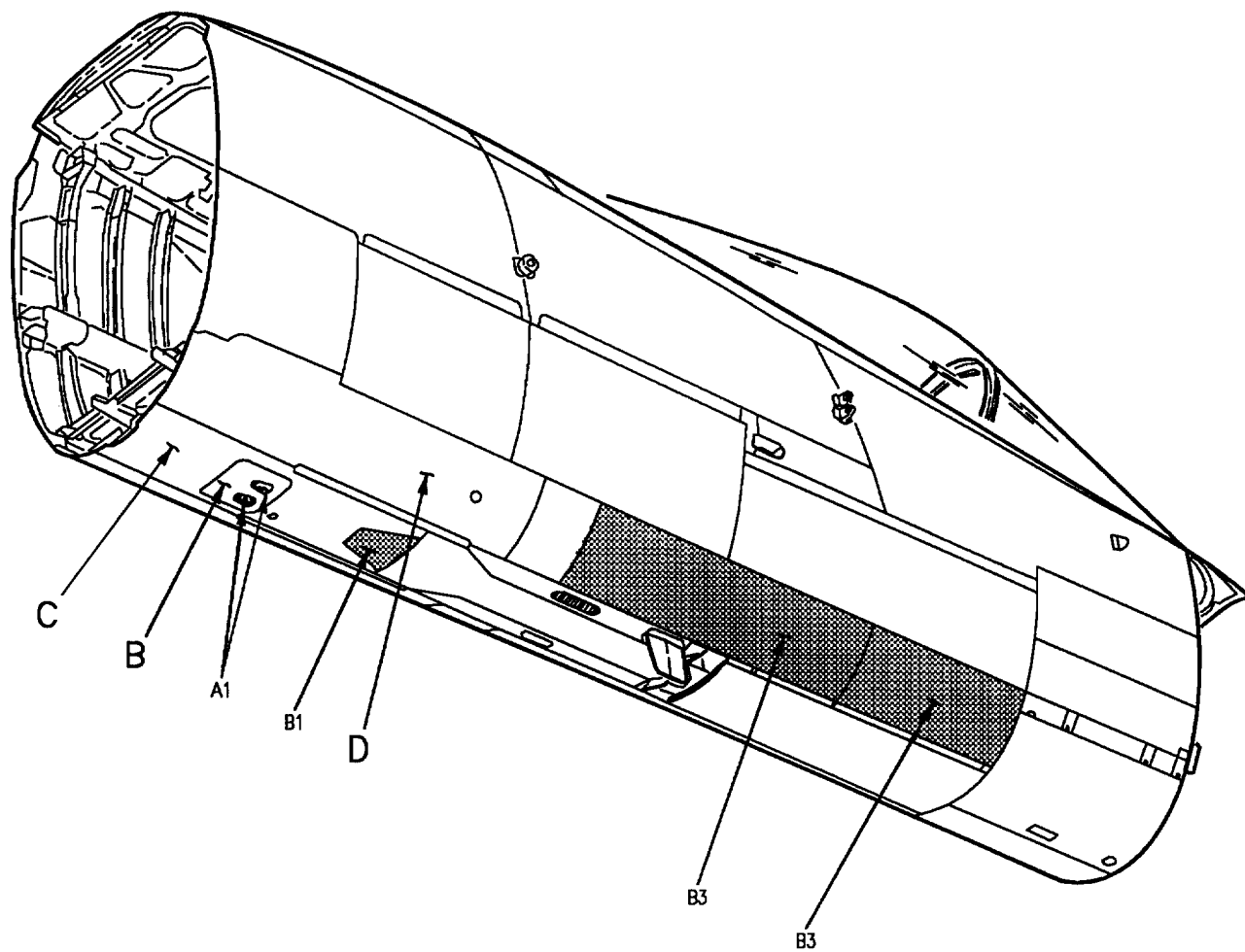


Figure 2. Repair Zones (Sheet 2)

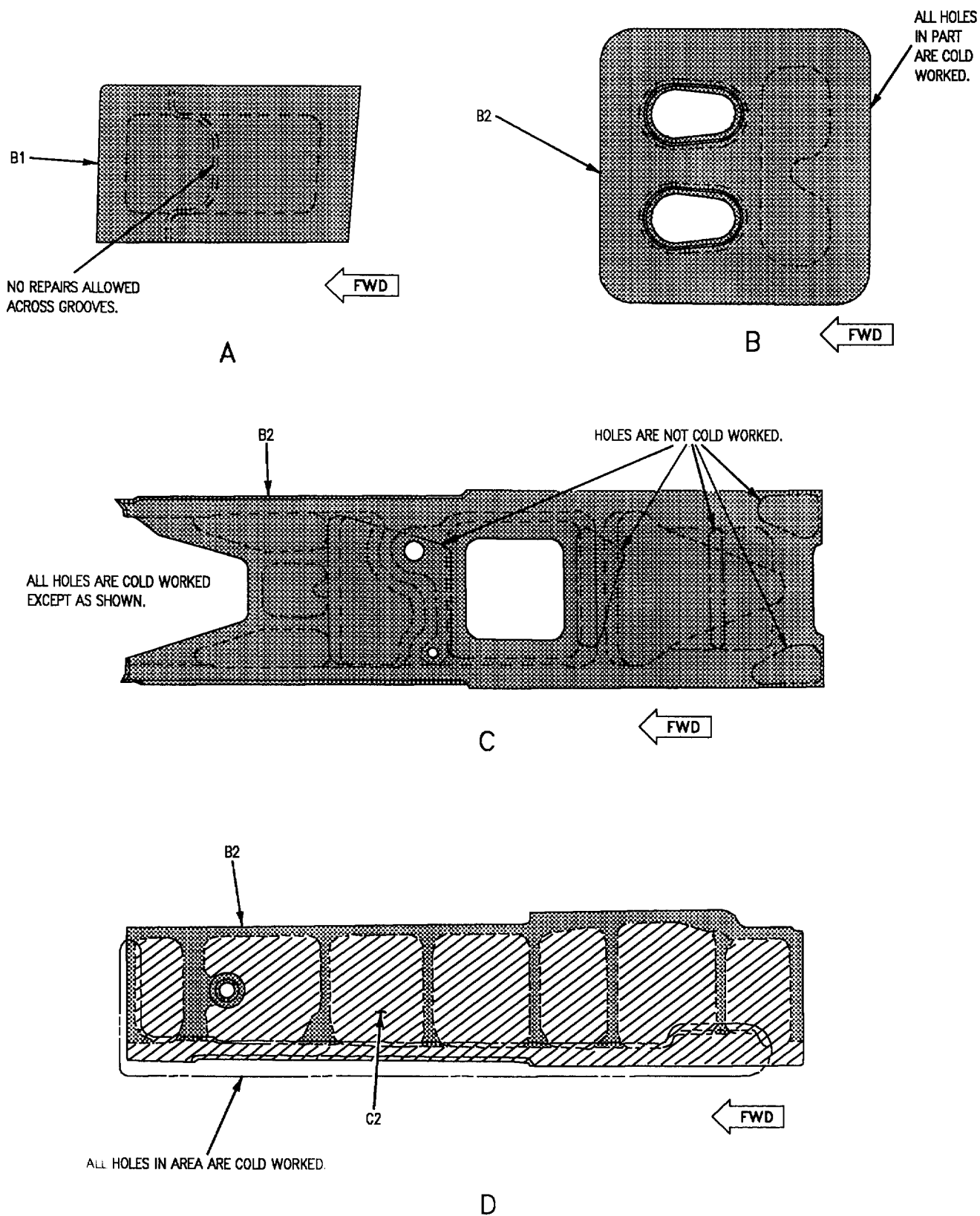


Figure 2. Repair Zones (Sheet 3)

ORGANIZATIONAL MAINTENANCE
STRUCTURE REPAIR**FORWARD FUSELAGE EXTERNAL NUMBERED
METAL DOORS REPLACEMENT**

Reference Material

Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Windshield Panel, Aircraft - Inst of	FIG 007 00
Fuselage Section - Fwd Fus, Structure	FIG 023 00
Door, Access - External Power Recp, Fwd Fus, Instl of	FIG 033 00
Deck Assy - Canopy Sill, Fwd Fus, F/A-18A (Y260.677 to Y383.000)	FIG 035 00
Deck Assy - Canopy Sill, Fwd Fus, F/A-18B (Y365.700 to Y383.000)	FIG 037 00
Skin, Aircraft - Fwd Fus, Lwr, Y332.880 to Y383.000, Assy of	FIG 039 00
Skin, Aircraft - Lwr, Fwd Fus, Y204.500 to Y233.700, Instl of	FIG 043 00
Skin, Aircraft - Fwd Fus, Lwr, Y233.700 to Y260.677, Instl of	FIG 044 00
Skin, Aircraft - Fwd Fus, Lwr, Y260.677 to Y311.000, Instl of	FIG 045 00
Skin, Aircraft - Fwd Fus, Lwr, Y326.500 to Y383.00, Assy of	FIG 046 00
Structure Repair, General Information	A1-F18AC-SRM-200
Locating Blind Holes and Trim Lines	WP004 03
Gang Channel and Plate Nut Identification and Repair	WP004 05
Adhesive, Cement, and Sealant; Preparation and Application	WP011 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Form In Place Sealing	WP010 00
Windshield, Canopy, and Cockpit Finish System	WP021 00
Line Maintenance Access Doors	A1-F18AC-LMM-010
Seat, Canopy, Survival Equipment and Boarding Ladder	A1-F18AC-120-300
Canopy Jettison Rocket Motor	WP092 00

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Cover (Door 7) F/A-18B	2
Cover (Door 16)	2
Cover (Door 17) F/A-18A	2
Cover (Door 24)	2
Cover (Door 85) F/A-18B	3
Cover (Door 108)	3
Cover (Door 141)	3
Door 9	2
Fairing (Door 96) F/A-18B	3
Skin (Door 11)	2

Alphabetical Index (Continued)

Subject	Page No.
Skin (Door 25)	2
Skin (Door 30)	3
Skin (Door 33)	3
Skin (Door 35)	3
Skin (Door 96) F/A-18A	3

Record of Applicable Technical Directives

None

1. REPLACEMENT.

2. Fastener attaching hardware is shown for covers, skins, and doors as follows. Replaceable doors require drilling and/or trimming. For locating blind holes and trim lines (A1-F18AC-SRM-200, WP004 03). For form in place sealing (A1-F18AC-SRM-500, WP010 00). For replacement rivets attaching plate nuts, gang channels or receptacles not shown in figure 1 thru 14 (A1-F18AC-SRM-200, WP004 05).

3. **COVER (DOOR 7) F/A-18A.** Cover is interchangeable. Fastener attaching hardware is shown on figure 1. For fasteners (A1-F18AC-SRM-420, FIG 035 00).

4. **COVER (DOOR 7) F/A-18B.** Cover is interchangeable. Fastener attaching hardware is shown on figure 1. For fasteners (A1-F18AC-SRM-420, FIG 037 00).

5. DOOR 9.

a. Door is interchangeable and spared with two MS20426AD6-8 rivets bagged and attached with door for installation of electrical jumpers, see figure 2. For fasteners (A1-F18AC-SRM-420, FIG 033 00). Adjust bolt on latch until force required to unlatch door is 32 pounds, plus or minus 5 pounds using spring resiliency tester.

6. **SKIN (DOOR 11).** Skin is replaceable and requires trimming and drilling. Skin is spared with two pilot holes and has 1.00 inch excess material on the forward, aft, and lower edge of part. Fastener attaching hardware is shown on figure 3. For fasteners (A1-F18AC-SRM-420, FIG 043 00).

7. **COVER (DOOR 16).** Cover is replaceable and may require trimming of the forward edge to align with the trim of 74A314282 skin. Fastener attaching hardware is shown on figure 4. For fasteners (A1-F18AC-SRM-420, FIG 023 00).

8. **COVER (DOOR 17) F/A-18A.** Cover is interchangeable. Fastener attaching hardware is shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 035 00).

9. **COVER (DOOR 24).** Cover is replaceable and requires trimming a maximum of 0.125 inch of material from lower edge of cover on installation. Fastener attaching hardware is shown on figure 6. For fasteners (A1-F18AC-SRM-420, FIG 007 00).

10. **SKIN (DOOR 25).** Skin is replaceable and requires trimming and drilling. Skin is spared with two pilot holes and has excess material on the forward, upper, and lower edge of parts. Fastener attaching hardware is shown in figure 7. For fasteners (A1-F18AC-SRM-420, FIG 044 00).

Support Equipment Required

Part Number or Type Designation	Nomenclature
DPP-50	Spring Resiliency Tester

Materials Required

None

11. **SKIN (DOOR 30).** Skin is replaceable and requires trimming and drilling. Skin is spared with two pilot holes and has 0.250 inch excess material on lower edge of part and 1.000 inch excess material on upper edge of part. Fastener attaching hardware is shown on figure 8. For fasteners (A1-F18AC-SRM-420, FIG 045 00).

12. **SKIN (DOOR 33).** Skin is replaceable at depot level. Skin requires trimming, drilling and cold work of fastener holes. Fastener attaching hardware is replaced at organizational maintenance, see figure 9. For fasteners (A1-F18AC-SRM-420), FIG 039 00).

13. **SKIN (DOOR 35).** Skin is replaceable and requires trimming and drilling. Fastener attaching hardware is shown on figure 10. For fasteners (A1-F18AC-SRM-420, FIG 046 00).

14. **SKIN (DOOR 96) F/A-18A.** Skin is replaceable and requires trimming and drilling. Skin is spared with 0.250 inch excess material on the aft and outboard edges of part. All holes are omitted. Fastener attaching hardware is shown on figure 11. For fasteners (A1-F18AC-SRM-420, FIG 035 00).

15. **FAIRING (DOOR 96) F/A-18B.** Fairing is replaceable and requires trimming and drilling. Fairing is spared with two pilot holes and has 1.00 inch excess material on aft edge of part, 0.050 inch excess material on sides aft of Y376.050 and 0.250 inch excess material on all other sides forward of Y376.050. Fastener attaching hardware is shown on figure 11. For fasteners (A1-F18AC-SRM-420, FIG 037 00).

16. **COVER (DOOR 108).** Cover is replaceable and requires drilling. Cover is spared with two pilot holes and one 0.250 inch diameter drain hole. All other holes are omitted. Fastener attaching hardware is shown on figure 12. For fasteners (A1-F18AC-SRM-420, FIG 023 00).

17. **COVER (DOOR 141).** Doors interchangeable. Fastener attaching shown on figure 13. For fasteners (A1-F18AC-SRM-420, FIG 023 00).

18. **COVER (DOOR 85) F/A-18B.** Cover is replaceable and requires trimming and drilling. Cover is spared with angles, washer, rivets, bolts, plate nuts and gang channels as a loose part kit. See figure 14.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
---------------------------------	--------------

74A350865-1001, -1002	Cover Assembly
-----------------------	----------------

a. Remove canopy jettison rocket motor (A1-F18AC-120-300, WP092 00).

NOTE

Cover is spared with 0.250 inch excess material on the aft and lower edge of part.

b. Remove existing form in place seal and make sure door sill is clean and free of any residual sealing compound.

c. Position cover in place and locate trim lines on the aft and lower edge of part (A1-F18AC-SRM-200, WP004 03).

d. Position and secure angles on structure to make sure the pilot holes in angles align with the existing holes in structure.

e. Position cover in place and check for contour smoothness making sure angles are flush with inner surface of cover.



Use care when mate drilling not to damage existing holes.

f. Mate drill 0.195 +0.007 -0.000 inch diameter holes in angles using existing holes in structure as guide.

g. Secure angles to structure with temporary fasteners.

h. Position cover in place and locate blind holes (A1-F18AC-SRM-200, WP004 03).

i. Countersink holes in cover to flushness requirements of fastener.

j. Install fasteners as needed to securely hold cover in place.

k. Lay out rivet pattern where angles attach to cover.

l. Drill 15 holes where angles attach to cover.

m. Countersink holes in cover to the flushness requirements of fastener.

n. Remove cover and angles.

o. Locate and drill attachment holes for plate nuts. See detail A.

p. Apply finish system to angles and cover as required (A1-F18AC-SRM-500, WP021 00).

q. Wet install rivets holding angles to cover (A1-F18AC-SRM-200, WP011 00).

r. Install plate nuts on angles.

s. Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

t. Apply form in place seal (A1-F18AC-SRM-500, WP010 00).

u. Install canopy jettison rocket motor (A1-F18AC-120-300, WP092 00).

v. Install door 85 (A1-F18AC-LMM-010).

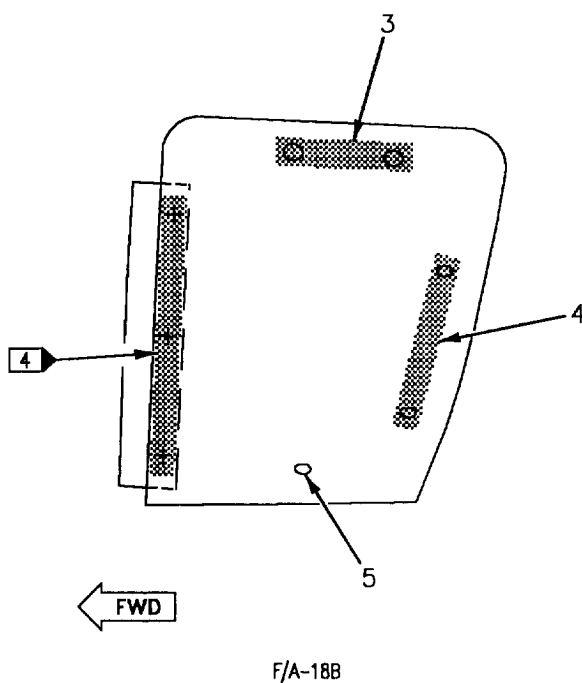
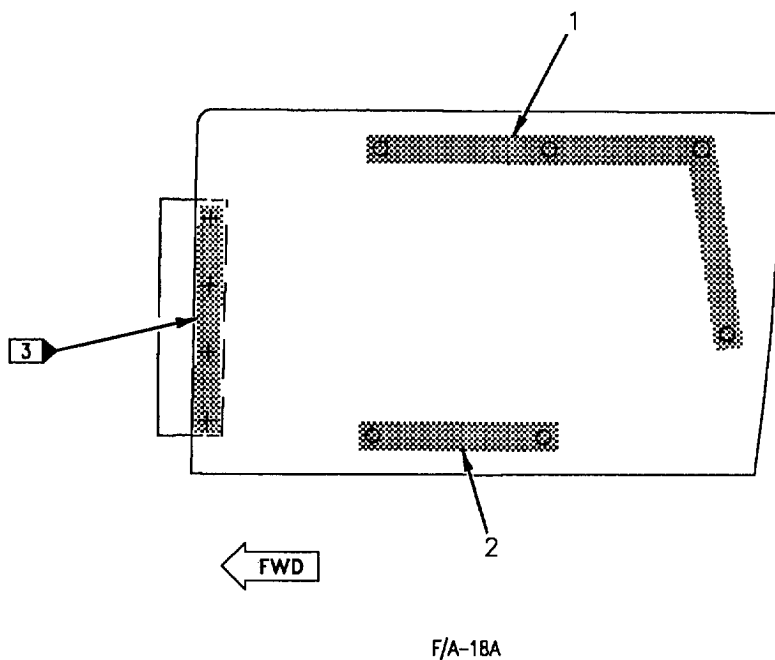


Figure 1. Cover (Door 7), Replacement (Sheet 1)











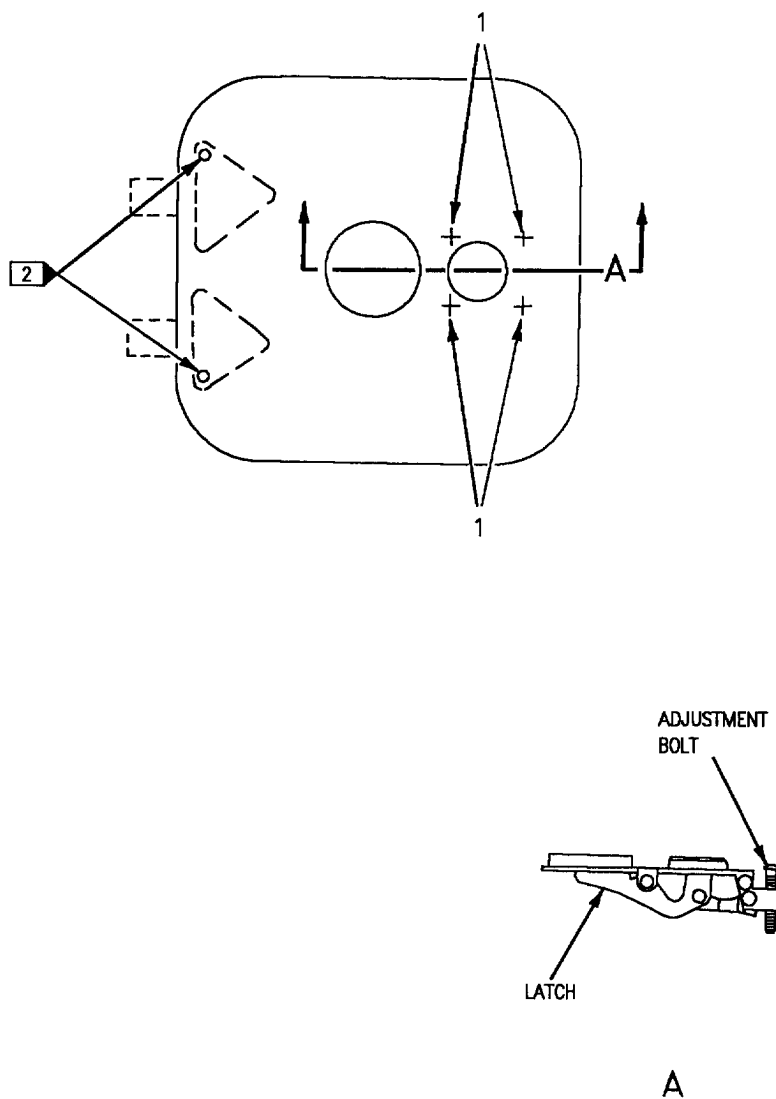
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49069N4-2
2		 	Plate Nut Shim	F49069N-4-2 NAS463XDD416
3			Gang Channel	G14421-1-4F122
4			Plate Nut	F14421-1-4
5			Plate Nut	RMF19427-1-4
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.255 +0.007 -0.000 in door and 0.250 +0.006 -0.000 in structure.</p> <p> Attached with CSR904B3-5 rivets.</p> <p> Attached with BRFS5AD rivets.</p> <p> Attached with MS20426AD5 rivets.</p>				

Figure 1. Cover (Door 7), Replacement (Sheet 2)



18AC-SRM-222-(37-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Rivet	MS20426AD4
LEGEND				
Hole diameter is 0.0128 +0.006 -0.000.				
Hole diameter is 0.191 +0.006 -0.000 inch for MS20426AD6-8 rivet attaching electrical jumper.				

Figure 2. Door 9, Latch Replacement

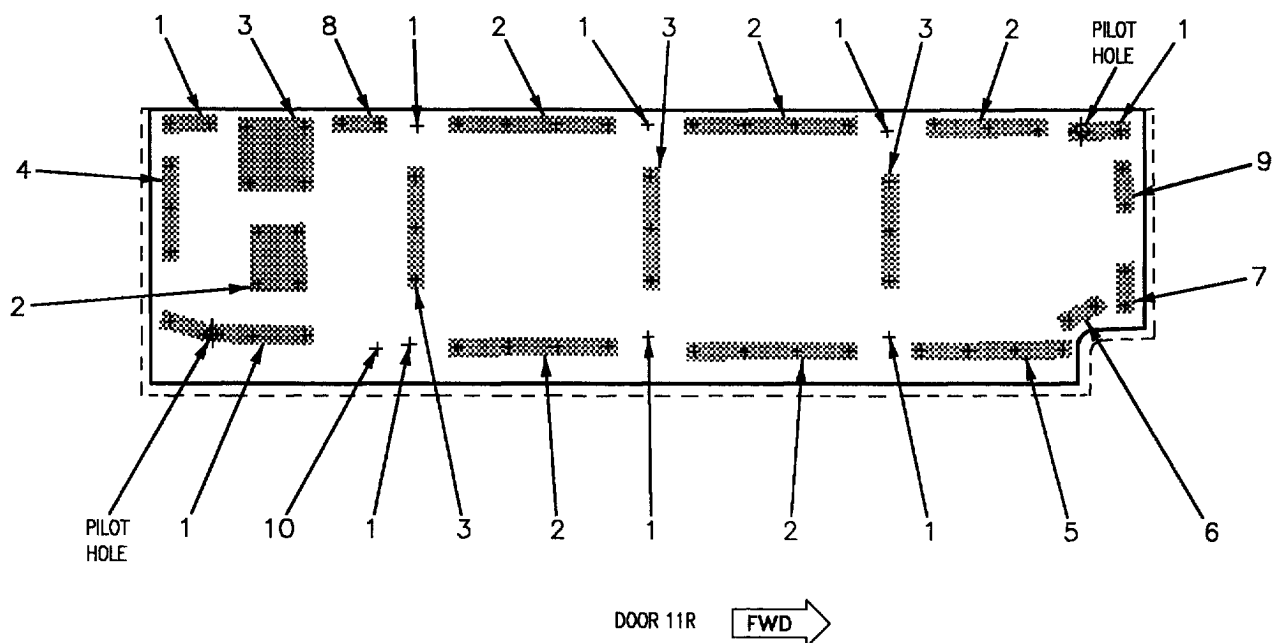
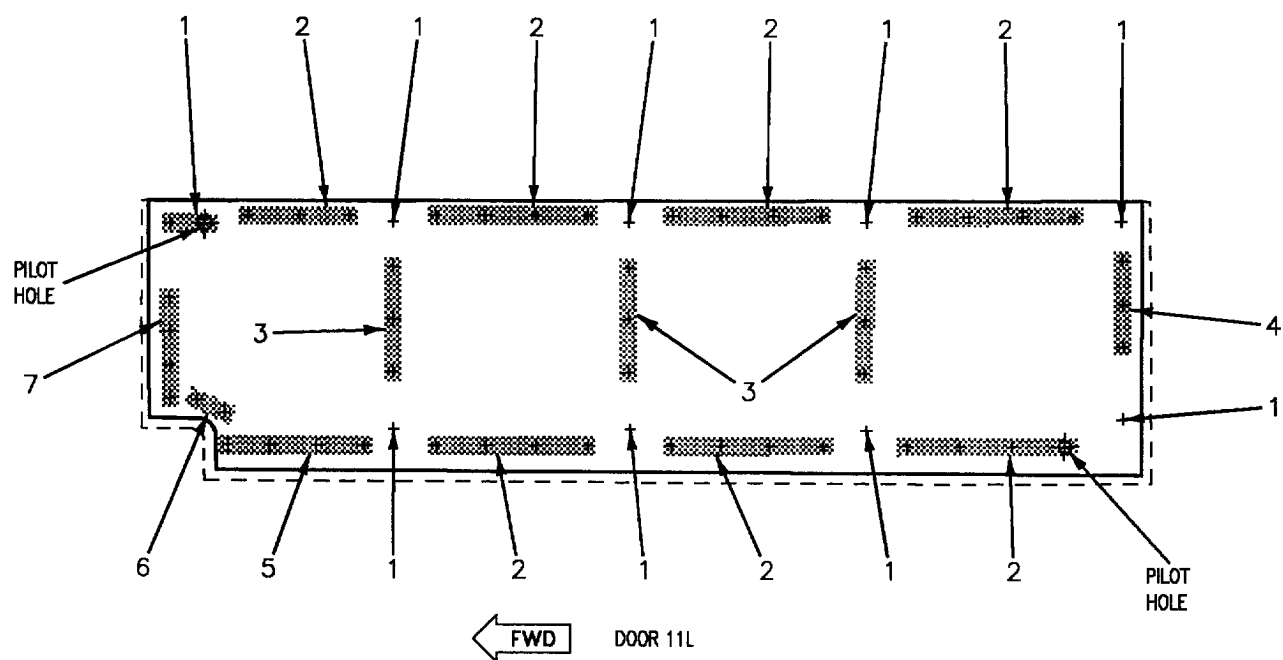


Figure 3. Skin (Door 11), Replacement (Sheet 1)












IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50339-3-2
2			Gang Channel	G50344-3-1-12
3			Gang Channel	G50344-3-2-12
4			Gang Channel	G50344-3-2-10
5			Gang Channel	G50344-3-1-11
6			Gang Channel	G50344-3-1-7
7			Gang Channel	G50344-3-2-8
8			Gang Channel	G50344-3-1-9
9			Gang Channel	G50344-3-2-7
10			Plate Nut	F50340-3-2
LEGEND				
 Hole diameter is 0.191 +0.006 -0.000.				

Figure 3. Skin (Door 11), Replacement (Sheet 2)

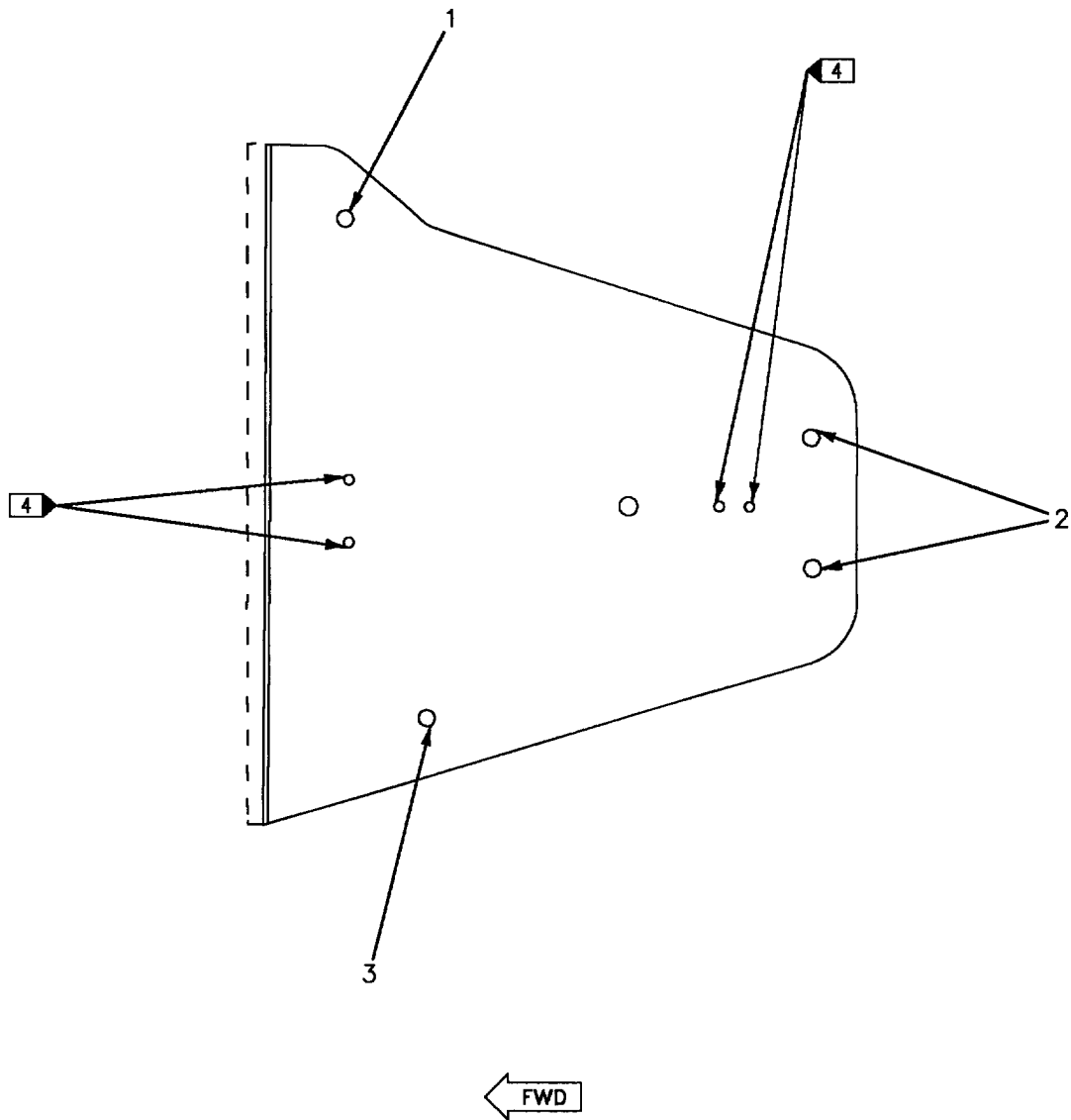
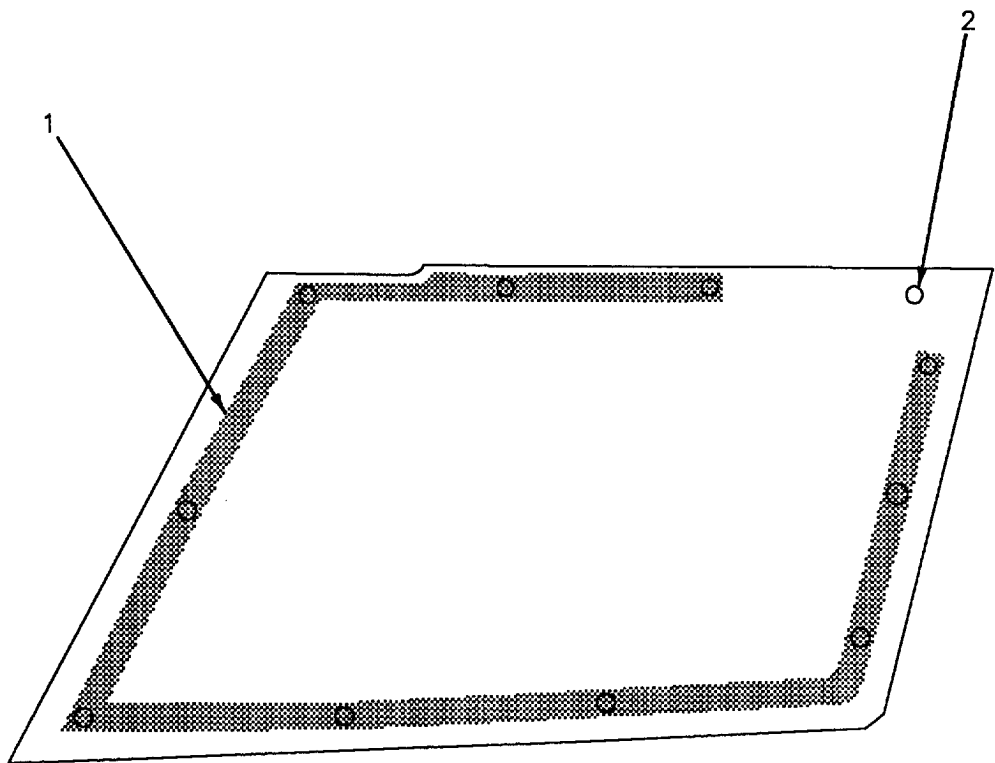


Figure 4. Cover (Door 16), Replacement (Sheet 1)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1	<div>2</div> <div>3</div>	<div>1</div> <div>1</div>	Receptacle <div>5</div> Receptacle <div>5</div>	196012-6-9-01 196012-6-9-0
2	<div>2</div> <div>3</div>	<div>1</div> <div>1</div>	Receptacle <div>5</div> Receptacle <div>5</div>	195012-6-9-01 195012-6-9-1
3	<div>2</div> <div>3</div>	<div>1</div> <div>1</div>	Receptacle <div>5</div> Receptacle <div>5</div>	195012-6-9-2 195012-6-9-4
<p style="text-align: center;">LEGEND</p> <div>1</div> Hole diameter is 0.377 +0.007 -0.000. <div>2</div> 161353 THRU 161987. <div>3</div> 162394 AND UP. <div>4</div> Brackets attached with BRFS4AD rivets. <div>5</div> Attach with BRFS4AD rivets.				

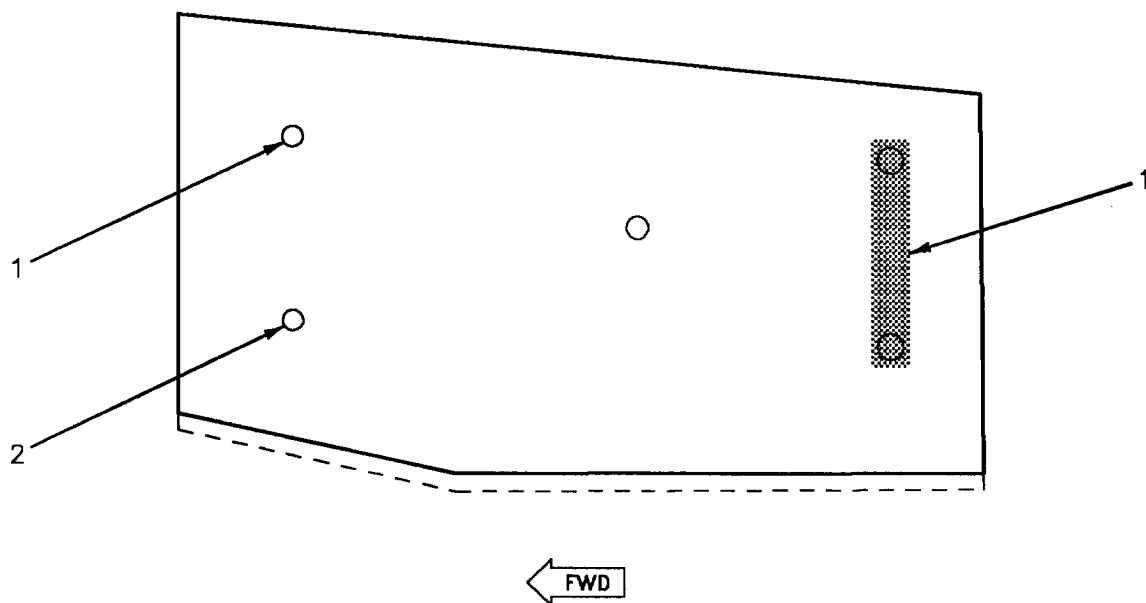
Figure 4. Cover (Door 16), Replacement (Sheet 2)



18AC-SRM-222-(40-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49069N4-2
2			Plate Nut	F39879N4-2
LEGEND				
Hole diameter is 0.255 +0.007 -0.000.				

Figure 5. Cover (Door 17), Replacement



18AC-SRM-222-(41-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50340-3-1
2			Plate Nut	F50339-3-1
LEGEND				
Hole diameter is 0.196 +0.006 -0.000.				

Figure 6. Cover (Door 24), Replacement

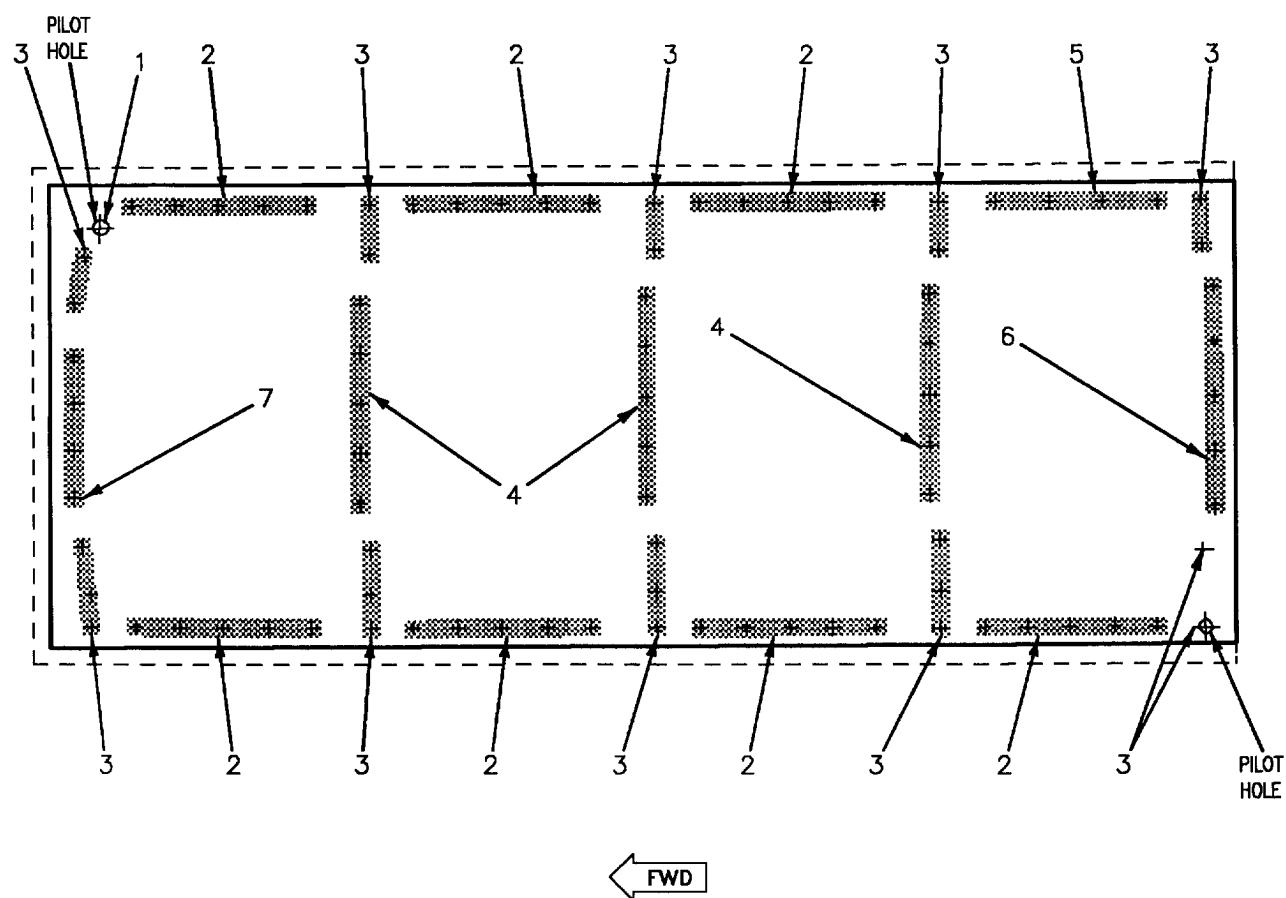


Figure 7. Skin (Door 25), Replacement (Sheet 1)























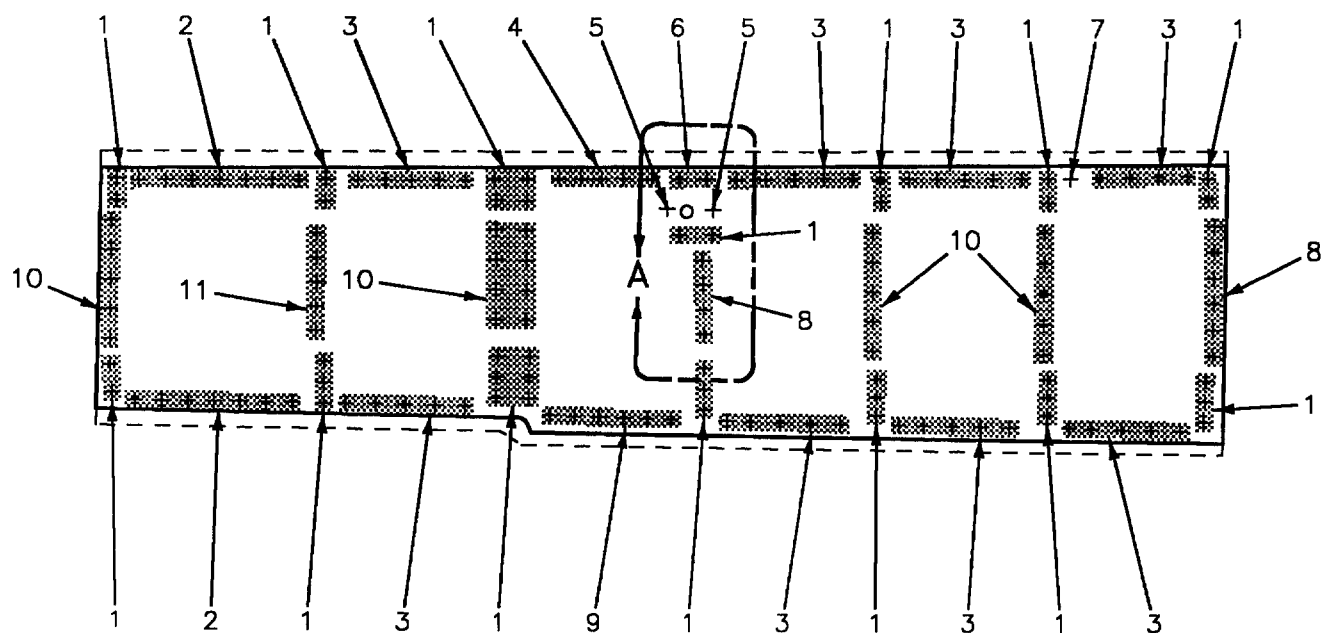
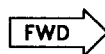
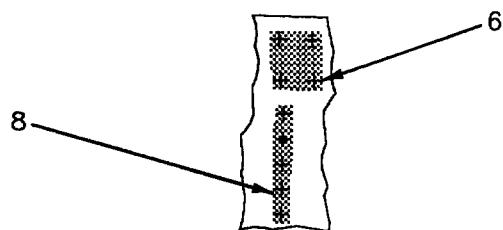
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50340-3-2
2			Gang Channel	G50344-3-2-8
3			Plate Nut	F50339-3-2
4	  	 	Gang Channel Gang Channel Shim	G50344-3-2-9 G50344-3-1-9 4M49A3DL9-5
5			Gang Channel	G50344-3-2-10
6	  	 	Gang Channel Gang Channel Shim	G50344-3-2-10 G50344-3-1-9 4M49A3DL10-5
7	  	 	Gang Channel Gang Channel Shim	G50344-3-2-9 G50344-3-1-9 4M49A3DL9-4
LEGEND				
 Hole diameter is 0.191 +0.006 -0.000.  161353 THRU 162426, 162428.  162427, 162429 AND UP.				

Figure 7. Skin (Door 25), Replacement (Sheet 2)



DOOR 30L/R



DOOR 30R

A

Figure 8. Skin (Door 30), Replacement (Sheet 1)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50339-3-2
2			Gang Channel	G50344-3-2-9
3			Gang Channel	G50344-3-2-10
4			Gang Channel	G50344-3-2-8
5			Plate Nut	F50403-3-2
6			Plate Nut Spacer	F50339-3-1 74A314219-2009
7			Plate Nut	F50340-3-2
8	 	 	Gang Channel Gang Channel Shim	G50344-3-2-9 G50344-3-1-9 4M49A3KM9
9	 	 	Gang Channel Gang Channel Shim	G50344-3-1-8 G50344-3-2-8 4M49A3DT8
10	 	 	Gang Channel Gang Channel Shim	G50344-3-2-10 G50344-3-1-10 4M49A3KM10
11	 	 	Gang Channel Gang Channel Shim	G50344-3-2-8 G50344-3-1-8 4M49A3KM8
<p style="text-align: center;">LEGEND</p> <p> Hole diameter 0.191 +0.006 -0.000.</p> <p> 162427, 162429 AND UP.</p> <p> Two required on L/H door, four required on R/H door.</p> <p> 162399 AND UP.</p> <p> 161353 THRU 162426, 162428.</p> <p> 161524 AND UP.</p> <p> 161353 THRU 161523.</p>				

Figure 8. Skin (Door 30), Replacement (Sheet 2)

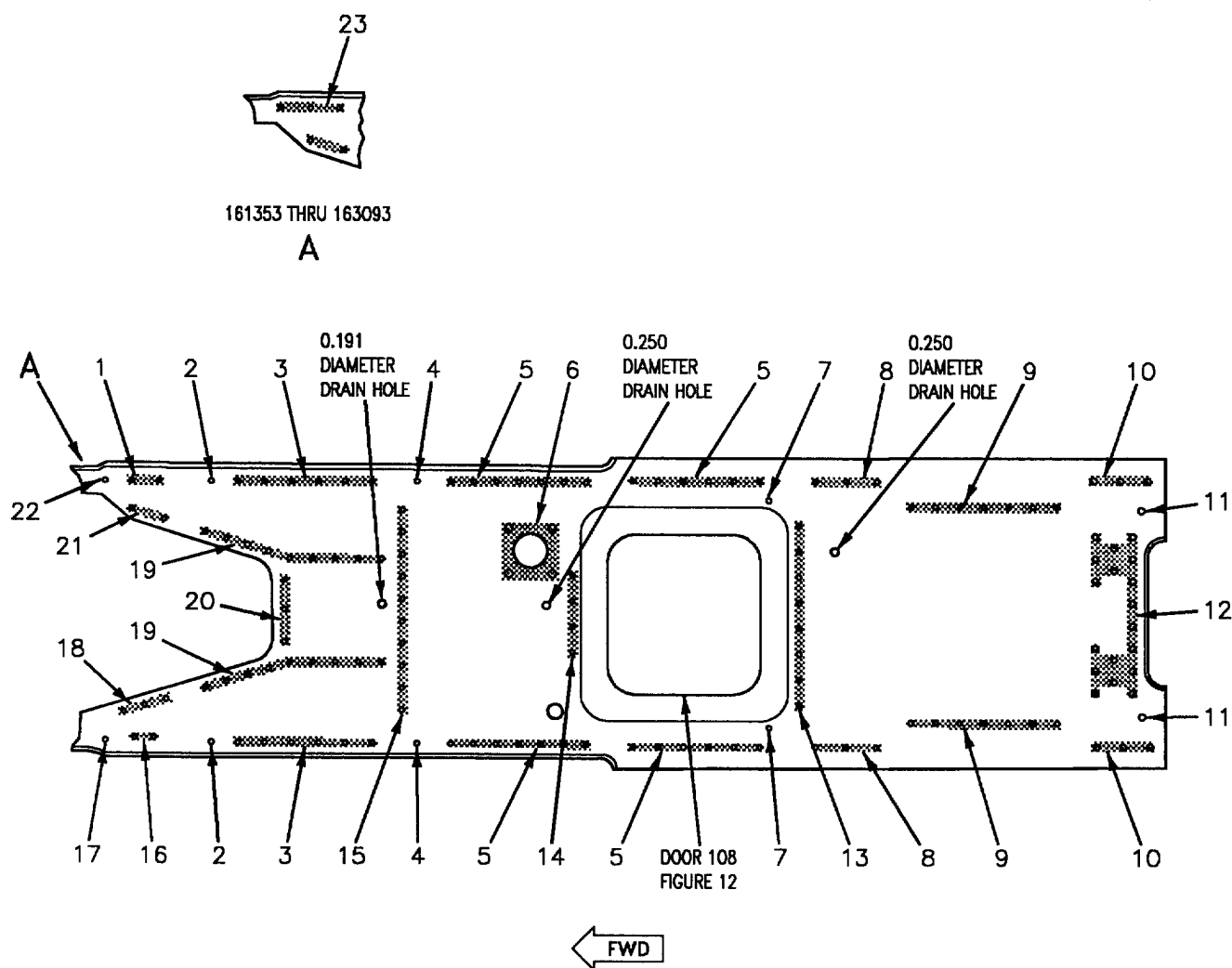


Figure 9. Skin (Door 33), Replacement (Sheet 1)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1	17	1	Gang Channel Spacer	G50344-5-1-10 4M49F5KT10-2
2		2	9 Plate Nut	F50339-4-2
3		3	9 Gang Channel	G50344-3-2-10
4		3	9 Plate Nut	F50339-3-2
5		3	9 Gang Channel	G50344-3-2-9
6	5 6 6	4 4	Nut Plate Nut Shim	MS21059L3 F50405-3 NAS463XDD10H
7		3	Plate Nut	F50339-3-2
8		3	9 Plate Nut	F50405-3
9		3	9 Gang Channel	G50344-3-1-9
10		2	9 Gang Channel	G50344-4-2-10
11		2	Plate Nut	F50339-4-2
12		2	Gang Channel Spacer	G50344-4-1-8 4M49F4DM8
13		3	Gang Channel	G50344-3-1-10
14		3	Gang Channel	G50344-3-1-9
15		3	Gang Channel Shim	G50344-3-1-8 4M49A3KM8-5
16	11 12 14	2	9 Gang Channel Gang Channel Shim	G50344-4-2-8 G50344-4-1-8 4M49A4KM8-2
17		1	10 Plate Nut	F50339-5-2
18	14	3	Gang Channel Shim Shim	G50344-3-1-7 4M49A3KL7-3 4M49A3KM7-3
19		3	Gang Channel	G50344-3-1-8
20		3	Plate Nut	F50405-3

Figure 9. Skin (Door 33), Replacement (Sheet 2)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
21	<div>16</div> <div>15</div>	<div>3</div> <div>3</div>	Gang Channel Gang Channel	G50344-3-1-12 G18421JL1-3-12
22	<div>17</div>	<div>1</div>	Plate Nut Spacer	F50403-5-1 NAS463FD516L
23	<div>7</div> <div>8</div> <div>13</div>	<div>1</div> <div>1</div>	Gang Channel Gang Channel Spacer	G50344-5-1-10 G18421JL1-5-10 4M49A5KT10-3
LEGEND <div> <div>1</div> Hole diameter is 0.312 +0.007 -0.000. <div>2</div> Hole diameter is 0.250 +0.006 -0.000. <div>3</div> Hole diameter is 0.191 +0.006 -0.000. <div>4</div> Hole diameter is 0.201 +0.006 -0.000. <div>5</div> 161353 THRU 161736. <div>6</div> 161737 AND UP. <div>7</div> 161353 THRU 161951, 162827, 162830 THRU 163093. <div>8</div> 161952 THRU 162826, 162828, 162829. <div>9</div> Attached with CSR902B3 rivet, length to be determined on installation. <div>10</div> Attached with BRFS4T rivet, length to be determined on installation. <div>11</div> 161353 THRU 161981, 162402. <div>12</div> 161982 AND UP. <div>13</div> 162827, 162830 THRU 163093. <div>14</div> 162903 AND UP. <div>15</div> 161353 THRU 162826, 162828, 162829. <div>16</div> 162827, 162830 AND UP. <div>17</div> 163094 AND UP. </div>				

Figure 9. Skin (Door 33), Replacement (Sheet 3)

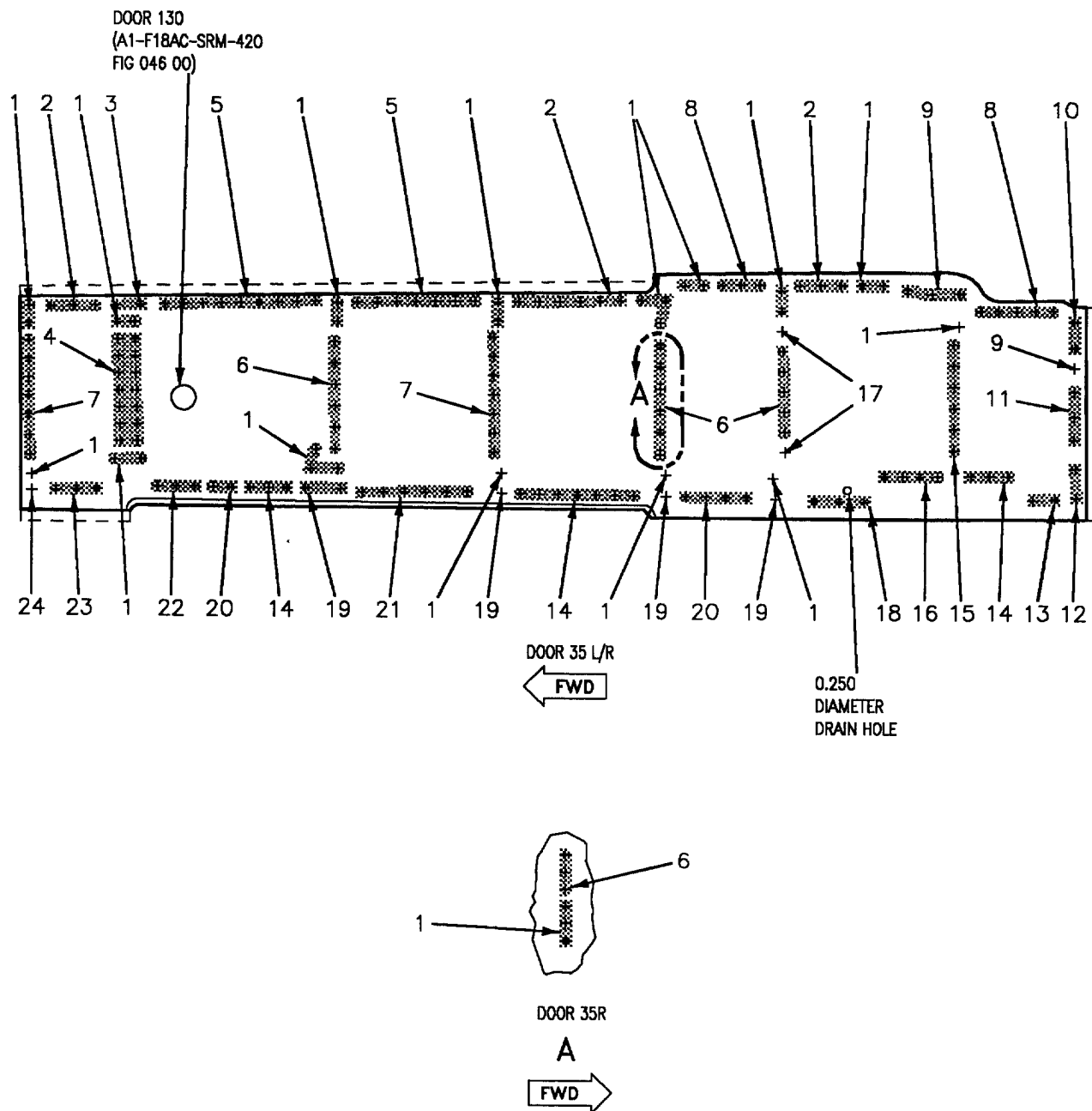


Figure 10. Skin (Door 35), Replacement (Sheet 1)























































IDX NO.	EFT		NOMENCLATURE	PART NUMBER
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2			Gang Channel	G50344-3-2-10
3	 	 	Plate Nut Plate Nut	F49249E3-2 F50339-3-2
4	  	 	Gang Channel Gang Channel Shim	G50344-3-2-8 G50344-3-1-8 4M49A3KL8
5			Gang Channel	G50344-3-2-9
6	  	 	Gang Channel Gang Channel Shim	G50344-3-2-10 G50344-3-1-10 4M49A3KL10
7	  	 	Gang Channel Gang Channel Shim	G50344-3-2-9 G50344-3-1-9 4M49A3KL9
8			Gang Channel	G50344-3-2-8
9			Plate Nut	F50339-4-2
10	  	 	Gang Channel Gang Channel Shim	G50344-4-2-8 G50344-4-1-8 4M49F4KM8
11	  	 	Gang Channel Gang Channel Shim	G50344-4-2-11 G50344-4-1-11 4M49A4KM11
12	  	 	Gang Channel Gang Channel Shim	G50344-4-2-12 G50344-4-1-12 4M49F4KM12
13	 		 Gang Channel  Gang Channel	G50344-4-2-9 G50344-4-2-10
14			 Gang Channel	G50344-3-2-9
15	  	 	Gang Channel Gang Channel Shim	G50344-3-2-10 G50344-3-1-10 4M49A3KM10
16			 Gang Channel	G50344-3-2-8
17			Plate Nut	F50339-3-1

Figure 10. Skin (Door 35), Replacement (Sheet 2)






































IDX NO.	EFT		NOMENCLATURE	PART NUMBER
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19			 Plate Nut	F50339-3-2
20			 Gang Channel	G50344-3-4-9
21			 Gang Channel	G50344-3-4-10
22	 	 	 Gang Channel  Gang Channel Spacer	G50344-3-2-9 G50344-3-4-9 74A314415-2003
23			 Gang Channel	G50344-4-2-9
24			 Plate Nut	F50339-4-2
LEGEND				
 Hole diameter is 0.191 +0.006 -0.000.  Hole diameter is 0.250 +0.006 -0.000.  Hole diameter in door and structure is 0.191 +0.006 -0.000. Hole diameter in spacer is 0.195 +0.007 -0.000.  161353 THRU 161359.  161360 AND UP.  Attach with CSR902B3 rivet, length to be determined on installation.  161353 THRU 161724.  161725 AND UP.  161353 THRU 162909.  163092 AND UP.  161353 THRU 161727.  161728 AND UP.  Plate nuts attached to 74A314311-2001 plate assembly which is attached to structure with MS20426T3-8 rivets.  161353 THRU 162892, 162894, 162895, 162897 THRU 162900, 162902, 162903, 162905, 162907, 162909, 163093 THRU 163096, 163098 THRU 163105, 163107 THRU 163111, 163113 THRU 163138, 163140, 163142 THRU 163169, 163171 AND UP.  162893, 162896, 162901, 162904, 162906, 162908, 163092, 163097, 163106, 163112, 163139, 163141, 163170.				

Figure 10. Skin (Door 35), Replacement (Sheet 3)

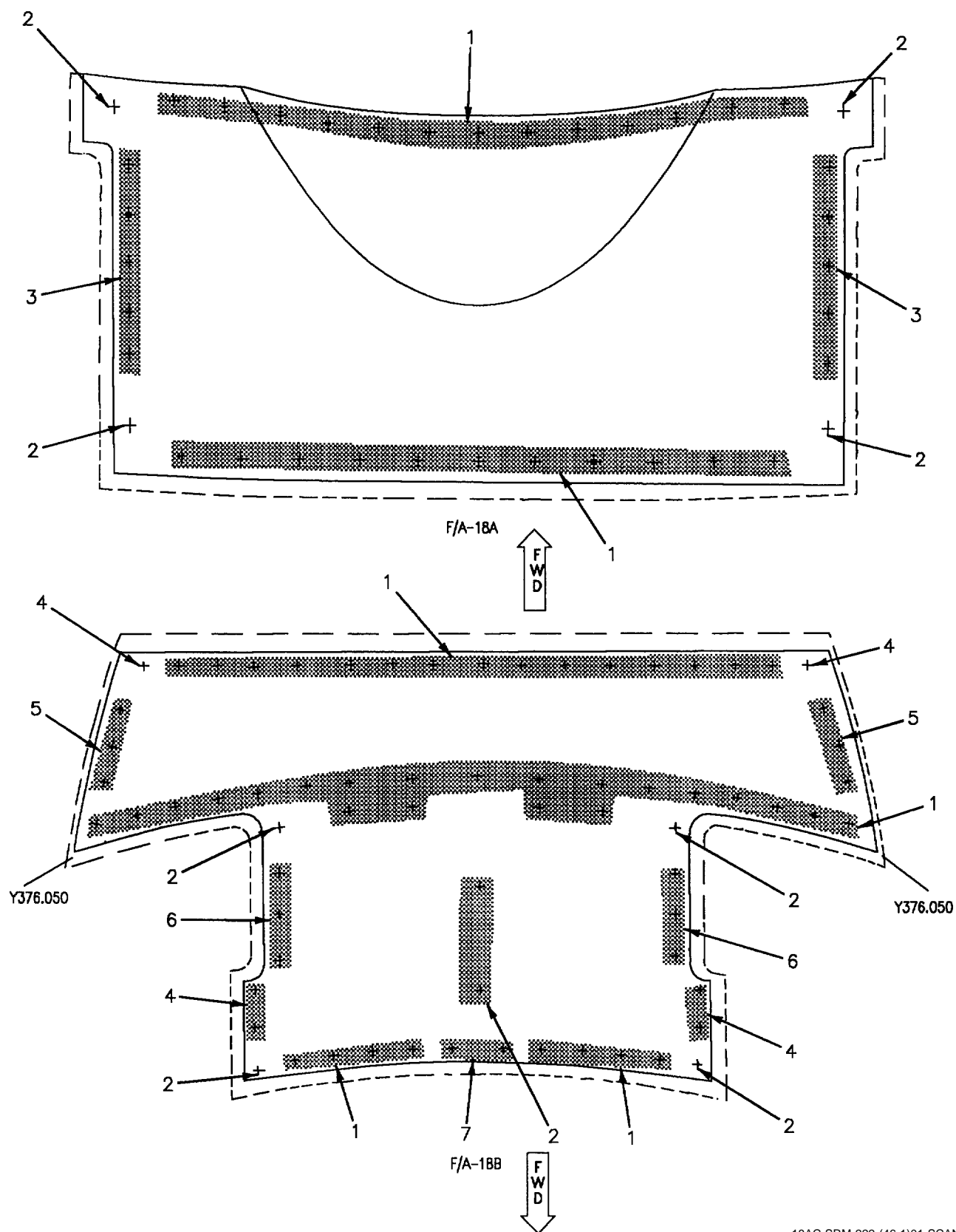


Figure 11. Skin (Door 96), Replacement (Sheet 1)










IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50339-3-2
2			Plate Nut	F50339-3-1
3			Gang Channel	G10851-3-10
4			Plate Nut	F50340-3-1
5			Gang Channel	G1842LJL1-3-9
6			Gang Channel	G18421JL1-3-10
7			Plate Nut	F50340-3-2
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.191 +0.006 -0.000.</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p>				

Figure 11. Skin (Door 96), Replacement (Sheet 2)

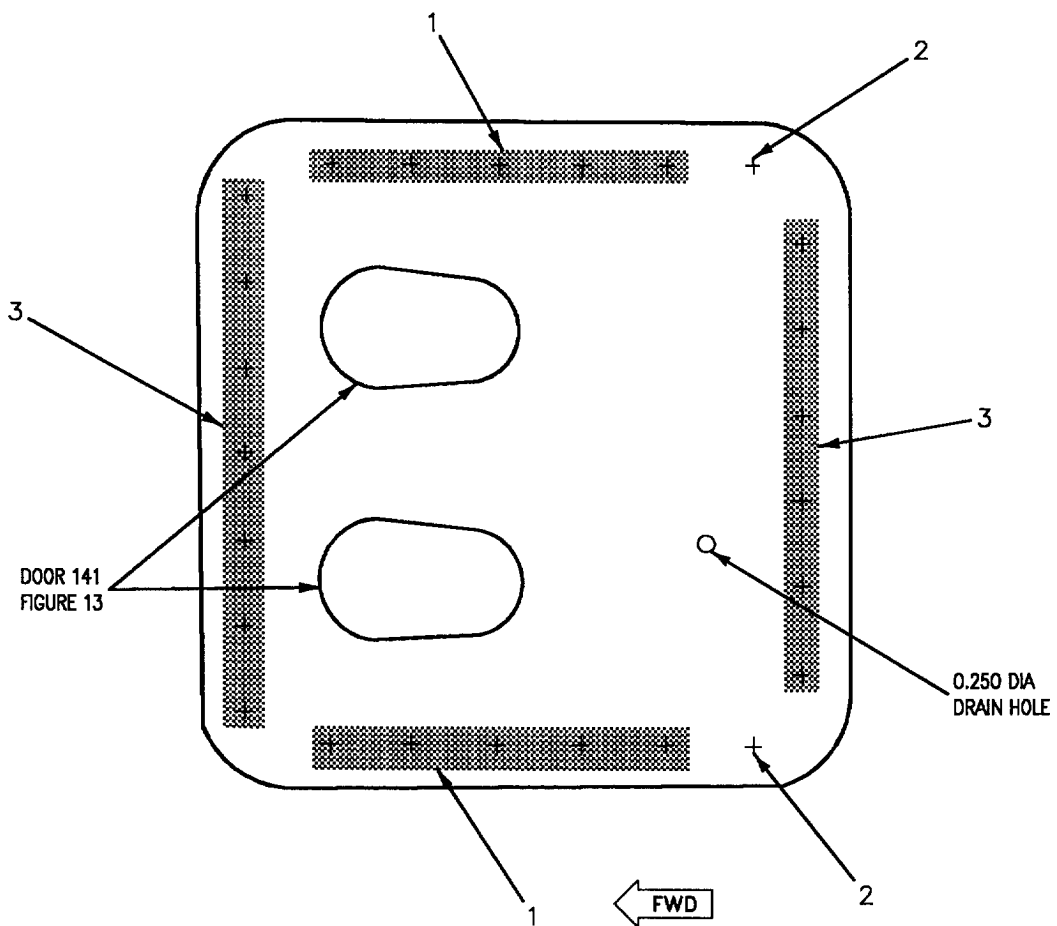
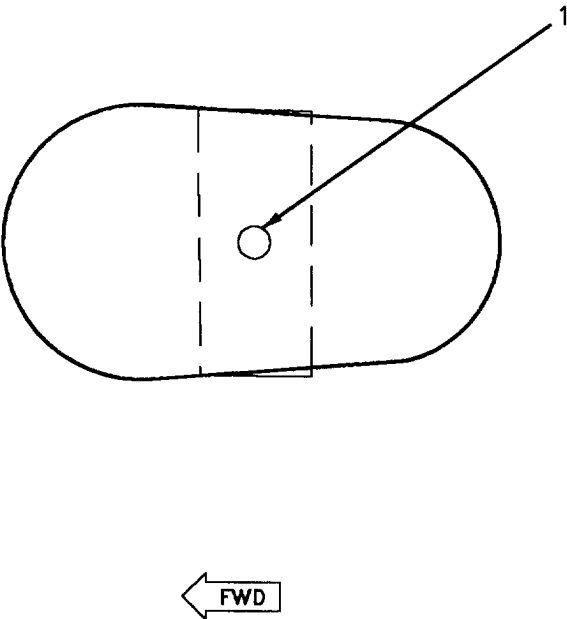


Figure 12. Cover (Door 108), Replacement (Sheet 1)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1	<div>2</div> <div>3</div>	<div>1</div>	Gang Channel Gang Channel	G10851J4-10 G50344-4-2-10
2	<div>2</div> <div>3</div>	<div>1</div>	Plate Nut Plate Nut	F50405-4 F50339-4-1
3	<div>2</div> <div>3</div>	<div>1</div>	Gang Channel Gang Channel	G1085LJ4-10 G50344-4-1-10
<p style="text-align: center;">LEGEND</p> <div>1</div> Hole diameter is 0.250 +0.006 -0.000. <div>2</div> 161353 THRU 161736. <div>3</div> 161737 AND UP.				

Figure 12. Cover (Door 108), Replacement (Sheet 2)



18AC-SRM-222-(48-1)01-CATI



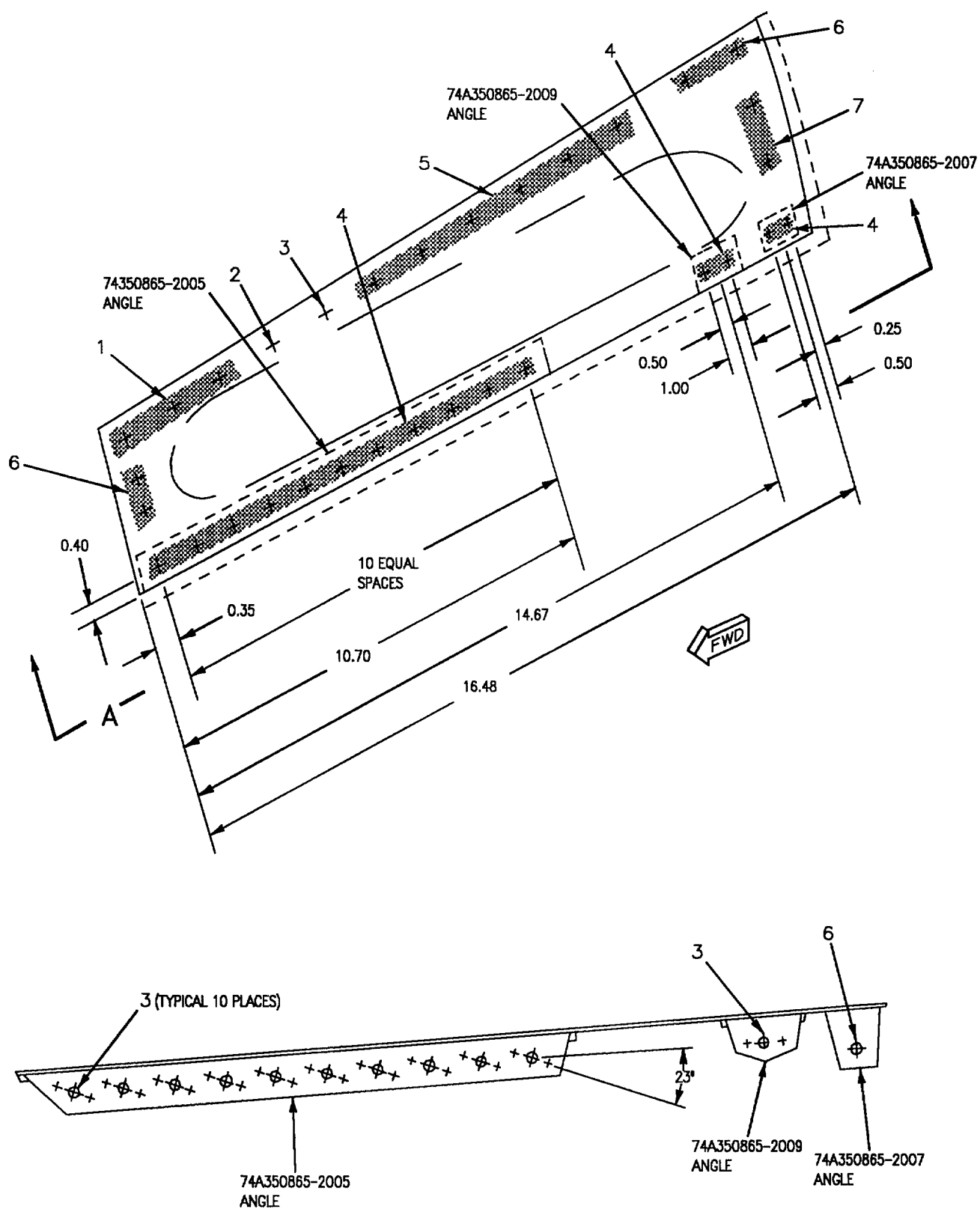
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21047L3
LEGEND				
 Hole diameter is 0.191 +0.006 -0.000.				

Figure 13. Cover (Door 141), Replacement



18AC-SRM-222-(49-1)01-SCAN

Figure 14. Cover (Door 85), Replacement (Sheet 1)




















IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			 Gang Channel	G18421JLM1-3-8
2			 Plate Nut	F50339-3-1
3			 Plate Nut	F50339-3-1
4			Rivet	BRFS4AD
5			 Gang Channel	G18421JLF1-3-11
6			 Plate Nut	F50340-3-1
7			 Plate Nut	F50339-3-1
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p> <p> Attached with NAS1097U3 rivet, length to be determined on installation.</p> <p> Attached with 1415-0310 rivet.</p> <p> F/A-18B 161354 THRU 161360.</p> <p> Hole diameter is 0.098 +0.005 -0.000.</p>				

Figure 14. Cover (Door 85), Replacement (Sheet 2)

ORGANIZATIONAL AND INTERMEDIATE MAINTENANCE**STRUCTURE REPAIR****EXTERNAL COMPOSITE DOORS**

Reference Material

Line Maintenance Access Doors	A1-F18AC-LMM-010
Nondestructive Inspection	A1-F18AC-SRM-300
Ultrasonic Through Transmission Contact Testing, Standardization and Inspection Procedures for Composite Laminate Skins Bonded to Honeycomb Core	WP008 01
Pulse Echo, Longitudinal Wave Contact, With Delay Line, For Composite Laminate Material Bonded To Honeycomb Core	WP008 04
Forward Fuselage Bonded Honeycomb Doors, Skin to Core Unbonds and Edge Delaminations	WP073 00
Forward Fuselage Bonded Honeycomb Doors, Water in Honeycomb	WP074 00
Forward and Center Fuselage; Upper Bonded Honeycomb Doors, Skin to Core Unbonds and Edge Delaminations	WP077 00
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Material Preparation	WP003 00
Curing of Repairs	WP004 00
Water Removal	WP005 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class I Damage Repair	WP012 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class III Damage Repair	WP014 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class IV Damage Repair	WP015 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class V Damage Repair	WP016 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class VI Damage Repair	WP017 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class VII Damage Repair	WP018 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class IX Damage Repair	WP019 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Chemical Treatment	WP008 00
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Structure Repair, General Information	A1-F18AC-SRM-200
Drilling and Machining Composite	WP004 08
EMI Electrical Bonding Strip Contact Verification	WP004 25
Adhesive, Cement, and Sealant; Preparation and Application	WP011 00

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Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
AFB 105	28 Aug 86	Inspection and Repair of the EMI Protection System on Sta Y-128.5, Gun Bay Formers and Inter-costal, Avionics Bay Longerons and Bulkheads, Dorsal Longerons and Bulkhead Arches at Sta Y-326 THRU Y-557, Doors 18, 26, 31, 40, 43, 49 and Vertical Stabilizer Doors 86 and 88	15 Nov 86	Navy Issued

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. Locating and determining size of damage by NDI method is intermediate maintenance. Damage not listed or exceeding the limits listed below require a depot engineering disposition. Repair zones are provided to allow repair in specified areas.

3. **NEGLIGIBLE DAMAGE.** See figure 3. Negligible damage may be allowed to exist as is. Type and limits are as below:

a. Delaminations between skin plies. See Section A. Determine size and location of delamination (A1-F18AC-SRM-300, WP008 04).

(1) Delaminations do not extend to edge of skin.

(2) Diameter is 1/2-inch or less.

(3) Distance between delaminations is at least four diameters of the largest delamination. Measure distance between delaminations edge to edge.

(4) No more than three delaminations are in a 12 inch diameter circle.

b. Unbonds between skin and honeycomb core. See Section B. Determine size and location of unbonds for doors 6, 10, 13, or 14 (A1-F18AC-SRM-300, WP073 00), for door 18 (A1-F18AC-SRM-300, WP077 00).

(1) Unbonds do not extend to edge of skin.

(2) Diameter is 3/4-inch or less.

(3) Distance between unbonds is at least 4 inches. Measure distance between unbonds edge to edge.

(4) No more than three unbonds are in a 12 inch diameter circle.

c. Dents. See Section A.

(1) Diameter is less than 3 inches.

(2) Depth is less than 0.015 inches.

4. **Rotary Latches.** Hexagon recess damage not affecting the locking or unlocking of the latch assembly is considered negligible damage and latch assembly need not be replaced.

5. **REPAIRABLE DAMAGE.** See figure 4. Repairable damage is damage that can be permanently repaired with no adverse effect on structural integrity, flight characteristics, or safety of the aircraft. See figure 2 for repair zones.

6. **Skin Surface Damage and Dents Without Honeycomb Core Damage, Class I Damage.**

See figure 4, section B. This class of damage does not require immediate repair but shall be repaired as soon as practical. The damage shall be monitored to make sure limits are not exceeded. The damage may be in repair zone A or B. Class I damage is skin damage which does not exceed the limits below:

a. Cuts, scratches, pits, erosion, or abrasions.

(1) Depth is no greater than 0.005 inch.

(2) No longer than 5 inches.

b. Dents.

(1) Depth is no greater than 0.05 inch.

(2) Diameter is no greater than 3 inches.

(3) Skin ply delaminations and skin to core unbonds do not exceed negligible damage limits.

(4) Fiber damage is no greater than 0.005 inch deep.

(5) Distance between dents is at least two diameters of the largest dent. Measure distance between dents edge to edge.

(6) Crushed core is not allowed.

7. **Skin Delaminations, Unbonds, or Skin to Core Unbonds Not Open to Edge, Class III Damage.**

See figure 4, section C. This damage is individual or multiple unbonds or delaminations that are not open to the edge and in repair Zone A. Determine size and location of unbonds for doors 6, 10, 13 or 14 (A1-F18AC-SRM-300, WP073 00), for door 18 (A1-F18AC-SRM-300, WP077 00). Class III damage shall not exceed limits below:

a. Unbonds between composite skins in the land area may be up to 1 inch wide and 4 inches long.

Distance between unbonds shall be at least four diameters of the largest unbond.

b. Unbonds between composite skin and honeycomb core may be up to 3 inches in diameter. Distance between unbonds shall be at least four diameters of the largest unbond.

c. Delaminations between the composite skin plies in the land area should meet requirements below:

- (1) Not in core area.
- (2) Not open to the edge.
- (3) No more than 1 inch wide.
- (4) No more than 4 inches long.

(5) Distance between delaminations is four times the length of the longest delamination.

8. Skin Delaminations or Unbonds Open to Edge, Class IV Damage. See figure 4, section D. This damage is delamination between skin plies or unbonds between skins that are open to the edge and are in repair zone A. Delaminations or unbonds may be up to 1 inch wide and 4 inches long. Distance between delaminations or unbonds shall be at least four times the length of the largest delamination or unbond. Determine size and location of edge delaminations or unbonds for doors 6, 10, 13, or 14 (A1-F18AC-SRM-300, WP073 00), for door 18 (A1-F18AC-SRM-300, WP077 00).

9. Fiber Damage Around Fastener Holes, Surface Rips, and Door 18 Damaged Fastener Holes, Class V Damage. See figure 4, section E. This damage is damaged fibers around fastener holes, surface ply rips, or damaged fastener holes in door 18 in repair zone A. Class V damage is skin damage which does not exceed the limits below:

a. Loose or broken fibers, missing fibers or skin abrasions around fastener holes and/or countersinks may be up to 0.010 deep, 1/4-inch wide, and 1/2-inch long.

b. Surface ply rips of graphite epoxy laminate may be up to 0.010 deep, 1/4-inch wide, and 1/2-inch long.

c. Damaged fastener holes in door 18 that can be cleaned up to 0.3906 inch diameter.

10. Skin Damage Without Penetration, Class VI Damage. See figure 4, section F. Class VI damage is damage in repair zone A which does not exceed the limits listed below:

a. Cracks, cuts, scratches, or erosion.

(1) Depth that is greater than 0.005 inch, but less than full skin penetration.

(2) Diameter is 4.0 inches or less.

(3) Distance to edge of damage is at least 1-1/2 inches from fastener holes.

(4) Distance between damages is at least four times the diameter of the largest damage.

(5) Crushed core is not allowed.

b. Delaminations over core.

(1) Delaminations between skin plies not open to the edge. Damage may be up to 3 inches in diameter.

(2) Distance between delaminations shall be at least four diameters of the largest delamination.

(3) Depth more than 0.005 inch deep, but less than full penetration.

(4) Distance to edge of damage is at least 1-1/2 inches from fastener holes.

(5) Crushed core is not allowed.

11. Skin Damage With Penetration and Dents With Honeycomb Core Damage, Class VII Damage. See figure 4, section G. Class VII damage is damage in repair zone A which does not exceed the limits listed below:

a. Full penetration of one and/or both skins.

b. Honeycomb core damage is allowable.

c. Diameter is 4.0 inches or less.

d. Distance to edge of damage is 1-1/2 inches from fastener holes and from inner mold line skin ramp at beginning of core taper at door periphery.

e. Distance between damages is at least four times the diameter of the largest damage.

12. Water In Honeycomb Core, Class VIII

Damage. Inspect for water in honeycomb core in doors 6, 10, 13, or 14 (A1-F18AC-SRM-300, WP074 00). Class VIII damage is water trapped in honeycomb core.

13. **Edge Damage, Class IX Damage.** See figure 4, section A. Class IX damage is damage in repair zone A which does not exceed the limits listed below:

a. Depth of damage is no greater than 0.20 inches.

b. Length of damage is no greater than 4.00 inches.

c. Edge to edge spacing is no less than four times the length of the largest of two nearest damages.

d. Class IV damage with this damage is acceptable if the class IV limitations are not exceeded.

14. REPAIRS.

15. Classes I, III, IV, V, VI, VIII and IX are organizational maintenance. Class VII less than 1.5 inches in diameter is organizational maintenance; over 1.5 inches in diameter is intermediate maintenance. Classes I, III, IV, V, VI, VII, VIII and IX may be repaired per the procedures referenced below. Refinish repaired area as required (A1-F18AC-SRM-500, WP024 00).

16. DOORS 6, 10, 13, 14 AND 18.

a. Repair class I damage (A1-F18AC-SRM-250, WP012 00).

b. Repair class III damage (A1-F18AC-SRM-250, WP014 00).

c. Repair class IV damage (A1-F18AC-SRM-250, WP015 00).

d. Repair class V damage.

(1) Repair fiber damage and surface rips (A1-F18AC-SRM-250, WP016 00).

(2) Repair door 18 damaged fastener holes using method 2 (A1-F18AC-SRM-250, WP016 00). Drill and countersink 0.281 + 0.020 - 0.000 diameter fastener hole after repair.

e. Repair class VI damage (A1-F18AC-SRM-250, WP017 00). Select patch for class VI damage per paragraph 17.

f. Repair class VII damage (A1-F18AC-SRM-250, WP018 00). Select patch for class VII damage per paragraph 17.

g. Repair class VIII damage (A1-F18AC-SRM-250, WP005 00).

h. Repair class IX damage (A1-F18AC-SRM-250, WP019 00).

17. **PATCH SELECTION.** Use table 1 to select applicable patch. Use EA9321 or FM300 adhesive. Repairs where patches cover fasteners or interfere with attaching structure require depot engineering disposition.

18. DOOR 18 FORWARD CORNER DAMAGE.

See figure 5. This damage consists of multiple delaminations, surface ply rips, missing plies or any combination of the three. Damage repair is organizational maintenance.

19. DOOR 18 ALLOWABLE CORNER DAMAGE LIMITS. See figure 5.

a. All damage must fall within the following area. Measure length starting at the forward corner.

(1) Length along the forward edge a maximum of 18 inches.

(2) Length along the side a maximum of 6 inches.

(3) Width a maximum of 2 inches.

b. Missing or cut plies limited to the outer mold line.

(1) Maximum length of 4 inches.

(2) Maximum width of 1-1/2 inches.

(3) Maximum depth one-half of skin thickness.

(4) Distances between damages 3 inches minimum.

20. **Repair Procedure.** See figure 6.

WARNING

Support Equipment Required

None

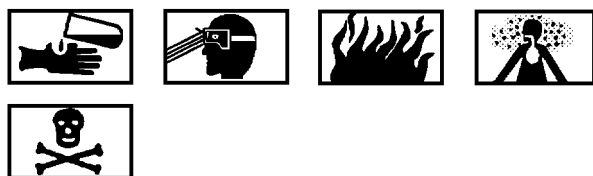
Materials Required

**Specification
or Part Number**

Nomenclature

A-A-1047 GRIT 180 - 9X11	Abrasive Paper, Silicon Carbide, Waterproof
A-A-1047 GRIT 240 - 9X11	Abrasive Paper, Silicon Carbide, Waterproof
EA956	Adhesive
C-C-440 TYPE 1 CLASS 1	Cheesecloth
Fiberite W133 TYPE 1	Dry Woven Graphite Cloth, Satin Weave, 8 Hardness, 24 X 23 Construction

a. Dry door assembly (A1-F18AC-SRM-250, WP005 00).



Adhesive, EA956

14

b. Repair delaminations with adhesive (A1-F18AC-SRM-250, WP015 00).

c. Verify that all delaminations have been filled (A1-F18AC-SRM-300, WP008 01). If the repaired area does not fall within the limit of negligible damage, a depot engineering disposition is required.

d. Fill all areas of missing plies and surface ply rips (A1-F18AC-SRM-250, WP017 00).

Sanding and cutting of graphite epoxy skin produces a fine dust that may cause skin irritation. Breathing of an excessive amount of dust may be injurious.

CAUTION

Use caution in the disposal of fibrous graphite and graphite epoxy scrap. Graphite fibers have high electrical conductivity. Free floating fibers that get inside unsealed or unprotected electrical equipment can cause failure or malfunction.

NOTE

Nonfibrous dust caused by sanding or cutting graphite epoxy skin is not considered a danger to electrical equipment and may be disposed of the same as any waste.

e. Lightly sand area around damaged area with 180 grit abrasive paper. Sanded area should extend minimum of 2 inches beyond edges of filled areas.

f. Clean area by wiping with clean, dry cheesecloth.

NOTE

Lay out L-shaped patch so that fiber direction is at 45 degree angle to door forward edge.

g. Cut dry woven graphite cloth patch to extend 1 inch beyond edge of entire damaged area. If damaged area includes all or part of fastener hole, extend patch 1 inch beyond fastener hole.

h. Prepare EA956 adhesive (A1-F18AC-SRM-250, WP003 00).

i. Impregnate patch with adhesive and install with fibers at 45 degree angle to the door forward edge.

j. Cure patch (A1-F18AC-SRM-250, WP004 00).

k. Trim patch flush with edge of door.

l. Lightly sand edges of patch and clean with clean, dry cheesecloth.

m. Redrill and recountersink any affected fastener holes (A1-F18AC-SRM-200, WP004 08).

n. Do NDI to verify bond line integrity (A1-F18AC-SRM-300, WP008 01).

o. Refinish repair area (A1-F18AC-SRM-500, WP024 00).

21. **REPLACEMENT.**

22. **EMI ELECTRICAL BONDING STRIPS.** Electrical bonding strips (EMI strip) damaged beyond acceptable limits shall be replaced. For EMI damage limits (A1-F18AC-LMM-010). See figure 1.

Support Equipment Required

None

Materials Required

**Specification
or Part Number**

Nomenclature

ST9M622-5-2400
CSR902B3-4
MIL-S-83430,
CLASS A-1/2
Y427
■ TT-I-735
CCC-C-440 TYPE 1
CLASS 1

Strip-Bonding Electrical
Rivet (as required)
Sealing Compound

Tape, Pressure Sensitive
Isopropyl Alcohol
Cheesecloth



Be careful not to enlarge holes when drilling out rivets. Damage to door can occur.

a. Remove rivets attaching retainer and EMI strip to door.

b. Remove retainer, damaged EMI strip, and tape.



Isopropyl Alcohol, TT-I-735

15

■ c. Clean surface where tape will be applied using clean cheesecloth moistened with isopropyl alcohol.

d. Cut to required length new tape from Y427 in 2 inch widths.

e. Apply tape to designated areas on door, figure 1.

NOTE

Maintain 0.03 - 0.08 gap between bonding strips.

f. Cut to size new EMI strip from ST9M622-5-2400.

g. Clean both sides of EMI strip with cheesecloth moistened with trichloroethane.

h. Apply chemical treatment to surface of EMI strip contacting tape (A1-F18AC-SRM-500, WP008 00).



Exercise care when clamping. Do not damage the door.

i. Locate retainer over new EMI strip and tape; clamp in place.

j. Punch holes through tape and EMI strip.



Sealing Compound, MIL-S-83430, Class A-1/2

6



Do not vibrate drive rivets, damage to door can occur.

k. Install rivets wet with sealing compound (A1-F18AC-SRM-200, WP011 00).

l. Fillet seal edges where retainer contacts EMI strip (A1-F18AC-SRM-200, WP011 00).

m. Refinish area (A1-F18AC-SRM-500, WP024 00).

n. Verify that EMI strips contact mating sill (A1-F18AC-SRM-200, WP004 25).

23. **EMI ELECTRICAL BONDING PRESSURE SENSITIVE TAPE, DOOR 18.** EMI protection pressure sensitive tape damaged beyond acceptable specified limits (A1-F18AC-LMM-010) shall be replaced. See figure 2.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
Y427	Tape, Pressure Sensitive, 2-inch width
TT-I-735	Isopropyl Alcohol
CCC-C-440, Type 1, CLASS 1	Cheesecloth

a. Remove damaged tape.



Isopropyl Alcohol, TT-I-735 15

b. Clean surface where tape will be applied using clean cheesecloth moistened with isopropyl alcohol.

c. Cut tape, Y427, to required length.

d. Apply tape to designated area on door, figure 1.

24. **EMI SEAL, DOOR 18.** Loose or damaged EMI seals shall be replaced. Tears or missing section of wire mesh or core of EMI seal more than 1 inch in length requires replacement of EMI seal. See figure 1, section B.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
EA934	Adhesive
TT-I-735	Isopropyl Alcohol
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
11M1022-	EMI Seal

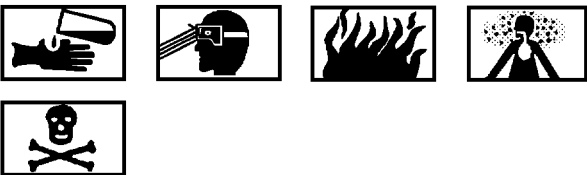
a. Pull EMI seal from door 18.



Isopropyl Alcohol, TT-I-735 15

b. Clean surface where EMI seal was located using clean cheesecloth moistened with isopropyl alcohol.

c. Cut to required length new EMI seal from 11M1022-1.



Adhesive, EA934 16

d. Prepare adhesive (A1-F18AC-SRM-200, WP011 00).



To prevent degrading of EMI protection, use care to apply adhesive only to specified bond areas.

e. Spot bond EMI seal to door with adhesive per dimensions shown on figure 1, section B.

f. Remove excess adhesive by wiping with clean cheesecloth.

g. Cure adhesive (A1-F18AC-SRM-200, WP011 00).

h. Apply finish system as required (A1-F18AC-SRM-500, WP024 00).

25. **WEATHER SEAL, DOOR 18.** Loose or damaged weather seal shall be replaced. Tears or missing sections of weather seal require replacement. Tears or missing sections of dacron cloth are acceptable. See figure 1, section B.

Support Equipment Required

None

Materials Required

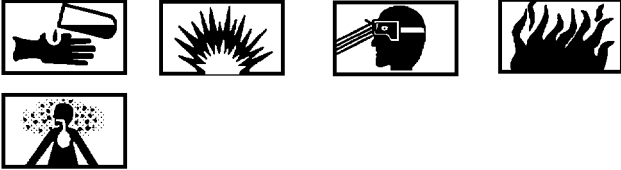
Specification or Part Number	Nomenclature
11M1025-1	Weather Seal
SS-4004	Primer, Rubber
RTV106	Adhesive
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
TT-I-735	Isopropyl Alcohol

a. Pull weather seal from door 18.



Isopropyl Alcohol, TT-I-73515

b. Clean surface where weather seal was located using clean cheesecloth moistened with isopropyl alcohol.



Silicone Primer, SS-400417

c. Apply adhesion promoting primer to surface.

d. Cut to required length new weather seal from 11M1025-1.



Adhesive, RTV10618



To prevent degrading of EMI protection, do not allow adhesive to extend beneath adjacent EMI seal.

e. Apply a thin layer of adhesive on mating surface of weather seal.

f. Position weather seal on door 18 using dimensions shown on figure 1, section B.

g. Allow adhesive to cure at room temperature for 24 hours.

h. Refinish area (A1-F18AC-SRM-500, WP024 00).

26. **ROTARY LATCHES.** See figure 1, (8).

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Torque Wrench, 0 to 50 Inch-Pounds

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
TT-I-735	Isopropyl Alcohol
MIL-S-81733 TYPE 4-12	Sealing Compound


a. Remove nut, washer, and bolt securing rotary latch to door.

b. Clean all residual sealing compound from door.



Isopropyl Alcohol, TT-I-73515

c. Wipe area clean with cheesecloth moistened with isopropyl alcohol.



Sealing Compound, MIL-S-81733, Type 4-125

d. Prepare sealing compound (A1-F18AC-SRM-200, WP011 00).

e. Fay surface seal mating areas between door and rotary latches (A1-F18AC-SRM-200, WP011 00).





f. Install bolt wet with sealing compound (A1-F18AC-SRM-200, WP011 00).

g. Install washer and nut.

h. Torque nut to 15-25 inch-pounds.

i. Install rotary latch cover (A1-F18AC-SRM-420, FIG030 00).

Table 1. Patch Selection for Graphite Composite and Titanium Patches

Damage Size Dia.	Graphite Epoxy Patch		Titanium Patch Two Plies	
	 No.	Dia.	 No.	Dia.
0.0 to 0.25	-1001	2.75	-2003 -2005	2.75
0.25 to 1.50	-1007	4.00	-2007 -2005	4.00
1.50 to 2.75	-1009	5.25	-2009 -2007	5.25
2.75 to 4.00	-1011	6.50	-2013 -2011	6.50
NOTE  Dash Number of 74K000002 kit.  Dash Number of 74K000003 kit.				

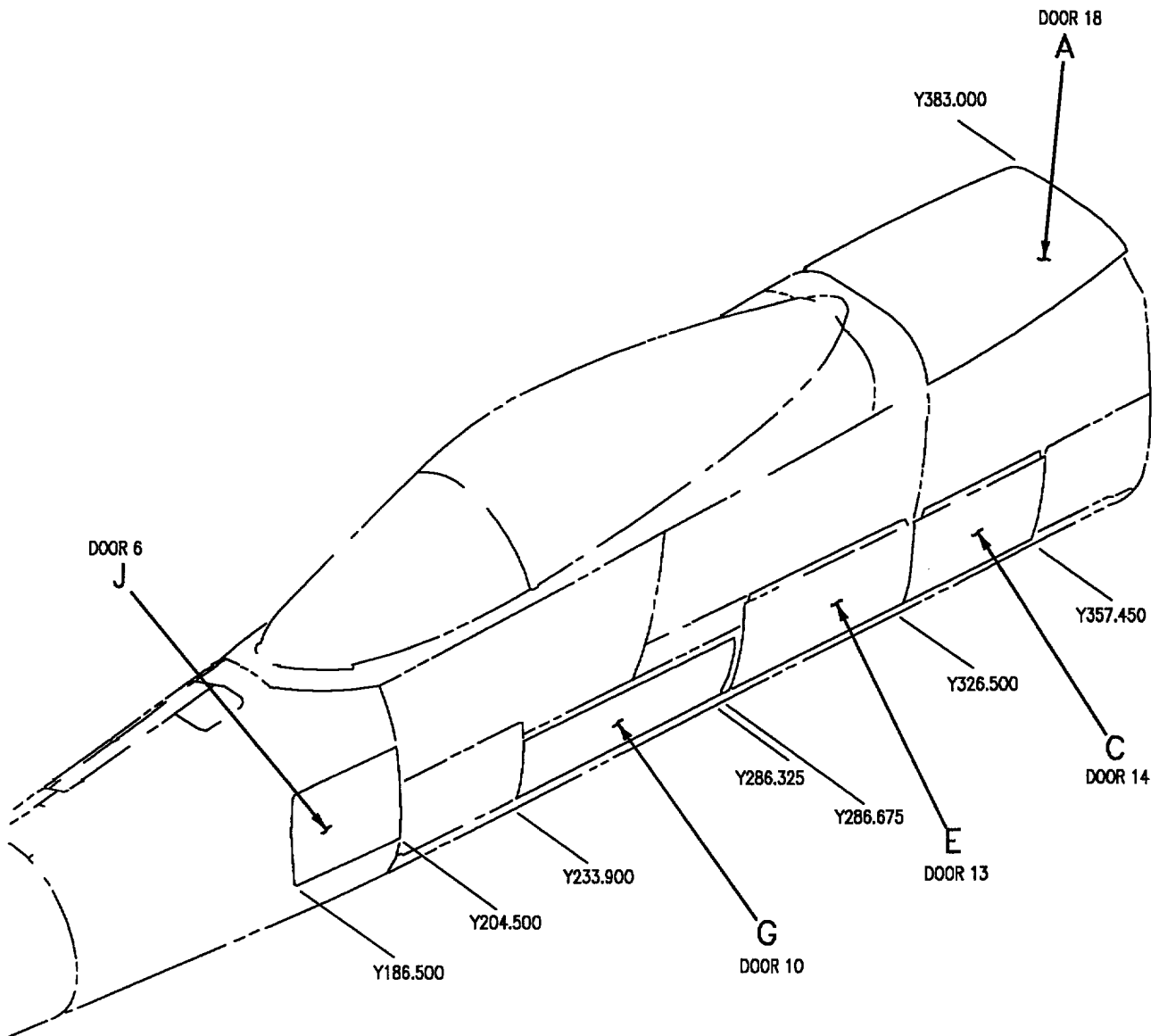


Figure 1. Material Index (Sheet 1)

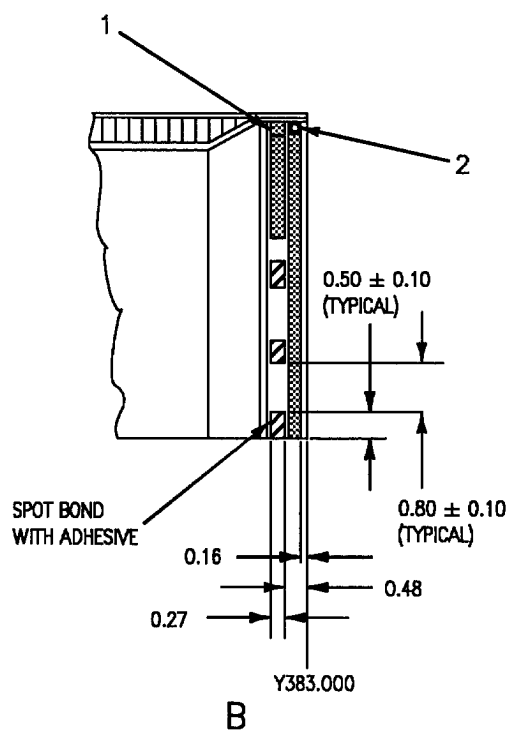
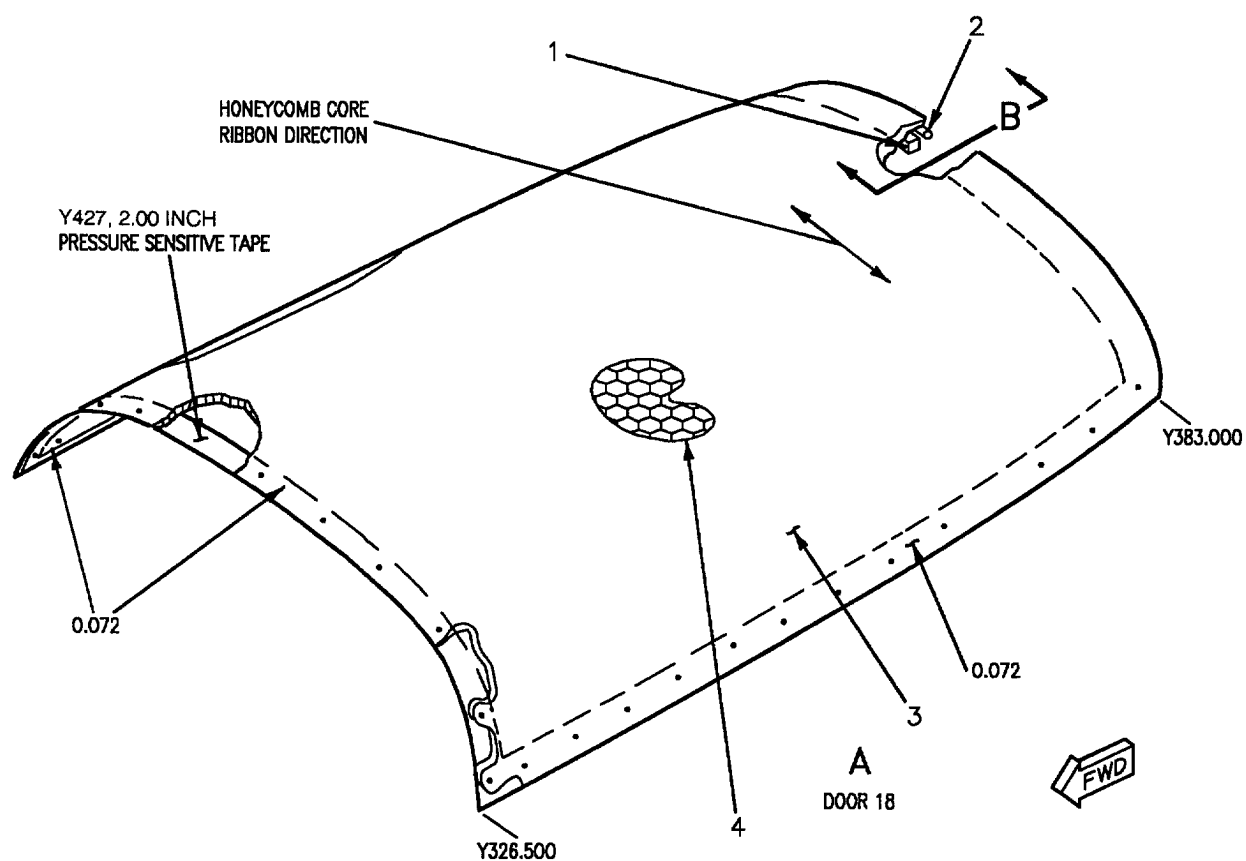


Figure 1. Material Index (Sheet 2)

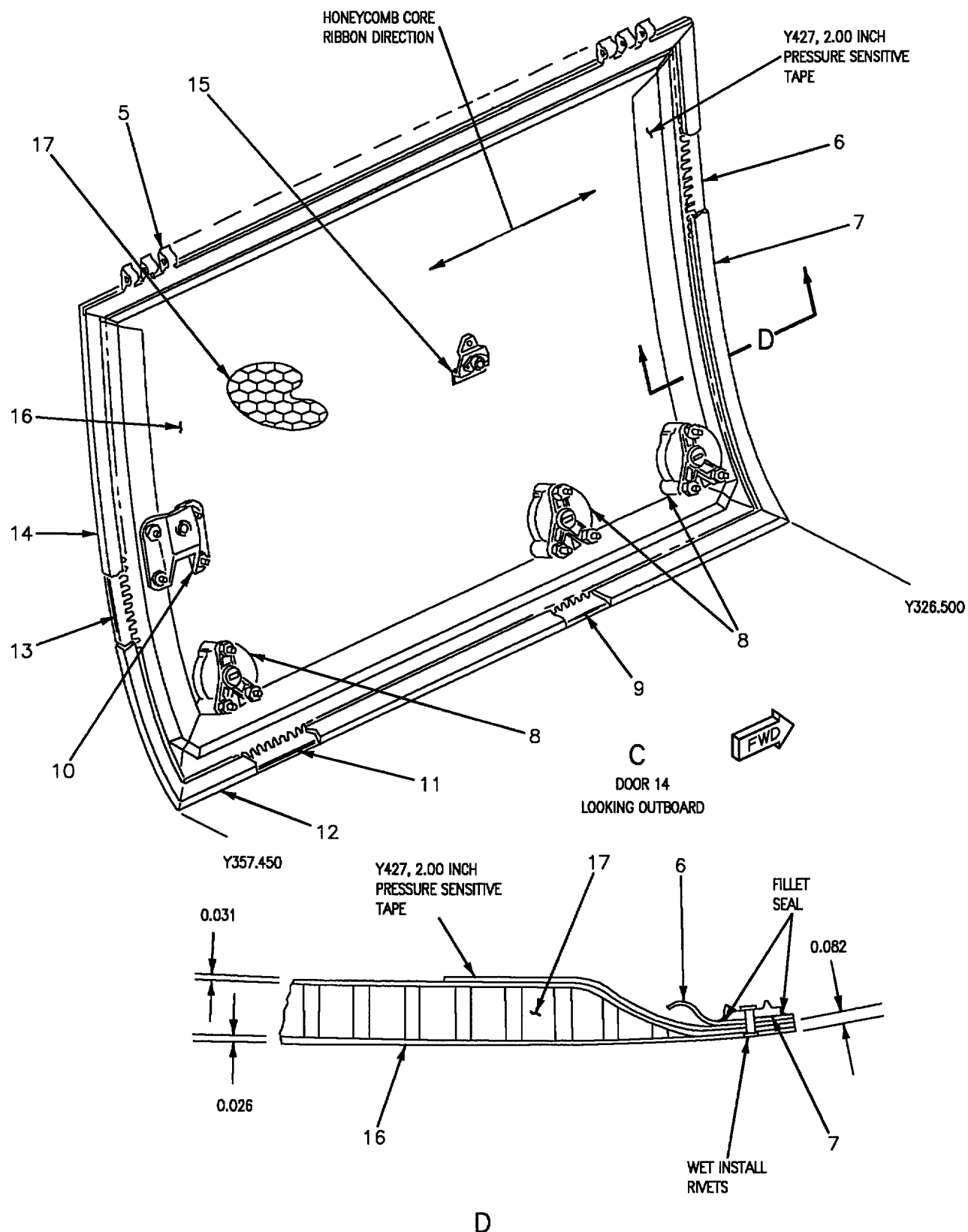


Figure 1. Material Index (Sheet 3)

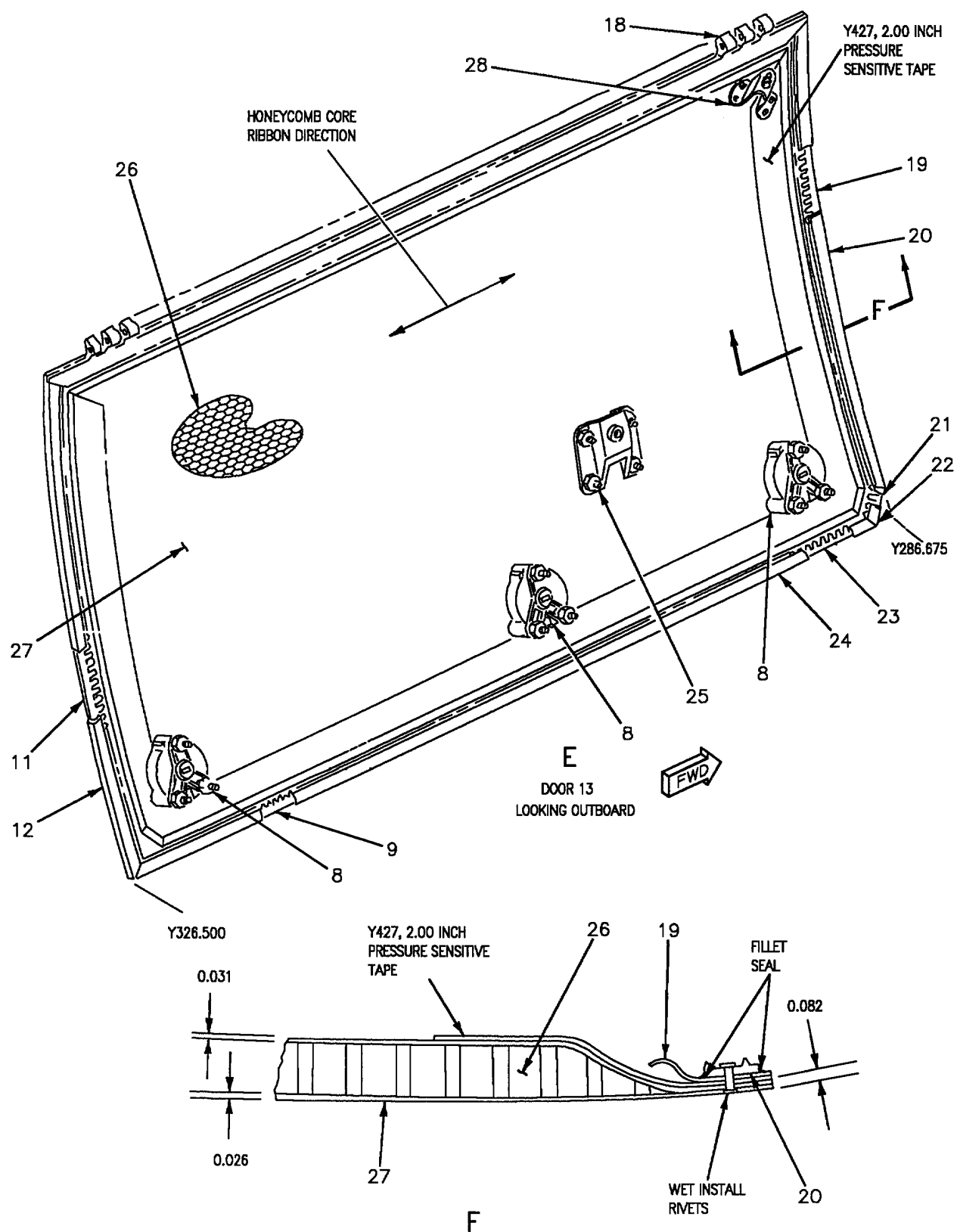


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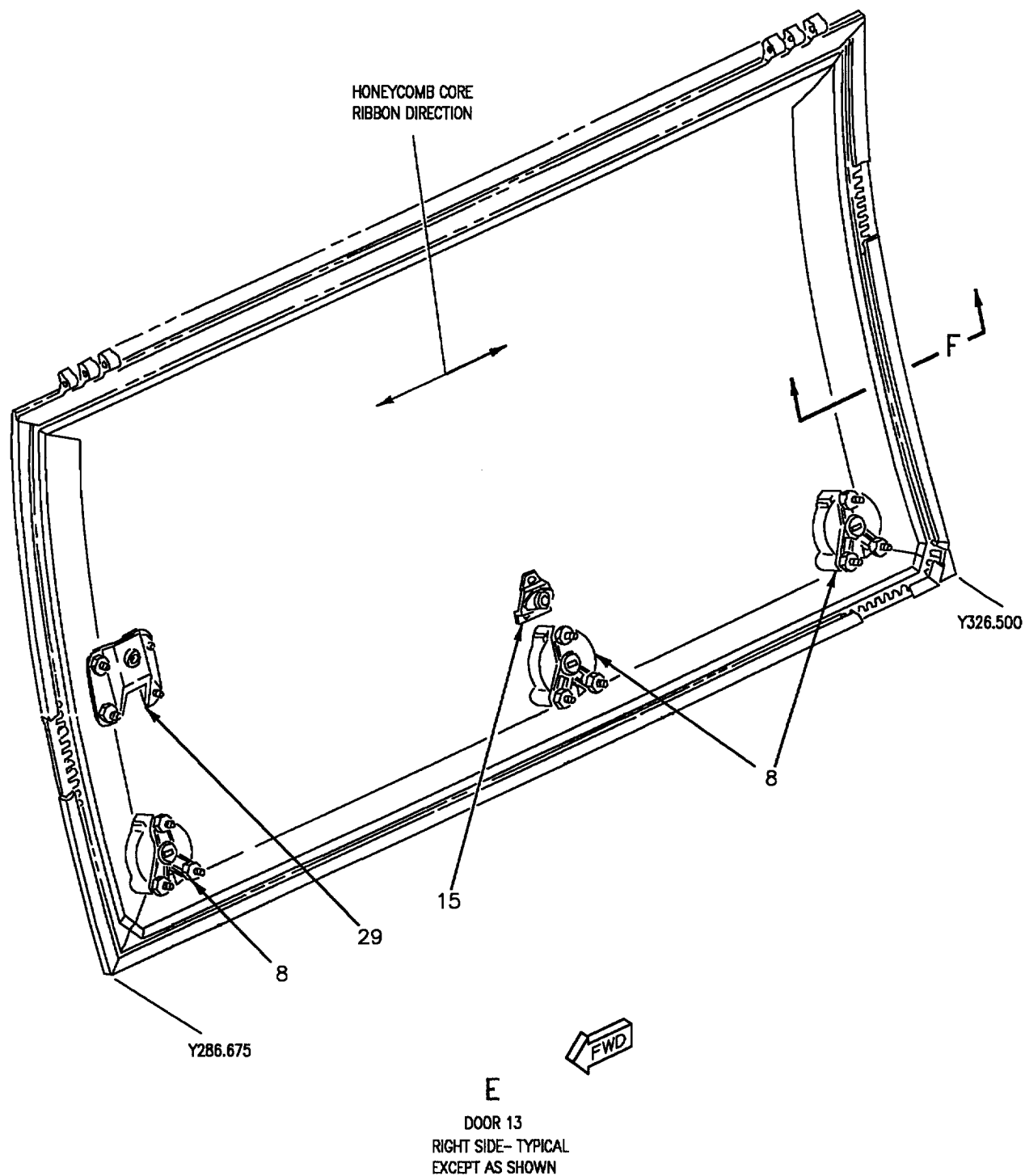
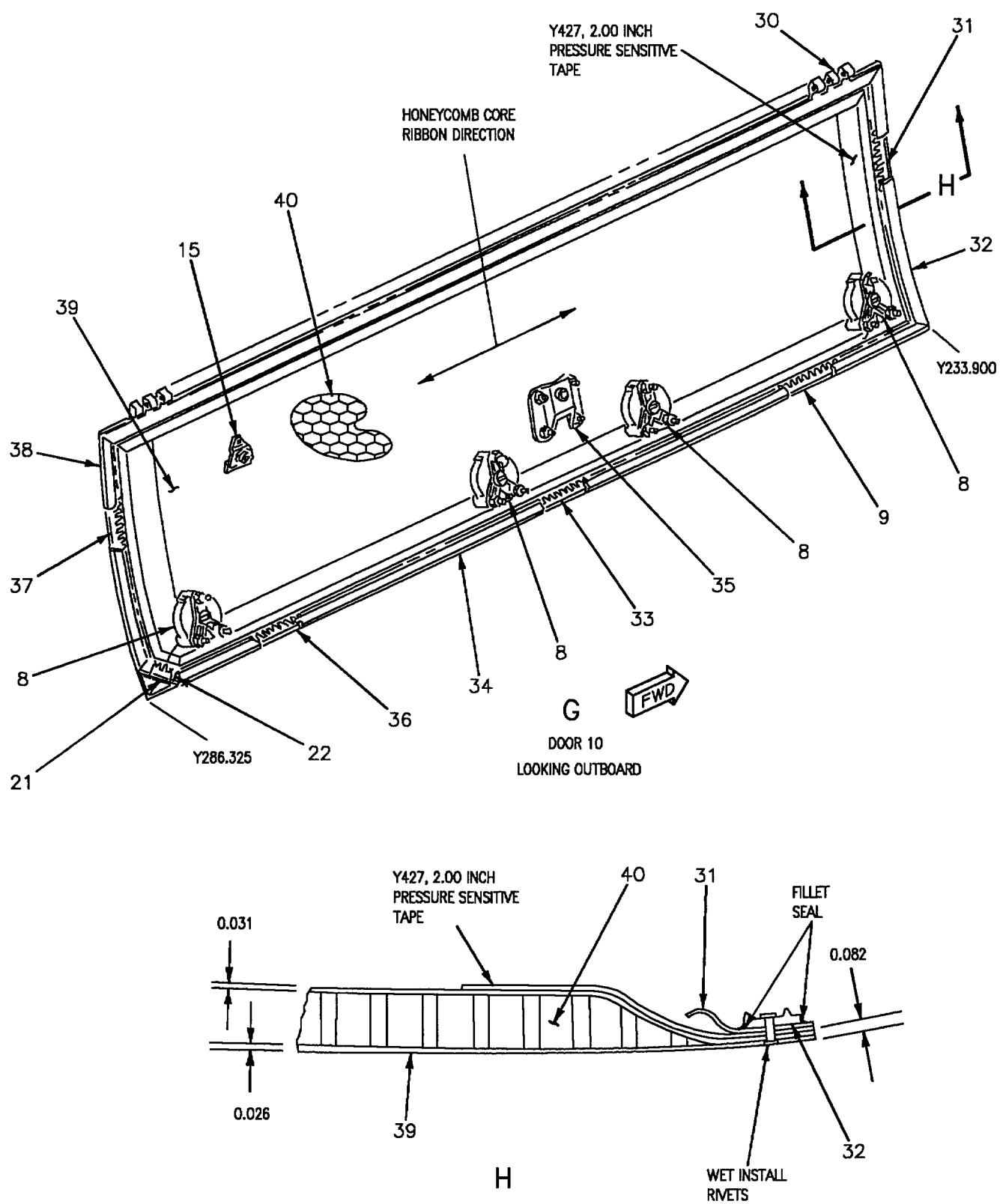


Figure 1. Material Index (Sheet 5)



18AC-SRM-222-(50-6)03-SCAN

Figure 1. Material Index (Sheet 6)

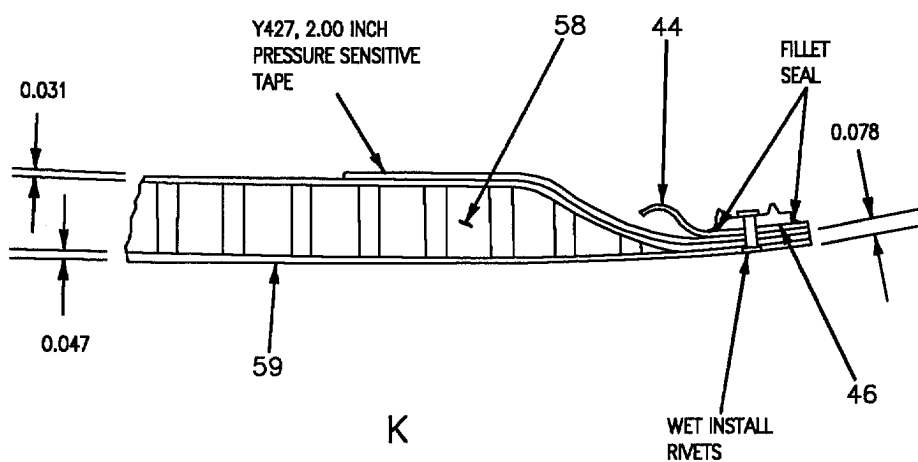
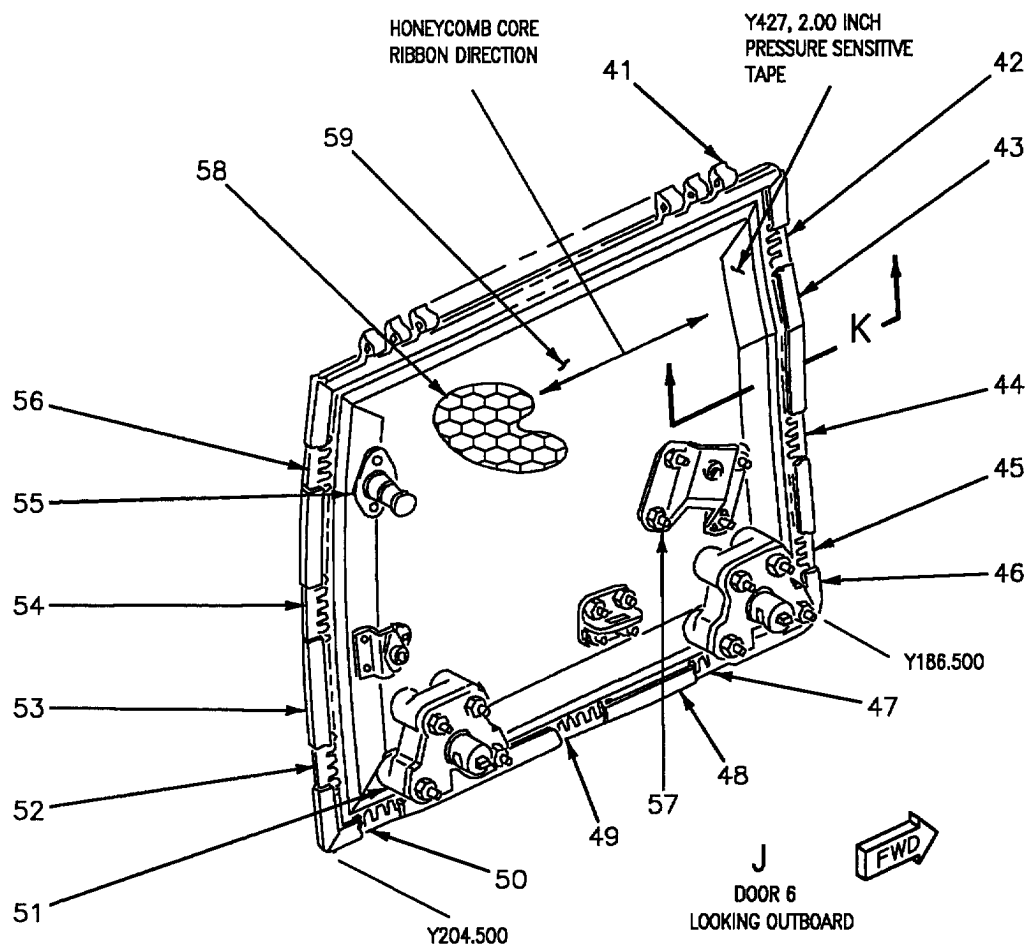


Figure 1. Material Index (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1	<div>2</div> <div>11</div> <div>12</div>	Seal, EMI 74A314103-2081 74A314103-2249 74A314103-2251	<div>14</div> 11M967-1 Extr 11M1022-1 Extr	Silicone Rubber
2	<div>13</div> <div>12</div>	Seal, Weather 74A314103-2083 74A314103-2253	11M966-1 Extr 11M1025-1 Extr	Silicone Rubber
3	<div>2</div> <div>3</div>	Skin (Door 18) 74A314073-1003 74A314073-1005	<div>1</div> Sheet	Graphite Epoxy Laminated Prepreg
4	<div>2</div> <div>15</div> <div>16</div>	Core 74A314101-2001 74A314101-2003 74A314101-2005	0.50 Inch Thick Flexcore Honeycomb	5056-H39 Al Aly
5		Hinge 74A315065-2003, -2004	1MA10467D05 Extr	7025-T73511 Al Aly
6	<div>21</div>	Leaf 74A315071-2033	STM9622-5-2112 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
7		Retainer 74A315071-2031	1MA10478C03 Extr	6061-T6511 Al Aly
8	<div>4</div> <div>5</div>	Latch TL12079-101 TL12079-103	-	-
9	<div>21</div>	Leaf 74A315069-2041, -2042	ST9M622-5-1645 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
10		Support 74A315017-2009	1MA10462-D06 Extr	7075-T76511 Al Aly
11	<div>21</div>	Leaf 74A315073-2033	ST9M622-5-1402 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H

Figure 1. Material Index (Sheet 8)






IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
12		Retainer 74A315073-2031	1MA10491C03 Extr	6061-T6511 Al Aly
13		 Leaf 74A315073-2029	ST9M622-5-2115 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
14		Retainer 74A315073-2027	1MA10478C03 Extr	6061-T6511 Al Aly
15		Bracket 74A315018-2003	0.040 Sheet	7075-T6 Alclad
16		Skin (Door 14) 74A315074-2049, -2050	 Sheet	Graphite Epoxy Laminated Prepreg
17		Core 74A315074-2101, -2102	0.145 Inch Thick Hex Cell Honeycomb	5056-H39 Al Aly
18		Hinge 74A315064-2003, -2004	1MA10468D05 Extr	7075-T73511 Al Aly
19		 Leaf 74A315071-2041, -2042	ST9M622-5-1859 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
20		Retainer 74A315071-2039, -2040	1MA10478C03 Extr	6061-T6511 Al Aly
21		 Leaf 74A315069-2021, -2022	ST9M622-5-316 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
22		Retainer 74A315069-2031, -2032	1MA10491C03 Extr	6061-T6511 Al Aly
23		 Leaf 74A315071-2037, -2038	ST9M622-5-2113 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
24		Retainer 74A315071-2035, -2036	1MA10491C03 Extr	6061-T6511 Al Aly
25		Support 74A315017-2003	1MA10462-D06 Extr	7075-T76511 Al Aly
26		Core 74A315072-2171, -2156	0.145 Inch Thick Hex Cell Honeycomb	5056-H39 Al Aly

Figure 1. Material Index (Sheet 9)







IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
27		Skin (Door 13) 74A315072-2001, -2002	 Sheet	Graphite Epoxy Laminated Prepreg
28		Bracket 74A315018-2005	0.040 Sheet	7075-T6 Alclad
29		Support 74A315017-2005	1MA10462-D06 Extr	7075-T76511 Al Aly
30		Hinge 74A315063-2001, -2002	1MA10470D05 Extr	7075-T73511 Al Aly
31		 Leaf 74A315069-2045, -2046	ST9M622-5-1400 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
32		Retainer 74A315069-2043, -2044	1MA10478C03 Extr	6061-T6511 Al Aly
33		 Leaf 74A315069-2039	ST9M622-5-1702 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
34		Retainer 74A315069-2035, -2036	1MA10491C03 Extr	6061-T6511 Al Aly
35		Support 74A315017-2007	1MA10462-D06 Extr	7075-T76511 Al Aly
36		 Leaf 74A315069-2037, -2038	ST9M622-5-1668 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
37		 Leaf 74A315069-2049, -2050	ST9M622-5-1164 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
38		Retainer 74A315069-2047, -2048	1MA10478C03 Extr	6061-T6511 Al Aly
39		Skin (Door 10) 74A315070-2001, -2003	 Sheet	Graphite/Epoxy Laminated Prepreg
40		Core 74A315070-2209, -2211	0.145 Inch Thick Hex Cell Honeycomb	5056-H39 Al Aly

Figure 1. Material Index (Sheet 10)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
41	<div>2</div> <div>6</div> <div>17</div> <div>18</div>	Hinge 74A315062-2001 74A315062-2003 74A315062-2006 74A315062-2009	1MA10463D05 Extr	7075-T73511 Al Aly
42		<div>21</div> Leaf 74A315067-2037	ST9M622-5-718 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
43		Retainer 74A315067-2039	1MA10478C03 Extr	6061-T6511 Al Aly
44		<div>21</div> Leaf 74A315067-2047	ST9M622-5-475 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
45		<div>21</div> Leaf 74A315067-2049	ST9M622-5-452 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
46		Retainer 74A315067-2045	1MA10478C03 Extr	6061-T6511 Al Aly
47		<div>21</div> Leaf 74A315067-2019	ST9M622-5-650 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
48		Retainer 74A315067-2031	1MA10491C03 Extr	6061-T6511 Al Aly
49		<div>21</div> Leaf 74A315067-2035	ST9M662-5-662 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
50		<div>21</div> Leaf 74A315067-2015	ST9M622-5-650 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
51	<div>4</div> <div>5</div>	Latch 74J318008-103 TL12079- 103	-	-
52		<div>21</div> Leaf 74A315067-2023	ST9M622-5-650 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
53		Retainer 74A315067-2001	1MA10478C03 Extr	6061-T6511 Al Aly

Figure 1. Material Index (Sheet 11)

































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54		 Leaf 74A315067-2017	ST9M622-5-600 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
55		Indicator 74A730205-1003	Holdback Mechanism	-
56		 Leaf 74A315067-2013	ST9M622-5-510 0.0005 Sheet	Beryllium Copper Aly 172 Cond. H
57	 	Support 74A315017-2011 74A315017-2015	1MA10462-D06 Extr	7075-T76511 Al Aly
58	 	Core 74A315068-2113 74A315068-2205	0.145 Inch Thick Hex Cell Honeycomb	5056-H39 Al Aly
59	   	Skin (Door 6) 74A315068-1015 74A315068-1017 74A315068-1019 74A315068-1021	 Sheet	Graphite/Epoxy Laminated Prepreg
LEGEND  Skin is fabricated of varying plys of Graphite laminate and Glass laminate.  F/A-18A 161353.  F/A-18A 161358 AND UP.  161353 THRU 161528.  161702 AND UP.  161354 THRU 161528.  161354 THRU 161527.  161528 AND UP.  161353 AND 161354.  161355 THRU 161527.  F/A-18A 161358 THRU 161946, 161966 THRU 161971.  F/A-18A 161948 THRU 161965, 161972 AND UP.  F/A-18A 161353 THRU 161946, 161966 THRU 161971.  When replacing, use superseding part.  F/A-18A 161358 THRU 162414.  F/A-18A 162415 AND UP.  161702 THRU 161987.  162394 AND UP.  161528 THRU 161939.  161940 AND UP.  EMI Electrical bonding strip.				

Figure 1. Material Index (Sheet 12)

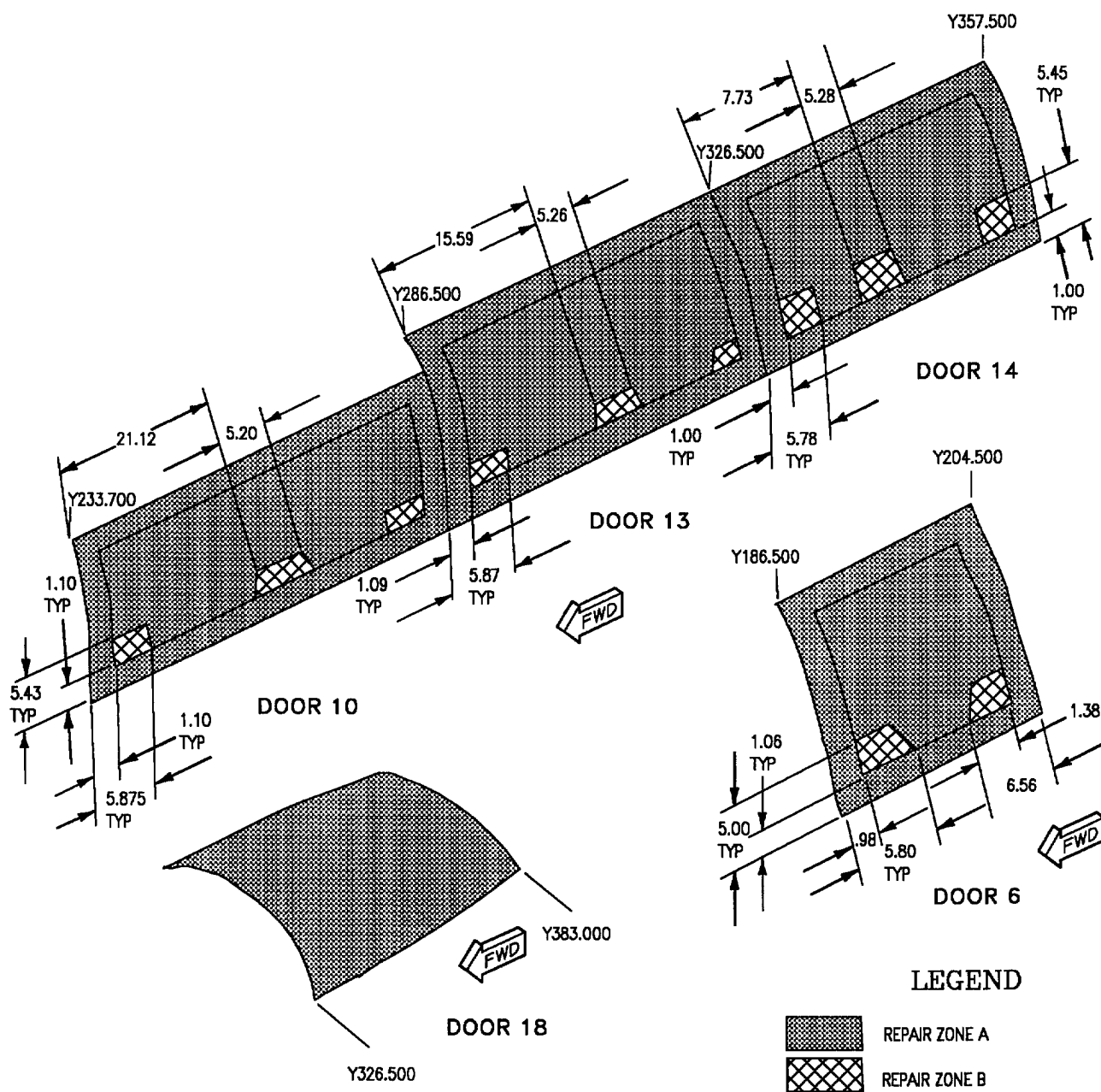


Figure 2. Repair Zones

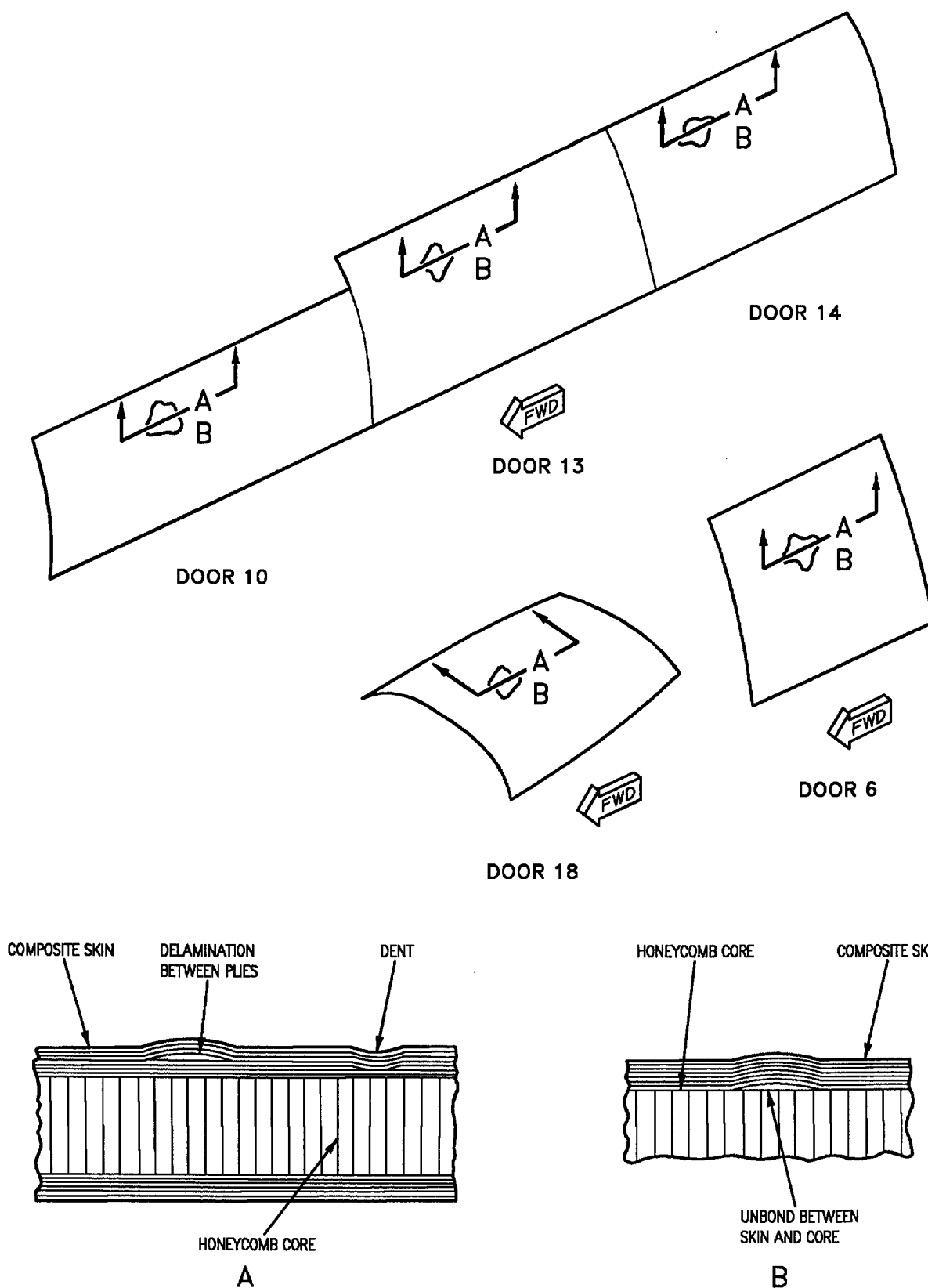


Figure 3. Negligible Damage

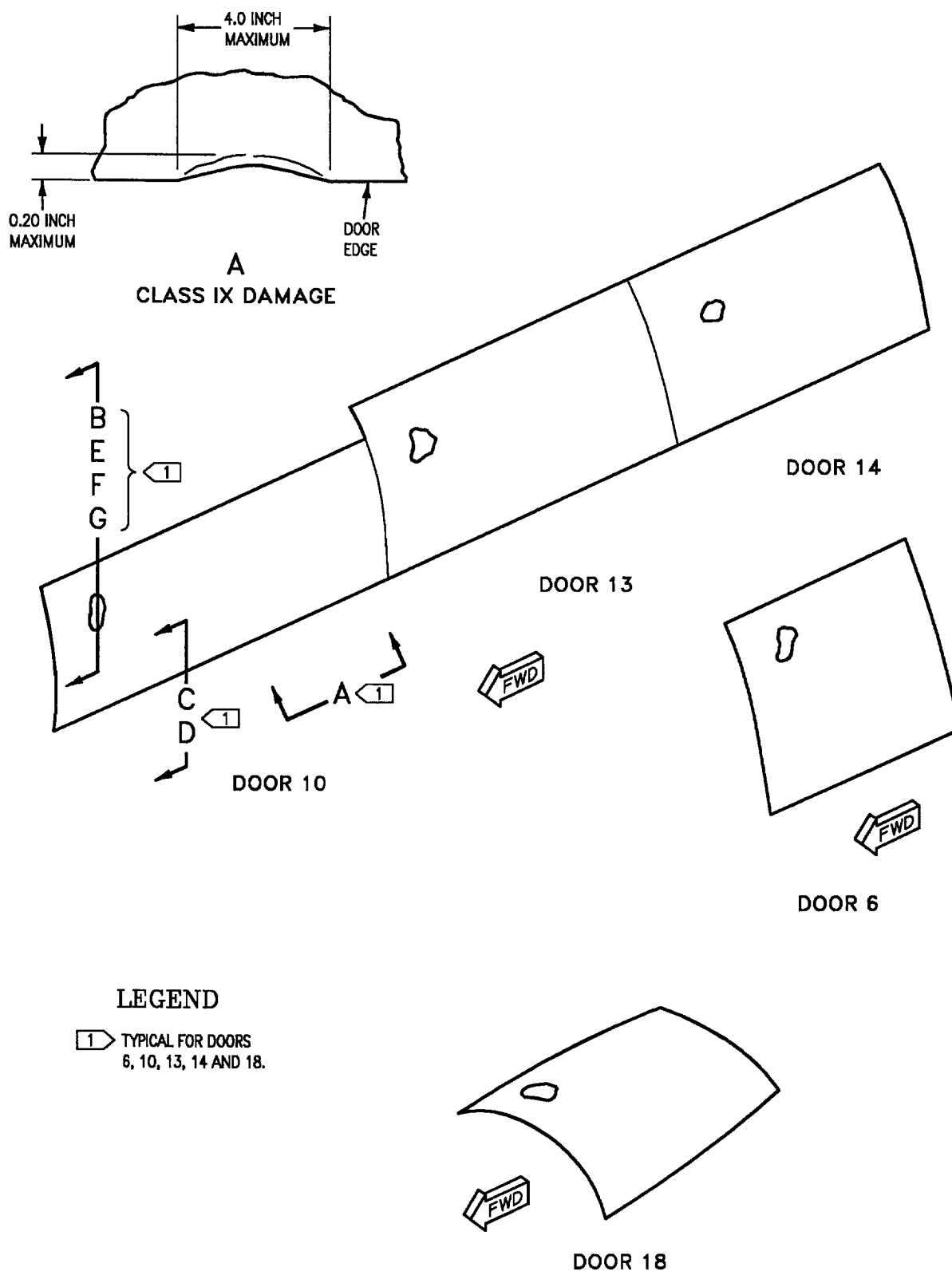


Figure 4. Repairable Damage (Sheet 1)

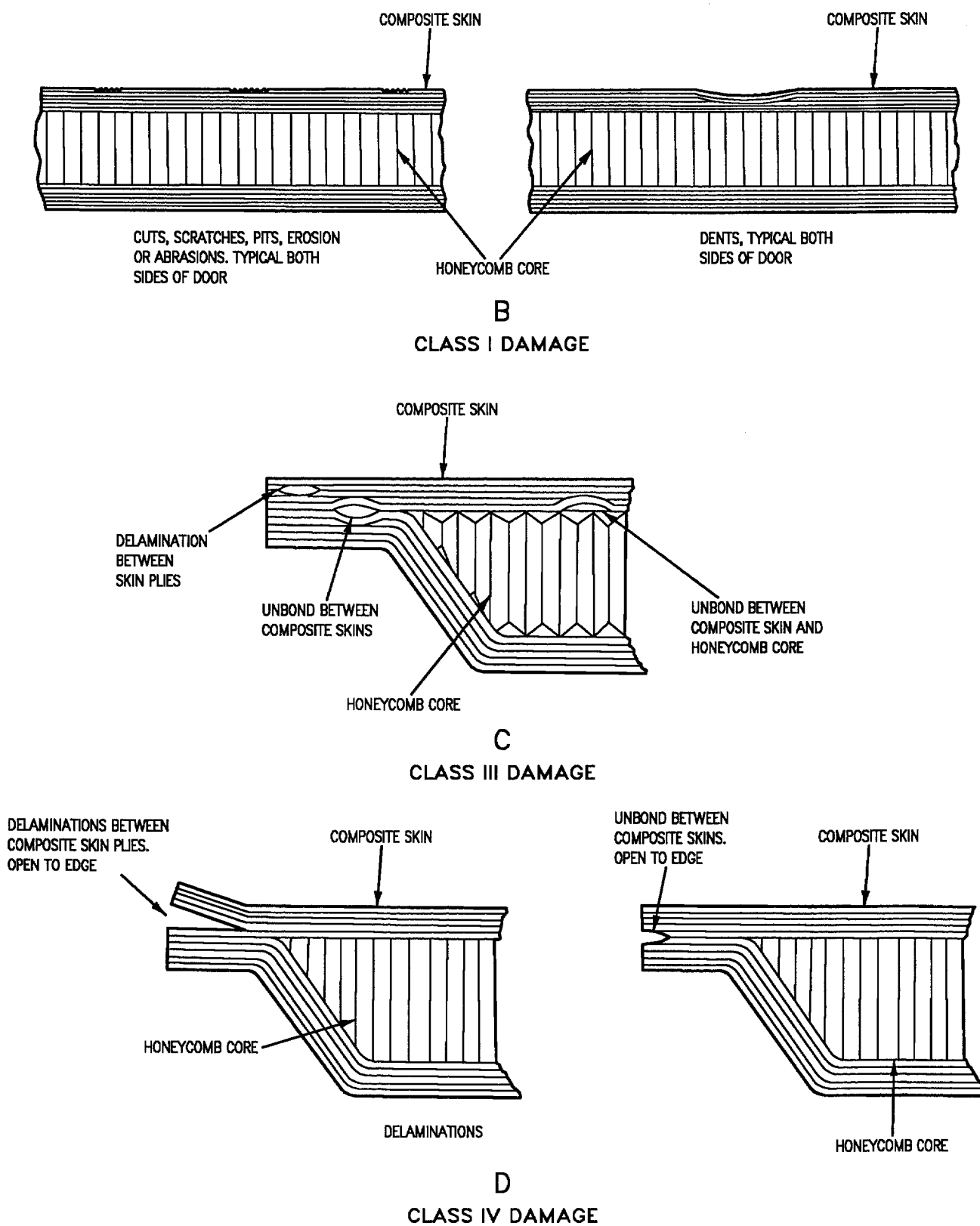
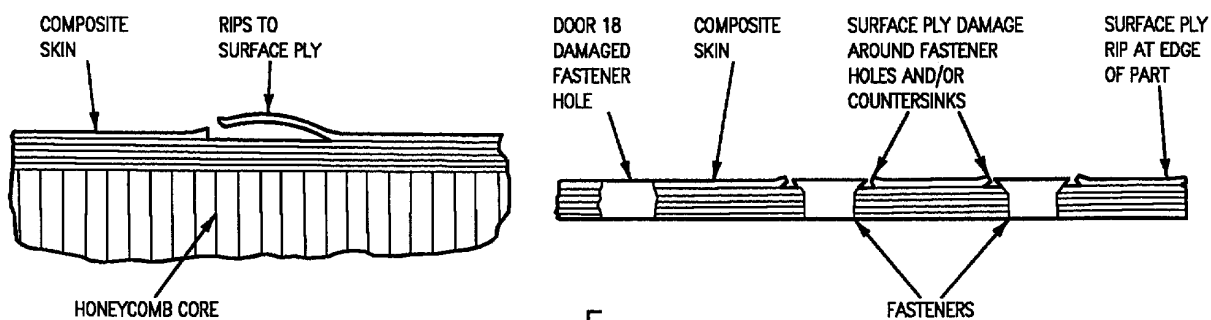
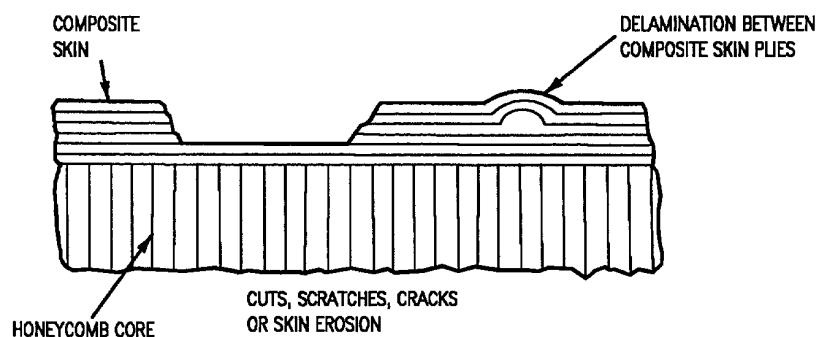


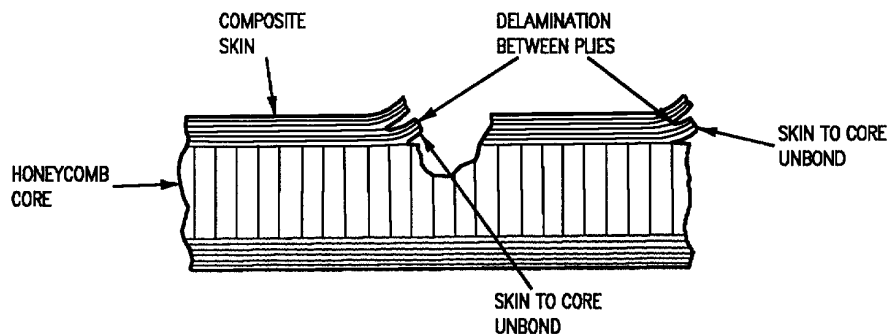
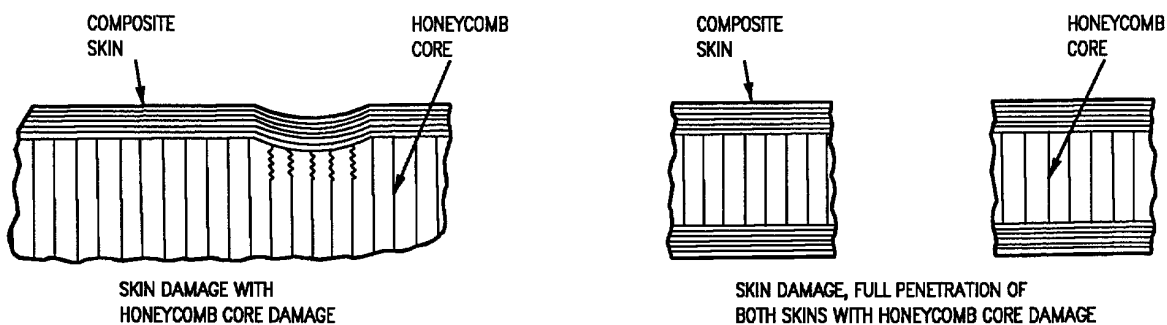
Figure 4. Repairable Damage (Sheet 2)



E
CLASS V DAMAGE

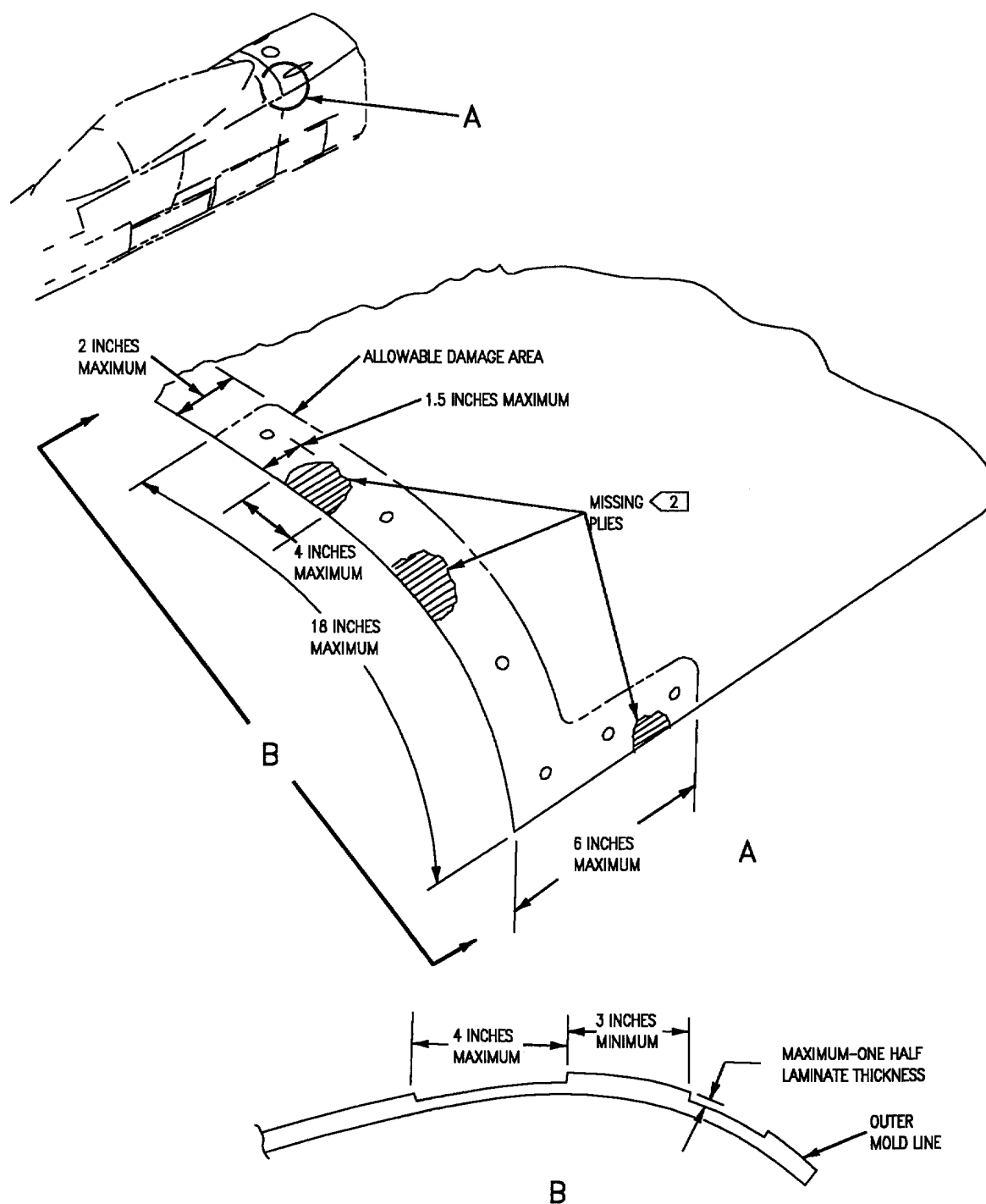


F
CLASS VI DAMAGE



G
CLASS VII DAMAGE

Figure 4. Repairable Damage (Sheet 3)



LEGEND

1. LIMITS APPLY TO BOTH LEFT AND RIGHT FORWARD CORNERS.

2 MISSING PLYES AND SURFACE PLY RIPS ALLOWED ON OUTER MOLD LINE ONLY.

Figure 5. Door 18 Forward Corner Damage Limits

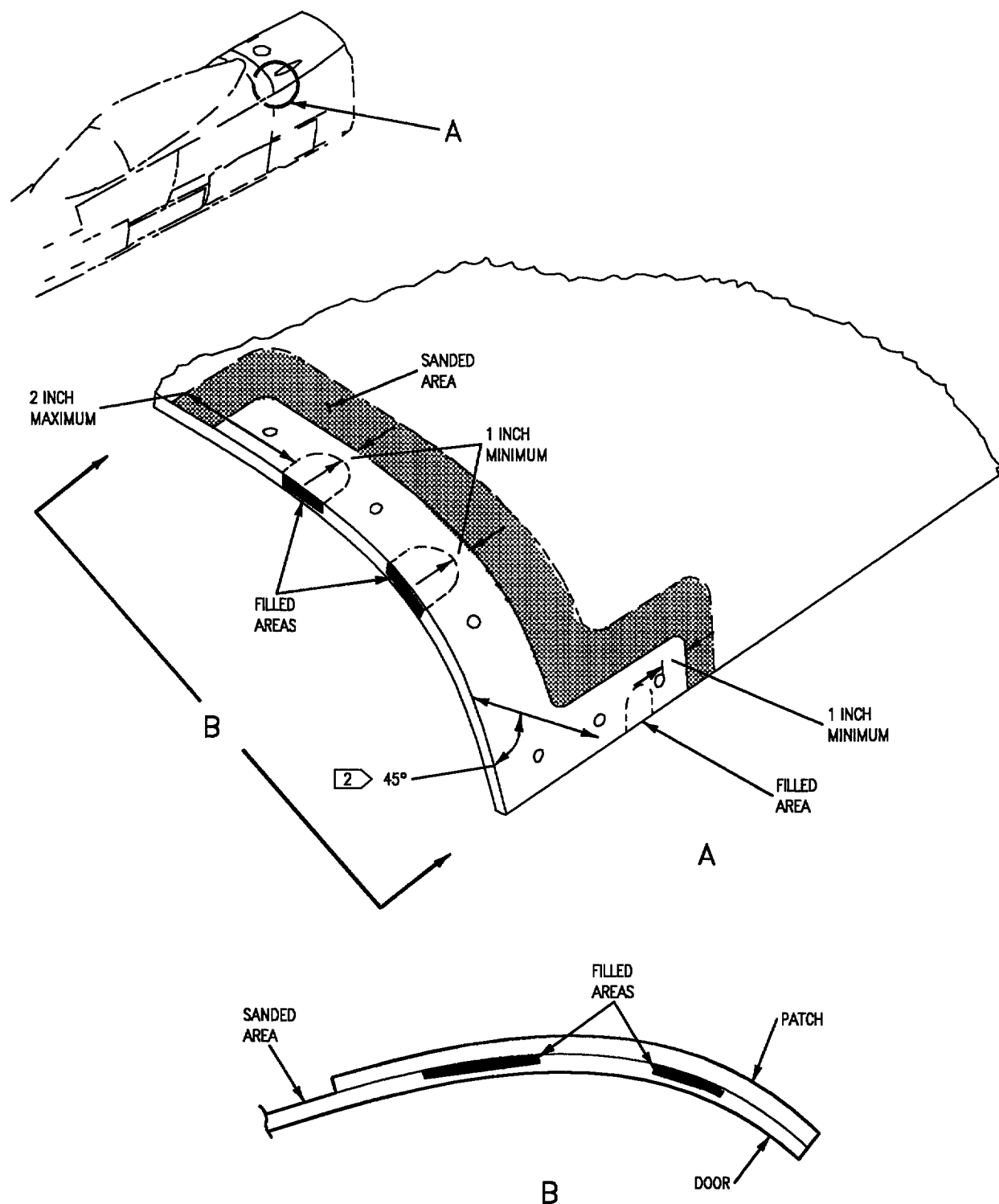


Figure 6. Door 18 Forward Corner Damage Repair

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

REPLACEMENT OF DOORS 6, 10, 13, 14, 18

Reference Material

Structure Repair, General Information	A1-F18AC-SRM-200
Locating Blind Holes and Trim Lines	WP004 03
Gang Channel and Plate Nut Identification and Repair	WP004 05
Aircraft Corrosion Control	A1-F18AC-SRM-500
Removal and Cleanup of Corrosion From Structure at Doors 10, 13, and 14	WP005 03
Form In Place Sealing	WP010 00
Form In Place Sealing With EMI Gasket	WP005 02
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Line Maintenance Access Doors	A1-F18AC-LMM-010
Structure Illustrated Parts Breakdown - Forward Fuselage	A1-F18AC-SRM-420
Fuselage Section - Fwd Fus, Structure	FIG 023 00

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Door 6, 161528 AND UP	2
Door 10	6
Door 13	9
Door 14	11
Door 18	13
Gun Loader Door (Door 6) Hinge Pin	2
Indicator, Holdback Mechanism (Door 6)	6

Record of Applicable Technical Directives

None

Support Equipment Required

Materials Required

Part Number or
Type Designation

Nomenclature

None

-

Torque Wrench, 0 to
120 Inch-Pounds

1. REPLACEMENT.

2. On 161353 THRU 161736, corrosion is possibly
forming on structure under doors 10, 13, and 14,

because of type form in place seal installed in production. When found: remove, clean up corrosion, and replace form in place (A1-F18AC-SRM-500, WP005 03). After form in place seal has been replaced on aircraft noted above and also on 161737 AND UP, maintain, repair, or replace form in place seal (A1-F18AC-SRM-500, WP005 03).

3. **DOOR 6, 161353 THRU 161527.** See figure 1. Door 6 is interchangeable. Remove and replace door 6 as below:

a. Removal.

- (1) Open door (A1-F18AC-LMM-010).
- (2) Disconnect electrical leads.
- (3) Disconnect strut from structure and store on door.
- (4) Support door, remove hinge pins at center of door and remove door.
- (5) Remove form-in-place seal (A1-F18AC-SRM-500, WP010 00).

b. Replacement.

- (1) Align door hinge to structure hinge and install hinge pin. For hinge pin repair, see figure 2.
- (2) Raise door and install strut.
- (3) Install electrical leads.
- (4) Locate the striker 0.80 nominally from the intercostal measured along the outboard surface of the striker as shown in section A of figure.
- (5) Close door and check latch lock and unlock torque.
- (6) If door latch lock or unlock torque is not 40-60 inch pounds, open door, use 7/16 open end wrench to tighten the adjustment nut on the striker to get 40-60 inch-pounds latch lock and unlock torque.
- (7) Inspect mold line mismatch around the periphery of the door. Maximum mismatch is 0.040.
- (8) Read just striker if required to meet mold line mismatch. After readjustment, latch unlock torque is to be 40-100 inch-pounds.
- (9) Install form-in-place seal (A1-F18AC-SRM-500, WP010 00).

- (10) Close door (A1-F18AC-LMM-010).

4. **DOOR 6, 161528 AND UP.** See figure 1. Door 6 is interchangeable. Remove and replace door 6 as listed below:

a. Removal.

- (1) Open door (A1-F18AC-LMM-010).
- (2) Disconnect electrical leads.
- (3) Disconnect strut from structure and store on door.
- (4) Support door, remove hinge pin and remove door.
- (5) Remove form in place seal (A1-F18AC-SRM-500, WP010 00).

b. Installation.

- (1) Align door hinge to structure hinge and install hinge pin.
- (2) Raise door and install strut.
- (3) Install electrical leads.
- (4) Close door and check latch lock and unlock torque.
- (5) If latch lock or unlock torque is not 70-90 inch-pounds, adjust latch striker to 1.70 inch from striker housing, as shown on figure.

NOTE

Striker assembly to have equal thickness of shim under each flange.

- (6) Adjust thickness of latch striker shims as required until latch lock and unlock torque for both latches is 30 to 40 inch-pounds.
- (7) Adjust striker adjustment nut until latch lock and unlock torque for both latches is 70 to 90 inch-pounds.
- (8) Install form in place seal (A1-F18AC-SRM-500, WP010 00).
- (9) Inspect door area for foreign objects.
- (10) Close door (A1-F18AC-LMM-010).

5. **GUN LOADER DOOR (DOOR 6) HINGE PIN.** The new single pin is preferred for repair and will be installed on all aircraft. See figure 2.

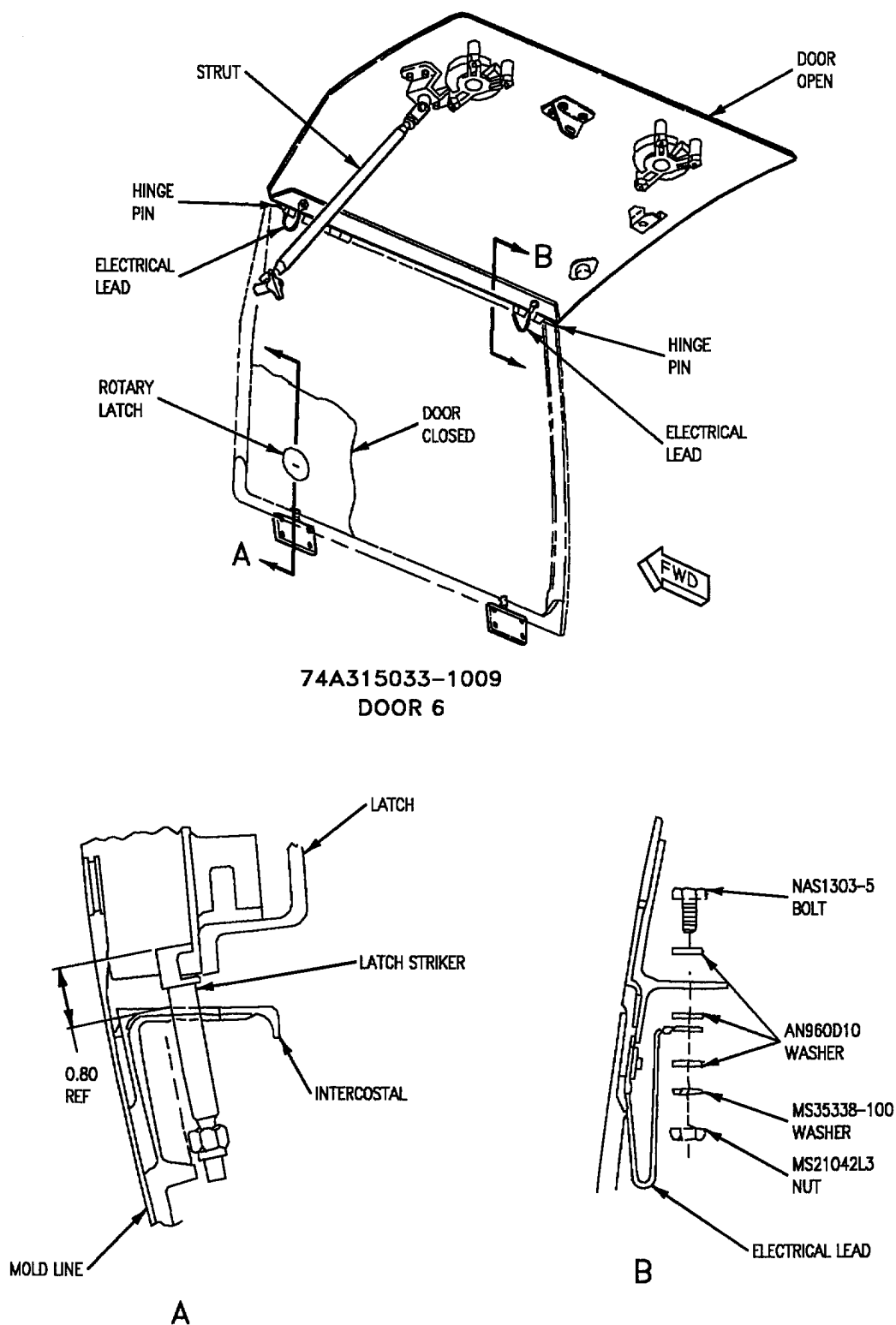


Figure 1. Door 6 Replacement (Sheet 1)

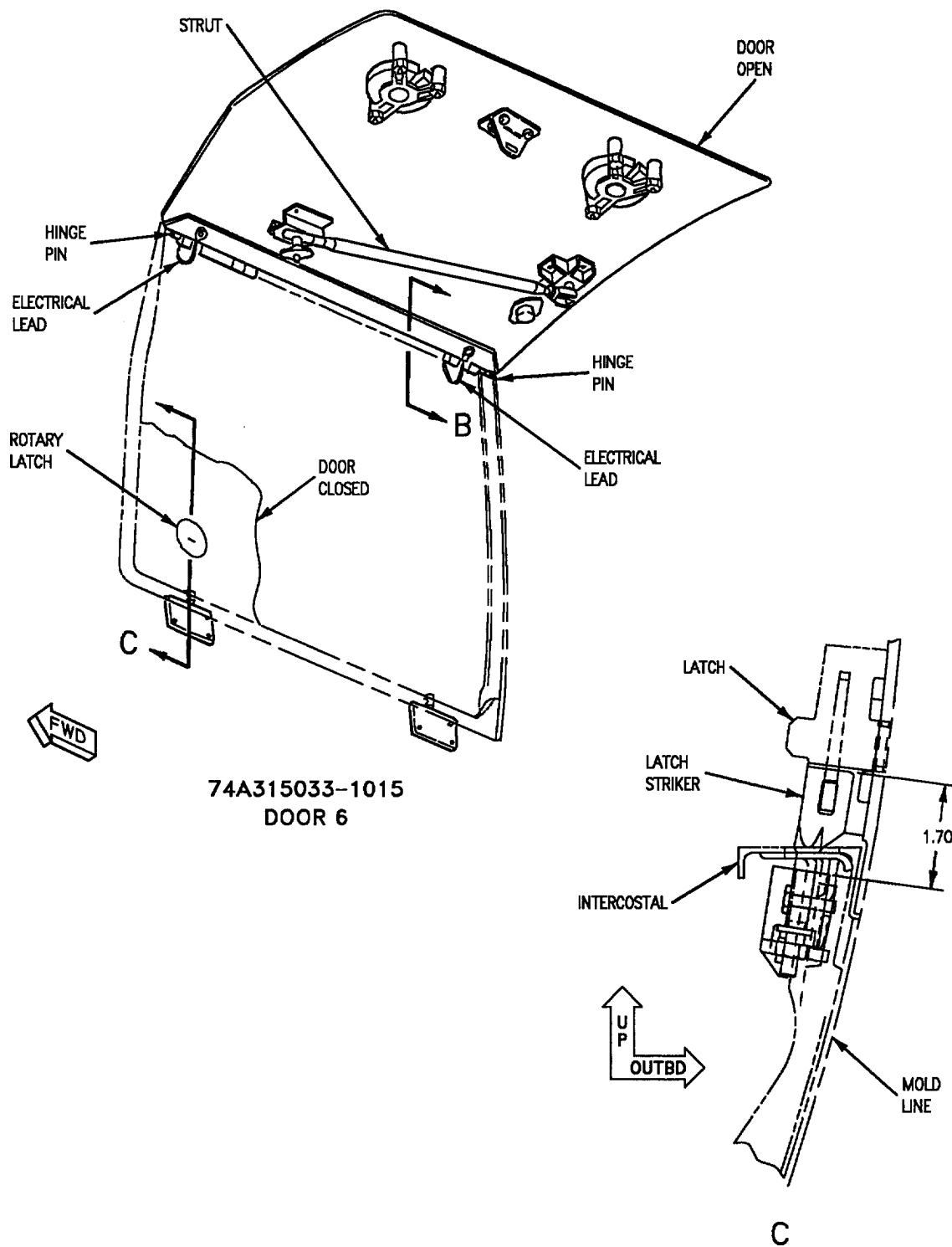


Figure 1. Door 6 Replacement (Sheet 2)

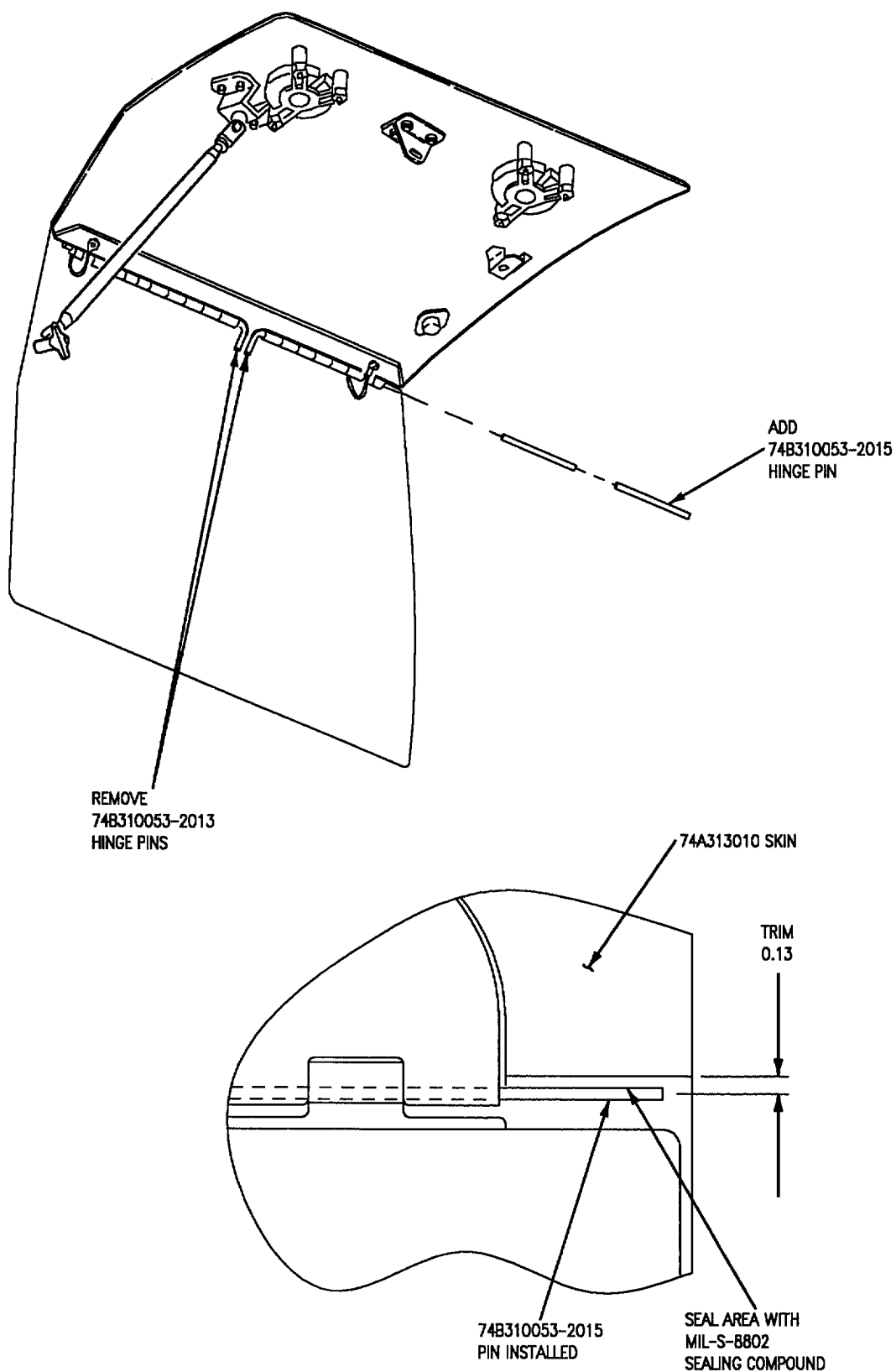


Figure 2. Gun Loader Door Hinge Pin Repair



Do not vibration drive rivets.

6. INDICATOR, HOLDBACK MECHANISM (DOOR

6). For replacement of holdback mechanism indicator, See figure 3.

7. **DOOR 10.** See figure 4. Door 10 is interchangeable. Remove and replace door 10 as listed below:

a. Removal.

(1) Remove hinge pin retainer.

(2) Open door (A1-F18AC-LMM-010).

(3) Remove electrical leads from structure. See section C of figure.

(4) Disconnect strut from structure and store in door.

(5) Support door and remove hinge pins through access at hinge pin retainer and remove door.

(6) Remove form-in-place seal (A1-F18AC-SRM-500, WP005 03).

b. Replacement.

(1) Align door hinge to structure hinge and install hinge pins.

(2) Install hinge pin retainer.

(3) Install electrical lead.

(4) Lower door and verify the dimension, 0.095 minimum and 0.175 maximum as shown in section A of figure. These dimensions must be satisfied when the door is held against the lower sill, finger pressure within 1 inch of lower edge, and all latches are open.

NOTE

If the dimension shown in Section A is not within the tolerances shown, corrective action shall be taken.

(5) With door open, remove the screw, washer, and nut from the latch vertical adjustment hole on door, four locations. See view B of figure.

(6) Adjust horizontal striker using substeps below:

NOTE

More than one striker may be adjusted at each operation.

(a) Adjust all striker heads to their highest point by turning the vertical adjustment setscrew counterclockwise.

(b) Loosen the four bolts on striker and slide the striker body as far inboard as possible. Retighten bolts as required to prevent horizontal motion.

(c) Close door, press on lower edge only, and turn latch.

(d) If cam does not engage, open door, loosen bolts and move striker body outboard one serration, 0.030.

(e) Close door, press on lower edge only, and turn latch.

(f) Repeat substep (d) until cam engages

(g) Open door and tighten striker attach bolts 50 to 70 inch-pounds torque.

(h) Close door and test torque to open and close latch. Torque shall be 100 plus or minus 50 inch-pounds to open and close latch.

(i) If the torque exceeds 150 inch-pounds, turn the vertical adjustment setscrew clockwise one full turn. Test torque to close latch.

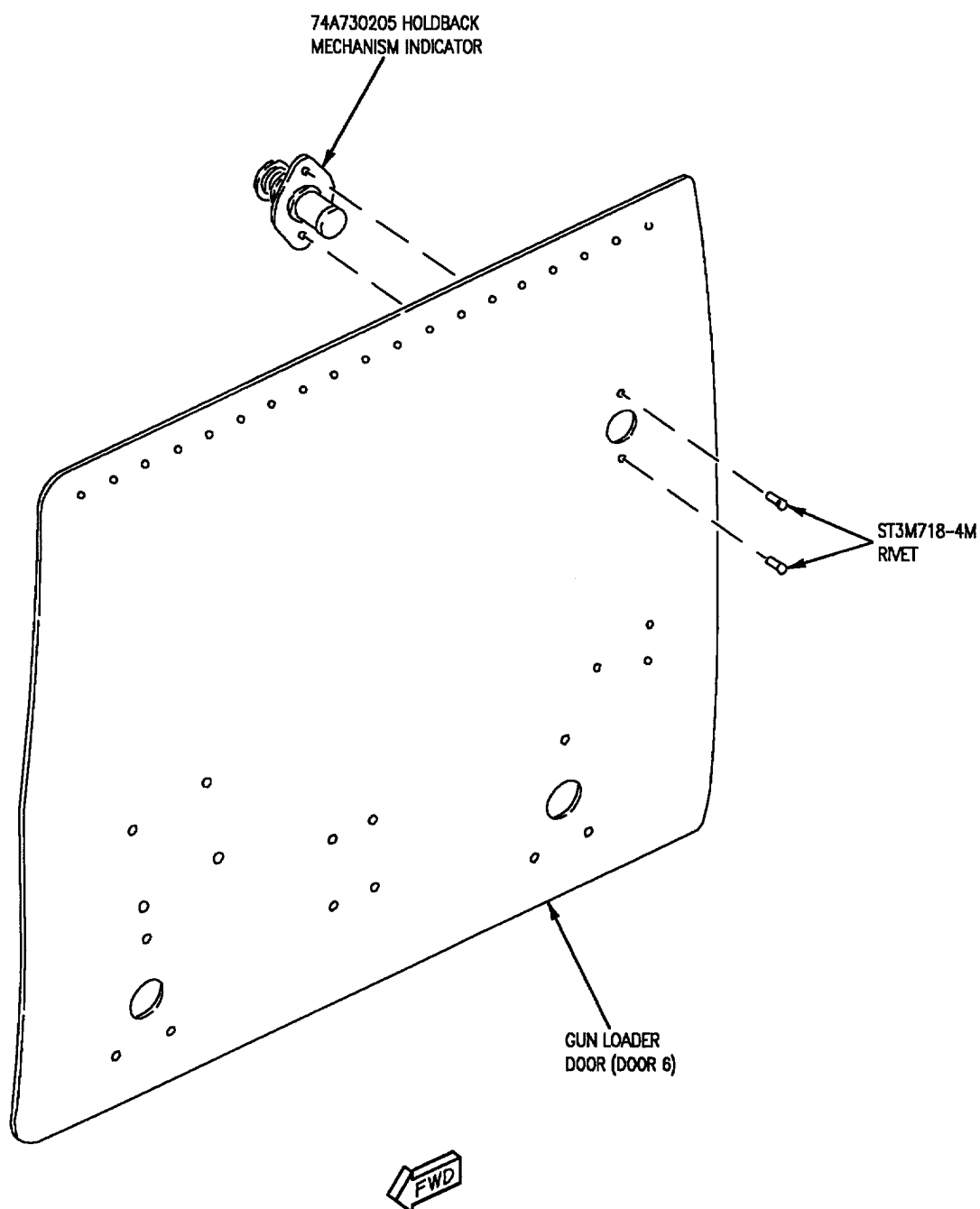
(j) If torque exceeds 150 inch-pounds, open door and move striker one serration outboard. If torque is less than 50 inch-pounds to door, move striker one serration inboard.

(k) Retighten striker attach bolts 50 to 70 inch-pounds of torque.

(l) Repeat steps (b) through (k) as required for each striker head.

(7) Adjust vertical striker using substeps below:

(a) With the door closed and latched, adjust center latches first by turning the vertical adjustment setscrew clockwise to make sure of contact between the striker head and latch in vertical direction.

**Figure 3. Indicator, Holdback Mechanism Replacement**

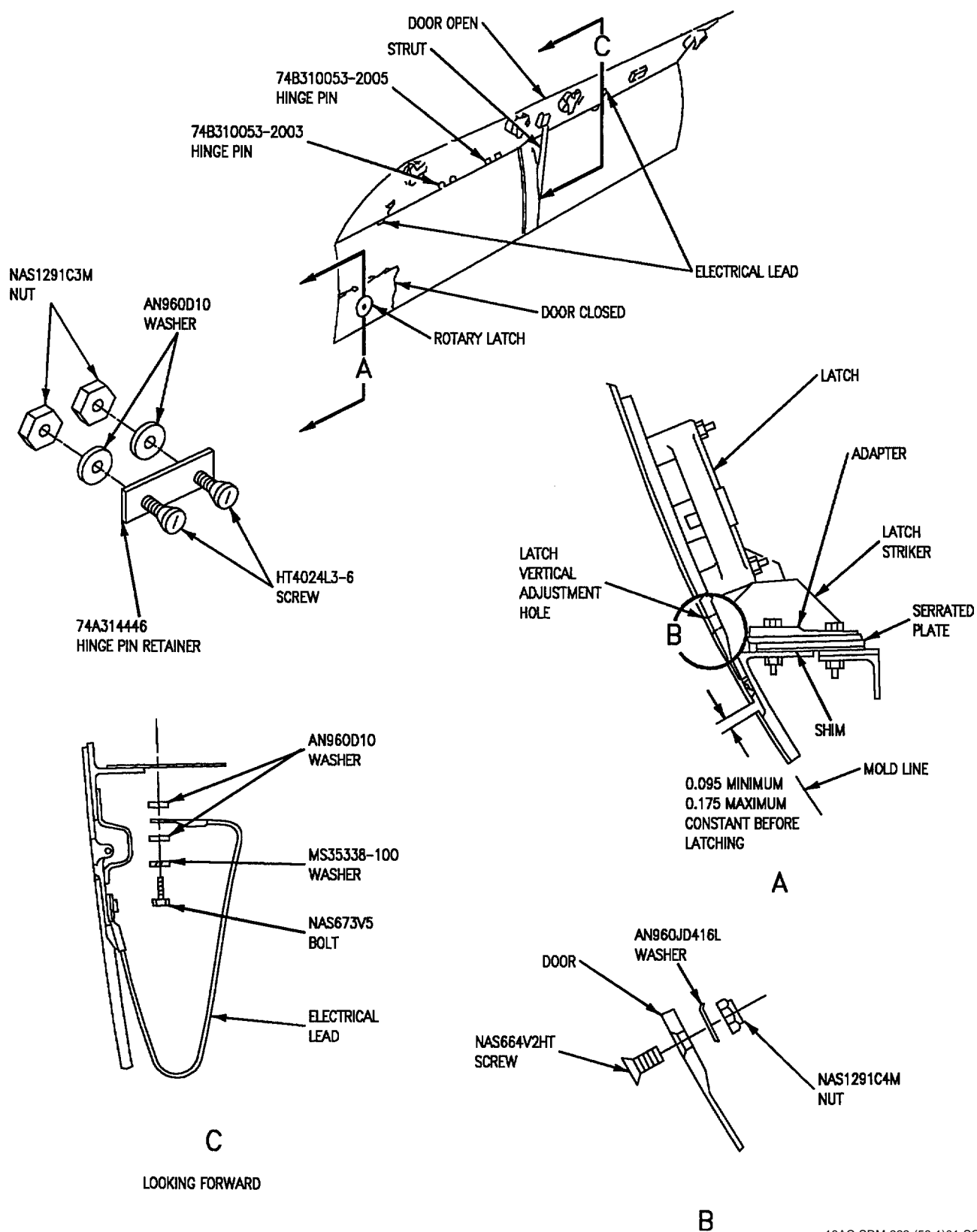


Figure 4. Door 10 Replacement

(b) Contact between the striker head and latch is made when there is a reduction in the gap between the lower edge of the door and the mold line skin below the door, when turning the vertical adjustment setscrew.

(c) Inspect mold line mismatch. Maximum mismatch is 0.040. If mismatch at forward or aft edge of door is greater than 0.040, turn (record number of turns) the forward and aft vertical adjustment setscrews clockwise until mold line mismatch is 0.040 or less. Turn center vertical adjustment setscrews same number of turns as forward setscrew. Maximum latch torque to be 250 inch-pounds.

(d) If mold line mismatch cannot be done and if latch torque is less than 250 inch-pounds, it is allowable to remove the shim under the striker serrated plate. Repeat steps b(6) and b(7).

(e) When mold line requirements have been satisfied, replace screws, washers, and nuts in all latch adjustment holes in the door. See View B of figure.

(f) Install form-in-place seal (A1-F18AC-SRM-500, WP005 03).

(g) Close door (A1-F18AC-LMM-010).

8. **DOOR 13.** See figure 5. Door 13 is interchangeable. Remove and replace door as listed below:

a. Removal.

(1) Remove hinge pin retainer.

(2) Open door (A1-F18AC-LMM-010).

(3) Remove electrical leads from structure. See section C of figure.

(4) Disconnect strut from structure and store in door.

(5) Support door and remove hinge pin through access at hinge pin retainer and remove door.

(6) Remove form-in-place seal (A1-F18AC-SRM-500, WP005 03).

b. Replacement.

(1) Align door hinge to structure hinge and install hinge pin.

(2) Install hinge pin retainer.

(3) Raise door and install strut.

(4) Install leads.

(5) Lower door and verify the dimension, 0.149 minimum/0.229 maximum as shown in section A of figure. These dimensions must be satisfied when the door is held against the lower sill, finger pressure within 1 inch of lower edge, and all latches are open.

NOTE

If the dimensions shown in Section A are not within the tolerances shown, corrective action shall be taken.

(6) With door open, remove the screw, washer, and nut from the latch vertical adjustment holes. See view B of figure.

(7) Adjust horizontal striker using substeps below:

NOTE

More than one striker may be adjusted at each operation.

(a) Adjust all striker heads to their highest point by turning the vertical adjustment setscrew counterclockwise.

(b) Loosen the four bolts on the striker and slide the striker body as far inboard as possible. Retighten bolts as required to prevent horizontal motion.

(c) Close door, press on lower edge only, and turn latch.

(d) If cam does not engage open door, loosen bolts and move striker body outboard one serration, 0.030.

(e) Close door, press on lower edge only, and turn latch.

(f) Repeat substep (d) until cam engages.

(g) Open door and tighten striker attach bolts 50 to 70 inch-pounds torque.

(h) Close door and test torque to open and close latch. Torque shall be 100 plus or minus 50 inch-pounds to open and close latch.

(i) If the torque exceeds 150 inch-pounds, turn the vertical adjustment setscrew clockwise one full turn. Test torque to close latch.

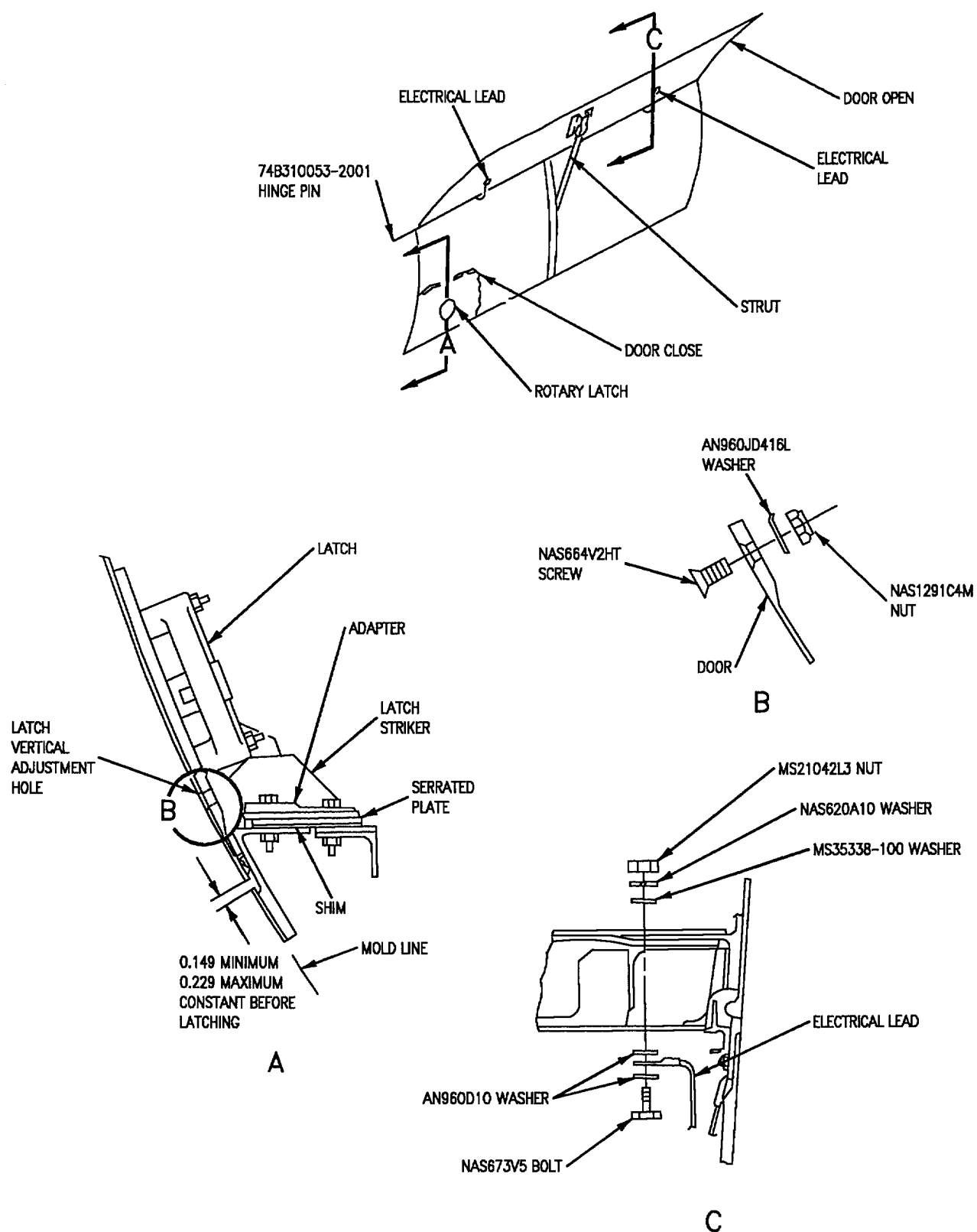


Figure 5. Door 13 Replacement

(j) If torque exceeds 150 inch-pounds, open door and move striker one serration outboard. If torque is less than 50 inch-pounds, open door and move striker one serration inboard.

(k) Retighten striker attach bolts 50 to 70 inch-pounds of torque.

(l) Repeat steps (b) through (k) as required for each striker head.

(8) Adjust vertical striker using substeps below:

(a) With the door closed and latched, adjust center latches first by turning the vertical adjustment setscrew clockwise to make sure of contact between the striker head and latch in vertical direction.

(b) Contact between the striker head and latch is made when there is a reduction in the gap between the lower edge of the door and the mold line skin below the door, when turning the vertical adjustment set screw.

(c) Inspect mold line mismatch. Maximum mismatch is 0.040. If mismatch at forward or aft edge of door is greater than 0.040, turn (record number of turns) the forward and aft vertical adjustment setscrews clockwise until mold line mismatch is 0.040 or less. Turn center vertical adjustment setscrews same number of turns as forward setscrew. Maximum latch torque to be 250 inch-pounds.

(d) If mold line mismatch cannot be done and if latch torque is less than 250 inch-pounds, it is allowable to remove the shim under the striker serrated plate. Repeat steps b(7) and b(8).

(e) When mold line requirements have been satisfied, replace screws and nuts in all latch adjustment holes in the door.

(f) Install form-in-place seal (A1-F18AC-SRM-500, WP005 03).

(g) Close door (A1-F18AC-LMM-010).

9. **DOOR 14.** See figure 6. Door 14 is interchangeable. Remove and replace Door 14 as listed below:

a. Removal.

(1) Remove hinge pin retainer.

(2) Open door (A1-F18AC-LMM-010).

(3) Remove electrical leads from structure. See section C of figure.

(4) Disconnect strut from structure and store in door.

(5) Support door and remove hinge pin through access at hinge pin retainer and remove door.

(6) Remove form-in-place seal (A1-F18AC-SRM-500, WP005 03).

b. Replacement.

(1) Align door hinge to structure hinge and install hinge pin.

(2) Install hinge pin retainer.

(3) Raise door and install strut.

(4) Install electrical leads.

(5) Lower door and verify the dimension, 0.149 minimum/0.229 maximum as shown in section A of figure. These dimensions must be satisfied when the door is held against the lower sill, finger pressure within 1 inch of lower edge, and all latches are open.

NOTE

If the dimensions show in section A are not within the tolerances shown, corrective action shall be taken.

(6) With door open, remove the screw, washer, and nut from the latch vertical adjustment holes. See view B of figure.

(7) Adjust horizontal striker using substeps below:

NOTE

More than one striker may be adjusted at each operation.

(a) Adjust all striker heads to their highest point by turning the vertical adjustment setscrew counterclockwise.

(b) Loosen the four bolts on striker and slide the striker body as far inboard as possible. Retighten bolts as required to prevent horizontal motion.

(c) Close door, press on lower edge only, and turn latch.

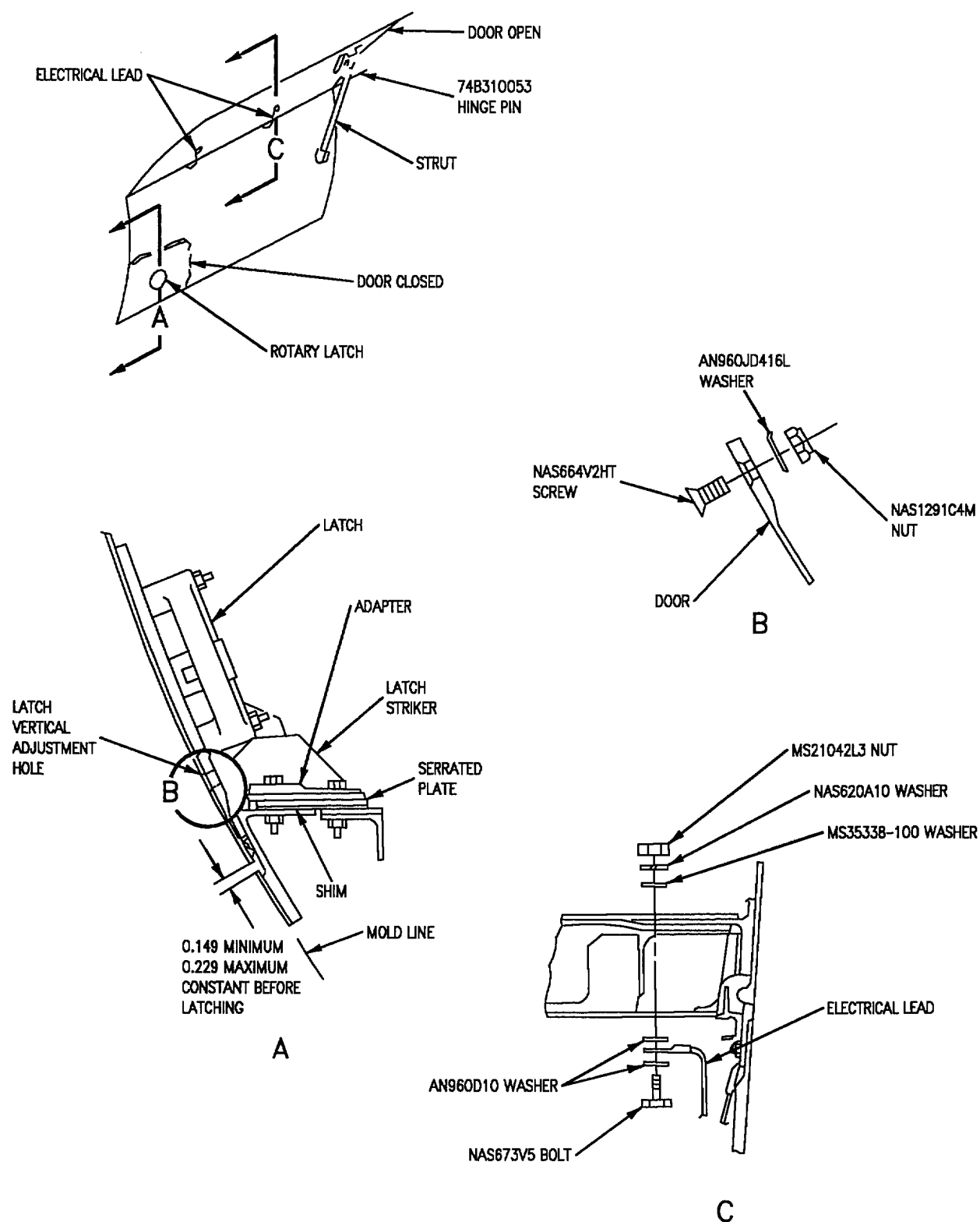


Figure 6. Cover (Door 14) Replacement

(d) If cam does not engage open door, loosen bolts and move striker body outboard one serration, 0.030.

(e) Close door, press on lower edge only, and turn latch.

(f) Repeat substep (d) until cam engages.

(g) Open door and tighten striker attach bolts 50 to 70 inch-pounds torque.

(h) Close door and test torque to open and close latch. Torque shall be 100 plus or minus 50 inch-pounds to open and close latch.

(i) If the torque exceeds 150 inch-pounds, turn the vertical adjustment setscrew clockwise one full turn. Test torque to close latch.

(j) If torque exceeds 150 inch-pounds, open door and move striker one serration outboard. If torque is less than 50 inch-pounds, open door and move striker one serration inboard.

(k) Retighten striker attach bolts 50 to 70 inch-pounds of torque.

(l) Repeat steps (b) through (k) as required for each striker head.

(8) Adjust vertical striker using substeps below:

(a) With the door closed and latched, adjust center latches first by turning the vertical adjustment setscrew clockwise to make sure of contact between the striker head and latch in vertical direction.

(b) Contact between the striker head and latch is made when there is a reduction in the gap between the lower edge of the door and the mold line skin below the door, when turning the vertical adjustment setscrew.

(c) Inspect mold line mismatch. Maximum mismatch is 0.040. If mismatch at forward or aft edge of door is greater than 0.040, turn (record number of turns) the forward and aft vertical adjustment setscrews clockwise until mold line mismatch is 0.040 or less. Turn center vertical adjustment setscrews same number of turns as forward setscrew. Maximum latch torque to be 250 inch-pounds.

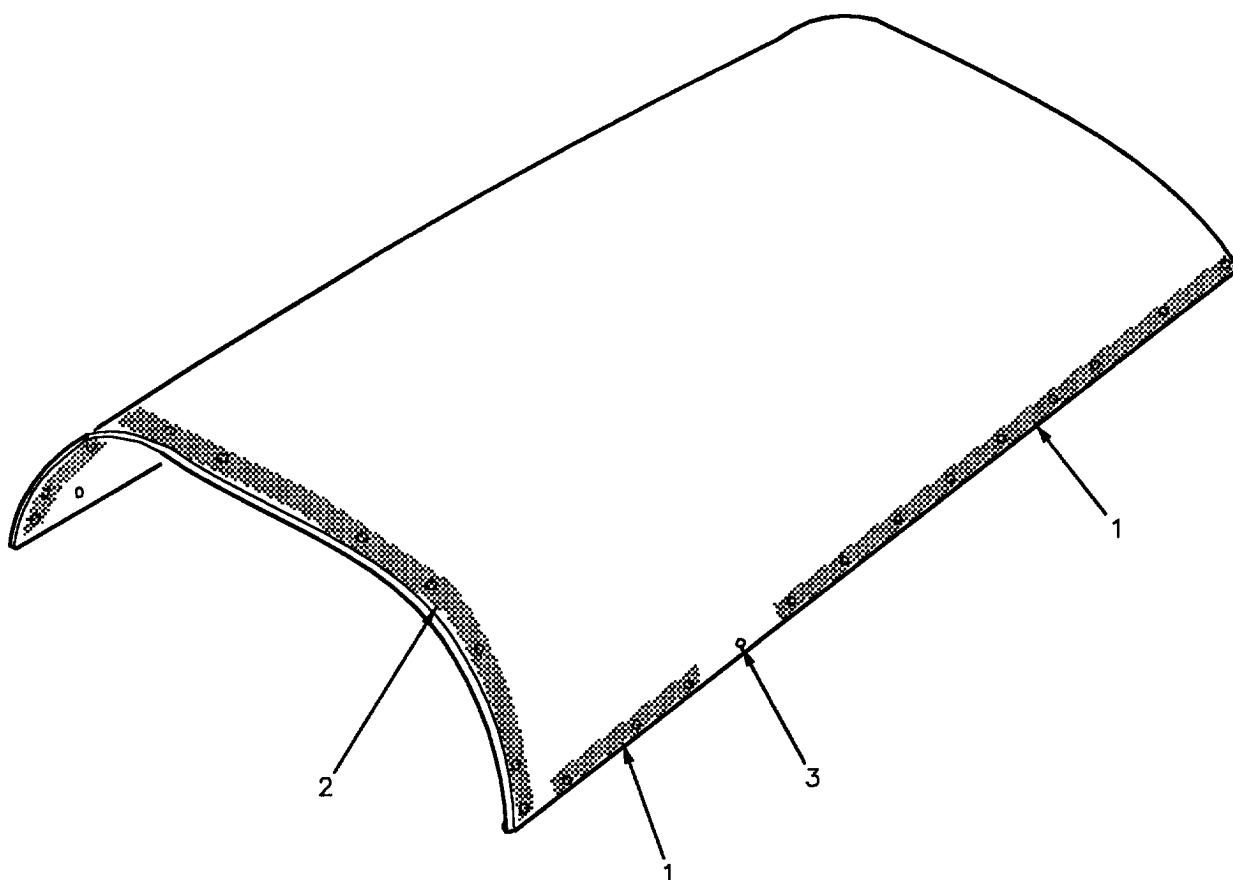
(d) If mold line mismatch cannot be done and the latch torque is less than 250 inch-pounds, it is allowable to remove the shim under the striker serrated plate. Repeat steps b(7) and b(8).

(e) When mold line requirements have been satisfied, replace screws and nuts in all latch adjustment holes in the door.

(f) Install form in place seal (A1-F18AC-SRM-500, WP005 03).

(g) Close door (A1-F18AC-LMM-010).

10. **DOOR 18.** See figure 7. Door 18 is interchangeable. Minor trimming may be required on aft edge (A1-F18AC-SRM-200, WP004 03). Fastener attaching hardware is shown on figure 7. For fasteners (A1-F18AC-SRM-420, FIG 023 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). For form in place seal with EMI gasket (A1-F18AC-SRM-500, WP005 02). Apply finish system as required (A1-F18AC-SRM-500, WP024 00).



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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49249E4-2
2			Plate Nut	F51827-4-10
3	 	 	Plate Nut Plate Nut	F49249E4-2 F49251E4-2
LEGEND				
Hole diameter is 0.281 +0.020 -0.000.				
F/A-18A 161353 THRU 161978.				
F/A-18A 161979 AND UP.				

Figure 7. Door 18 Replacement

ORGANIZATIONAL AND INTERMEDIATE MAINTENANCE

STRUCTURE REPAIR

COCKPIT INTERNAL DOORS AND COVERS

Reference Material

Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Crew Station Equipment - Instl of (Cockpit) (Kickshield Panels, Glare Shield Panel, Map and Data Case, Liner and Insulation)	FIG 015 00
Fuselage Section - Fwd Fus, Structure	FIG 023 00
Fuselage Nose Section - Fwd Fus, Assy of	FIG 024 00
Deck Assy - Canopy Sill, Fwd Fus, F/A-18A (Y260.677 to Y383.000)	FIG 035 00
Fuselage Section - Fwd Fus, Side Panel, Aft	FIG 042 00
Structure Installation - Main Instrument and Console Panel (Cockpit)	FIG 014 00
Shield, EMI - Upr Eqpt Bay, Instl of	FIG 040 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Structure Repair, General Information	A1-F18AC-SRM-200
Introduction	WP002 00
Locating Blind Holes and Trim Lines	WP004 03
Gang Channel and Plate Nut Identification and Repair	WP004 05
Adhesive, Cement, and Sealant; Preparation and Application	WP011 00
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Aluminum Patch Fabrication	WP006 01
Aluminum, Graphite Epoxy, or Titanium Patch Installation and Removal	WP007 00
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Aluminum Sheet Edge Repair	WP034 00
Aluminum Sheet Repairs, Across Structure and Lands	WP036 00
Blending	WP038 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Windshield, Canopy, and Cockpit Finish System	WP021 00

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Repairs	3
Permanent Repairs	3
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Cover, 74A314108, (EMI Shield) Repair, 162835 AND UP	5
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Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F/A-18 AFC 142	1 Jan 91	Upper Equipment Bay EMI Cover Assembly Installation	1 Mar 92	Navy Issued L-36-89

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figures 1 and 19. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Damage not listed or exceeding the following limits require a depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

4. **REPAIRABLE DAMAGE.** The types and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with figure and index numbers in the material index, figure 1.

NOTE

The limits in table 2 apply after blending the damage.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and lands must have edge of cleanup hole at least eight repair fastener diameters from any land, internal structure, or existing row of fasteners.

(2) Damage to lands, over structure, only one repair per land.

e. Dents exceeding the limits in Table 1 must be repaired.

5. REPAIRS.

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definition are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

7. PERMANENT REPAIRS.

8. Scratches, Nicks, Gouges, or Corrosion.

Blend scratches, nicks, gouges, or corrosion (A1-F18AC-SRM-250, WP038 00). If, after blending, the damage limits of table 2 are exceeded, repair aluminum sheet.

a. Scratches - make crack or edge repairs.

b. Nicks, gouges, or corrosion - make hole or edge repair.

9. Cracks.

a. In repair zones A1, A3 and A4, repair cracks free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Stop drill ends of crack in repair zone A1 or route out crack in repair zone A3. Completely cut out crack in smallest diameter circle possible in repair zone A4.

(2) In repair zones A1 and A3, install a lap patch for cracks.

(3) In repair zone A4, install a type two flush or lap patch.

(4) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone B3, repair cracks free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out crack in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

c. In repair zones A1, A3 and A4, repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

d. In repair zones A1, A3 and A4, repair cracks in aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

10. Holes.

a. In repair zones A1, A3 and A4, repair holes free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) In repair zones A1 and A3, install a type one flush or lap patch. In repair zone A4, install a type two flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone B3, repair holes free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

c. In repair zones A1, A3 and A4, repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, make repairs.

(a) Damage to Bay Requiring Repair Across Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair Across Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay; install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

d. In repair zones A1, A3 and A4, repair holes in aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

11. Edge. In repair zones A1, A3 and A4, repair edge damage in aluminum sheet (A1-F18AC-SRM-250, WP034 00).

a. Cut out damage.

b. Select and install repair patch.

(1) Corner Damage to Lands.

(2) Corner Damage to Lands and Bays.

(3) Edge Damage to Lands.

(4) Edge Damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

12. Dents.

a. In repair zones A1, A3 and A4, repair dents free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) In repair zones A1 and A3, install a type one flush or lap patch. In repair zone A4, install a type two flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone B3, repair dents free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

c. In repair zones A1, A3 and A4, repair dents across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, make repairs.

(a) Damage to Bay Requiring Repair Across Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair Across Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay; install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

d. In repair zones A1, A3 and A4, repair dents to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zones A1, A3 or A4, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

13. Cover, 74A314108, (EMI Shield) Repair, 161353 THRU 162834. See figure 3. Damage less than 1 inch in length need not be repaired. Repairs above 1 inch in length may be unlimited in both length and number.

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Soldering Iron/Gun

Materials Required

Specification or Part Number	Nomenclature
QQ-S-571 SN63-0-032DIA	Solder, Tin Alloy
MIL-F-14256 TYPE R	Flux, Soldering
0045R26X1	Wire, Mesh Tape
MMS-409	Cleaning Solvent for Electrical Components



Solvent, Cleaning, MMS-409

19

a. Clean damaged area with cleaning solvent.

b. Cut and fit wire mesh tape at damage, see figure.

NOTE

Solder seam must be completely around periphery of the damaged area.

c. Solder tape.

d. Clean repaired area with cleaning solvent.

14. Cover, 74A314108, (EMI Shield) Repair, 162835 AND UP. See figure 4. No repair required for damage less than 1 inch in length. Damage over 1 inch is unlimited in length and number and shall be repaired.

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Sewing Machine

Materials Required

Specification or Part Number	Nomenclature
302 or 304 Cres	Screen Wire, 0.011 Inch Dia.; Knit Weave, Single Strand
Fed Spec V-T-285D	Polyester Thread; Type I, Class 1, Subclass A; Twist Z, Color Natural (White) Size FF; Breaking Strength 16 Pounds

a. Cut a patch of screen at least 0.75 inch on all sides larger than the damage.

b. Machine stitch a seam 0.50 inch from damage completely around the periphery of the damaged area, using polyester thread, 6 to 8 stitches per inch. Back-stitch 0.50 inch from end of stitch.

c. Machine stitch a seam 0.125 inch from inside seam all the way around, 6 to 8 stitches per inch. Back-stitch 0.50 inch from end of stitch. End of patch to first seam to be no less than 0.25 inch.

15. EMI INSPECTION OF FASTENER HOOKS.

Support Equipment Required

Part Number or Type Designation	Nomenclature
77AN	Digital Multimeter
-	Sewing Machine

Materials Required**Specification
or Part Number****Nomenclature**

191034
V-T-285-D, TYPE 1,
CLASS 1, SUB CLASS
A, TWIST Z,
NATURAL COLOR,
SIZE FF,
BREAK STRENGTH
16 POUNDS

Fastener Hook
Polyester Thread

2 Shiny Pennies

NOTE

Be sure resistance measurements are made

across cuts or across different sections of
fastener hooks.

a. Turn EMI screen so that fastener hooks are
face up.

b. Place two shiny pennies on opposite ends of
fastener hook section.


c. Firmly place multimeter positive lead on one
penny and the negative lead on the other penny.

d. Wait for meter fluctuation to cease or to reach
lowest resistance reading.

e. Divide resistance reading by the length of the
hook section to obtain ohms per inch. If the value
obtained is greater than 2.0 ohms per inch, replace
that section of fastener hook.

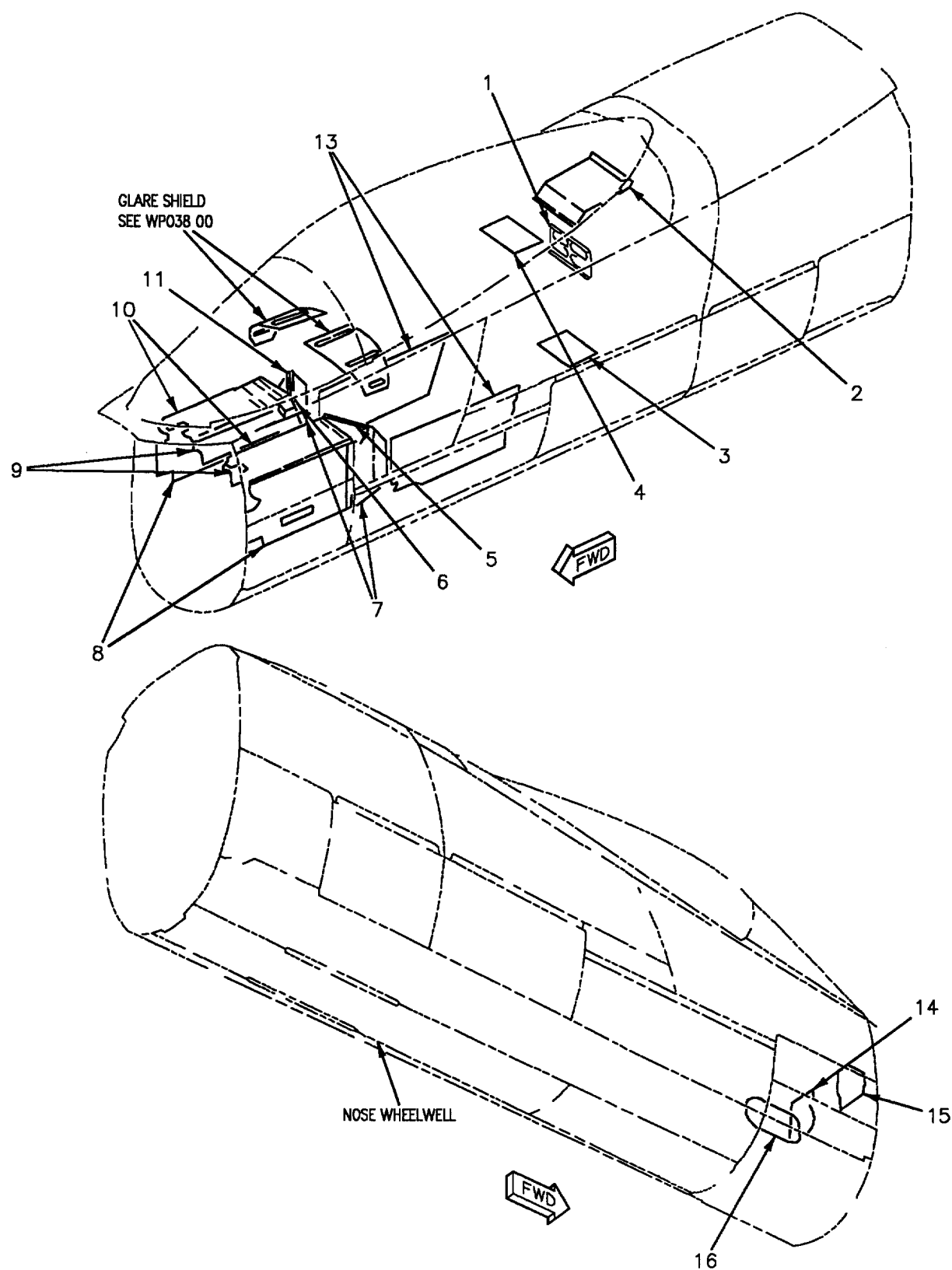
f. Repeat for each section of fastener hook on
screen.

Table 1. Negligible Damage Limits

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Door (CPA) Zone B4	0.032	0.0006	0.0006	100%	 0.010	N/A
		0.020	0.0006	0.0006	100%		N/A
Fig 1 (2)	Door (CPB) Zone A1	0.032	0.0006	0.0006	100%	0.016	N/A
Fig 1 (3)	Door (CPI) Zone A1	0.040	0.008	0.0006	100%	0.020	N/A
Fig 1 (14)	Door (NWB) Zone A4 Zone B4	0.063	0.0006	0.0006	100%	0.031	N/A
		0.032	0.0006	0.0006	100%	0.016	N/A
Fig 1 (15)	Door (NWA) Zone A4 Zone B4	0.063	0.0006	0.0006	100%	0.031	N/A
		0.032	0.0006	0.0006	100%	0.016	N/A
Fig 1 (16)	Door (NWC) Zone A3	0.040	0.008	0.0006	100%	0.020	N/A

NOTE

 None allowed.



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Figure 1. Material Index (Sheet 1)

























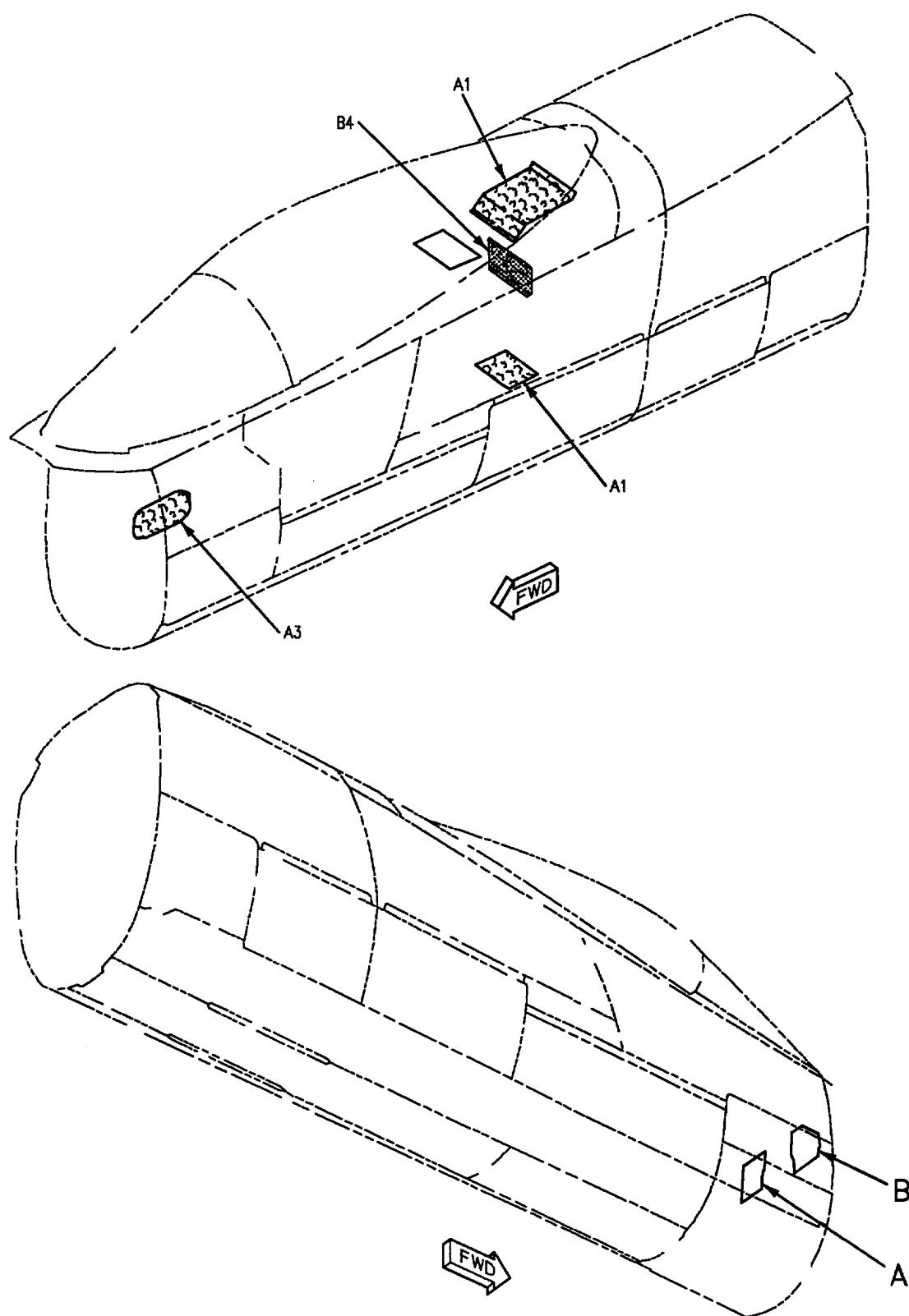
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1		Cover (Door CPA) 74A314077-2003	 Sheet	7075-T6 Alclad
2		Cover (Door CPB) 74A314063-2001	0.032 Sheet	6061-T6 Al Aly
3		Cover (Door CPI) 74A314231-2061	0.040 Sheet	7075-T6 Alclad
4	  	Cover (EMI Shield) 74A314108-2093 74A314108-2175 74A314108-2243	  	  
5		Closure (Door CPU) 74A800656-2007	0.040 Sheet	7075-T6 Alclad
6		(Door CPV) 74A620054-2009	0.032 Sheet	7075-T6 Alclad
7	 	Kickshield (Door CPR) 74A800671-2025, -2026 74A800671-9015, -9016	Sheet	Polycarbonate
8	   	Kickshield (Door CPQ) 74A800671-2011, -2024 74A800671-2033, -2034 74A800671-9017, -9018 74A800671-2043, -2044	Sheet	Thermoplastic Polycarbonate Polycarbonate
9	  	Kickshield (Door CPS) 74A800670-2015, -2016 74A800670-2019, -2020 74A800670-9003, -9004	Sheet	Thermoplastic Polycarbonate
10	   	Kickshield (Door CPK) 74A800669-2009, -2010 74A800669-2023, -2024 74A800669-2029, -2030 74A800669-9003, -9004	Sheet	Thermoplastic Polycarbonate
11		Closure (Door CPW) 74A800657-2007	0.040 Sheet	7075-T6 Alclad
12		Deleted		

Figure 1. Material Index (Sheet 2)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
13	<div>10</div> <div>16</div> <div>15</div>	Cover (Door CPP) 74A800739-2039, -2045 74A800739-2039, -2061 74A800739-9029, -9027	0.030 Sheet	Thermoplastic Polycarbonate
14		Web (Door NWB) 74A313090-2209	0.063 Sheet	7075-T6 Alclad
15		Web (Door NWA) 74A313090-2213	0.063 Sheet	7075-T6 Alclad
16		Cover (Door NWC) 74A314207-2051	0.040 Sheet	7075-T6 Alclad
LEGEND <div>1</div> Land is 0.032, bay is 0.020. <div>2</div> See figure 19 for material index. <div>3</div> F/A-18A 161353 THRU 161519. <div>4</div> F/A-18A 161520 THRU 162834. <div>5</div> 161353 THRU 161359. <div>6</div> 161360 THRU 162477. <div>7</div> 161360 THRU 161708. <div>8</div> 161709 THRU 162477, 162882 AND UP. <div>9</div> 161925 AND UP. <div>10</div> 161353 THRU 161924. <div>11</div> 161360 THRU 162477, 162882 AND UP. <div>12</div> F/A-18A 162835 AND UP. <div>13</div> 161353 THRU 162477, 162882 AND UP. <div>14</div> 162882 AND UP. <div>15</div> 162826 THRU 162881. <div>16</div> 161925 THRU 162477, AND 162882 AND UP.				

Figure 1. Material Index (Sheet 3)



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Figure 2. Repair Zones (Sheet 1)

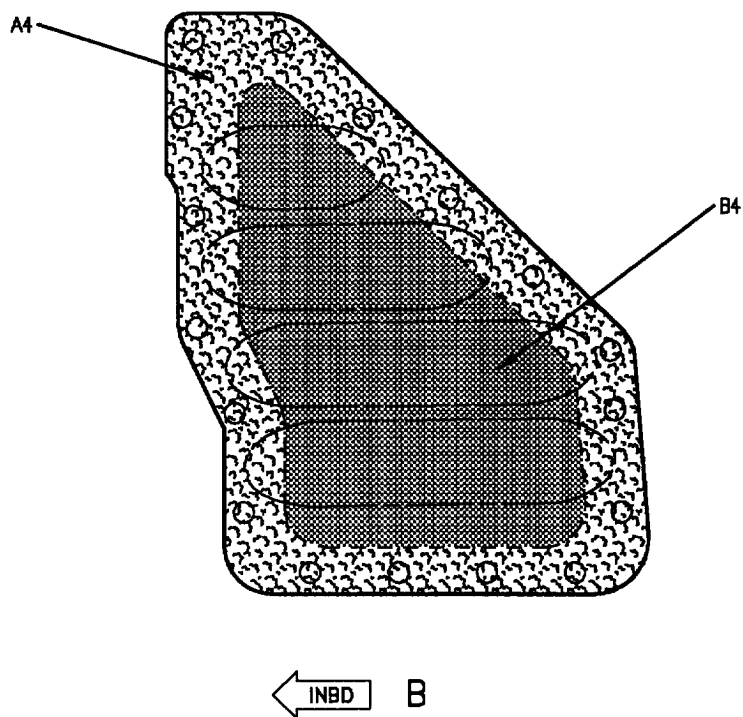
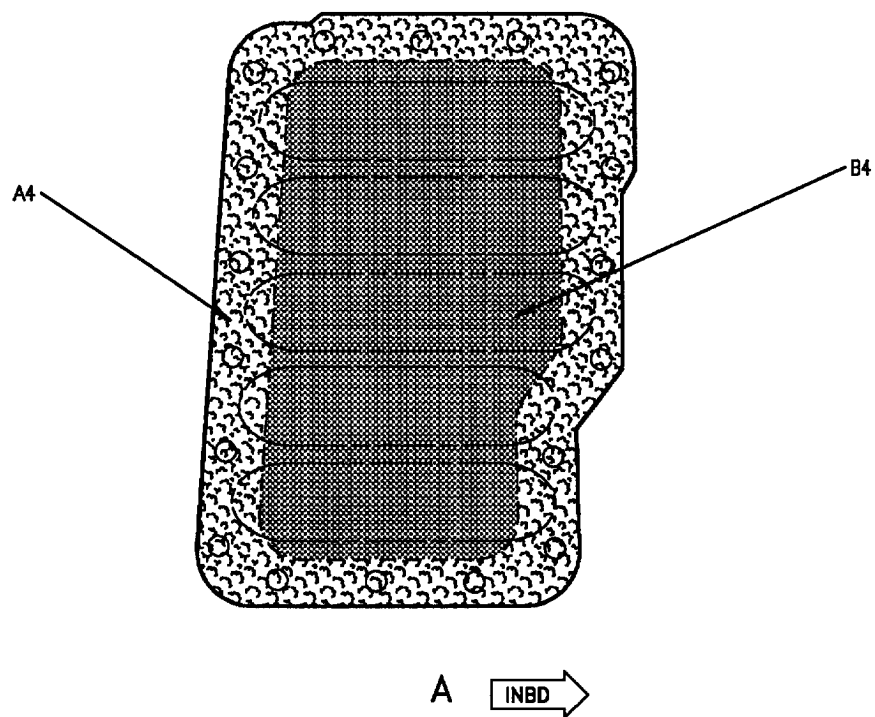


Figure 2. Repair Zones (Sheet 2)

16. REPLACEMENT.

17. Fastener attaching hardware is shown for covers as below:

a. Cover (Door CPA) is replaceable and requires drilling. For locating blind holes (A1-F18AC-SRM-200, WP004 03). Fastener attaching hardware is shown on figure 5. For fasteners A1-F18AC-SRM-420, FIG 023 00).

b. Cover (Door CPB) is interchangeable. Fastener attaching hardware is shown on figure 6. For fasteners (A1-F18AC-SRM-420, FIG 035 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

c. Cover (Door CPI). Fastener attaching hardware is shown on figure 7. For fasteners (A1-F18AC-SRM-420, FIG 042 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

d. Kickshield (Door CPK) is interchangeable. Fastener attaching hardware is shown on figure 8. For fasteners (A1-F18AC-SRM-420, FIG 015 00).

e. Cover (Door CPP) is interchangeable. Fastener attaching hardware is shown in figure 9. For fasteners (A1-F18AC-SRM-420, FIG 015 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

f. Kickshield (Door CPQ) is interchangeable. Fastener attaching hardware is shown on figure 10. For fasteners (A1-F18AC-SRM-420, FIG 015 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

g. Kickshield (Door CPR) is interchangeable. Fastener attaching hardware is shown on figure 11. For fasteners (A1-F18AC-SRM-420, FIG 015 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

h. Kickshield (Door CPS) is interchangeable. Fastener attaching hardware is shown on figure 12. For fasteners (A1-F18AC-SRM-420, FIG 015 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

i. Closure (Door CPU) is interchangeable. Fastener attaching hardware is shown on figure 13. For fasteners (A1-F18AC-SRM-420, FIG 014 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

j. Cover (Door CPV) is interchangeable. Fastener attaching hardware is shown on figure 14. For fasteners (A1-F18AC-SRM-420, FIG 042 00).

k. Closure (Door CPW) is interchangeable. Fastener attaching hardware is shown on figure 15. For fasteners (A1-F18AC-SRM-420, FIG 014 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

l. Web (Door NWA) is replaceable and requires drilling. For locating blind holes (A1-F18AC-SRM-200, WP004 03). Fastener attaching hardware is shown on figure 16. For fasteners (A1-F18AC-SRM-420, FIG 024 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

m. Web (Door NWB) is replaceable and requires drilling. For locating blind holes (A1-F18AC-SRM-200, WP004 03). Fastener attaching hardware is shown on figure 17. For fasteners (A1-F18AC-SRM-420, FIG 024 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

n. Cover (Door NWC) is interchangeable. Fastener attaching hardware is shown on figure 18. For fasteners (A1-F18AC-SRM-420, FIG 042 00).

o. EMI shield (74A314108) is interchangeable. Fastener tape is shown on figure 19 and (A1-F18AC-SRM-420, FIG 040 00).

18. **Pile, Fastener, EMI Shield -161353 THRU 161519.** See figure 19. Remove and replace as listed below.



Adhesive, EC847

13

Support Equipment Required

None



Wear gloves while bonding to make sure repair will bond correctly.

Materials Required

Specification or Part Number	Nomenclature
A-A-1047 GRIT 180 and 240-9 X11	Paper, Abrasive
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
MIL-C-38736 EC847	Cleaning Compound Adhesive
-	Velcro Fastener Tape
ZZ-G-381 TYPE 1 STYLE 1 Large	Gloves, Chemical

e. Apply a brush coat of adhesive evenly over structure and tape. If second coat is needed, allow 30 minutes between applications. Allow adhesive to air dry until it gets tacky.

f. Install tape in place. Apply hand pressure to make sure tape is bonded correctly.

g. Allow to air cure at room temperature for a minimum of 24 hours before stressing the bonded re-
pair.

19. **74A314108 Velcro Fastener Loop.** See figure 19.

Support Equipment Required

Part Number or Type Designation	Nomenclature
77AN	Digital Multimeter

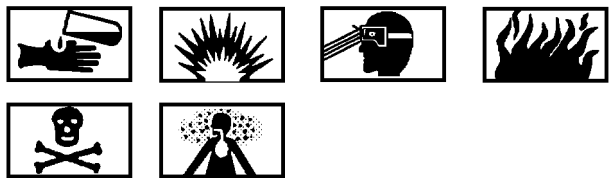
Materials Required

Specification or Part Number	Nomenclature
TT-I-735	Isopropyl Alcohol
CCC-C-440TY1CL1	Cheesecloth
MIL-S-81733 TYPE 4-12	Sealing Compound
MS20470AD5	Rivet (As Required)
4M27C5	Washer (As Required)
190960 (CAGE 11153)	Velcro Fastener Loop

a. Remove EMI screen.

b. Using digital multimeter, measure resistance of each section of fastener loop as follows:

(1) Firmly place multimeter leads on opposite ends of the fastener loop section without piercing fastener loop or touching rivets.



Cleaning Compound, MIL-C-38736 4

d. Clean surface with cheesecloth dampened with metal cleaning compound until all traces of old adhesive are gone.

(2) Wait for multimeter fluctuation to cease or to reach lowest resistance value.

(3) Divide resistance reading by the length of the loop section to obtain ohms per inch. If the value obtained is greater than 1.5 ohms per inch for any loop section, replace it per steps c through l. If less than 1.5 ohms, reinstall screen.



Use care when drilling out rivets not to damage structure.

- c. Drill out rivets attaching velcro fastener loop and titanium strip to structure.
- d. Remove velcro fastener loop and titanium strip.



Isopropyl Alcohol, TT-I-73515

e. Clean area where titanium strip and structure mate using clean cheesecloth moistened with isopropyl alcohol.

f. Clean area free of any foreign objects.






g. Fabricate new velcro fastener loop same length as titanium strip from 1.00 inch wide velcro fastener loop bulk material.

h. Transfer hole pattern from titanium strip to velcro fastener loop.

NOTE

If titanium strip requires replacement, fabricate from 0.020 inch thick, 1.00 inch wide, 6AL-4V titanium per MIL-T-9046 Type 3, Composition C, Condition Annealed.

i. Place velcro fastener loop on titanium strip position on structure, detail, D.



Sealing Compound, MIL-S-81733, Type 4-125

- j. Fillet seal around edge of gasket.
- k. Install rivets.
- l. Install EMI screen.

20. 74A314108 Velcro Fastener Loop - 161520 AND UP. See figure 19.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
P-D-680 TYPE II	Dry Cleaning Solvent
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
MIL-S-81733 TYPE 4-12	Sealing Compound
MS20470AD5	Rivet (As Required)
4M27C5	Washer (As Required)
HI-MEG No. 1000	Velcro Fastener Loop

- a. Remove EMI screen.



Use care when drilling out rivets not to damage structure.

- b. Drill out rivets attaching velcro fastener loop and titanium strip to structure.
- c. Remove velcro fastener loop and titanium strip.



Dry Cleaning Solvent, P-D-680, Type II7

d. Clean area where titanium strip and structure mate using clean cheesecloth moistened with dry cleaning solvent.

e. Clean area of any foreign objects.

f. Fabricate new velcro fastener loop same size as titanium strip from 1.00 inch wide velcro fastener loop bulk material.

g. Transfer hole pattern from titanium strip to velcro fastener loop.

NOTE

If titanium strip requires replacement, fabricate from 0.020 inch thick, 1.00 inch wide, 6AL-4V titanium per MIL-T-9046 Type 3, Composition C, Condition Annealed.

h. Place velcro fastener loop on titanium strip and position on structure, detail K.

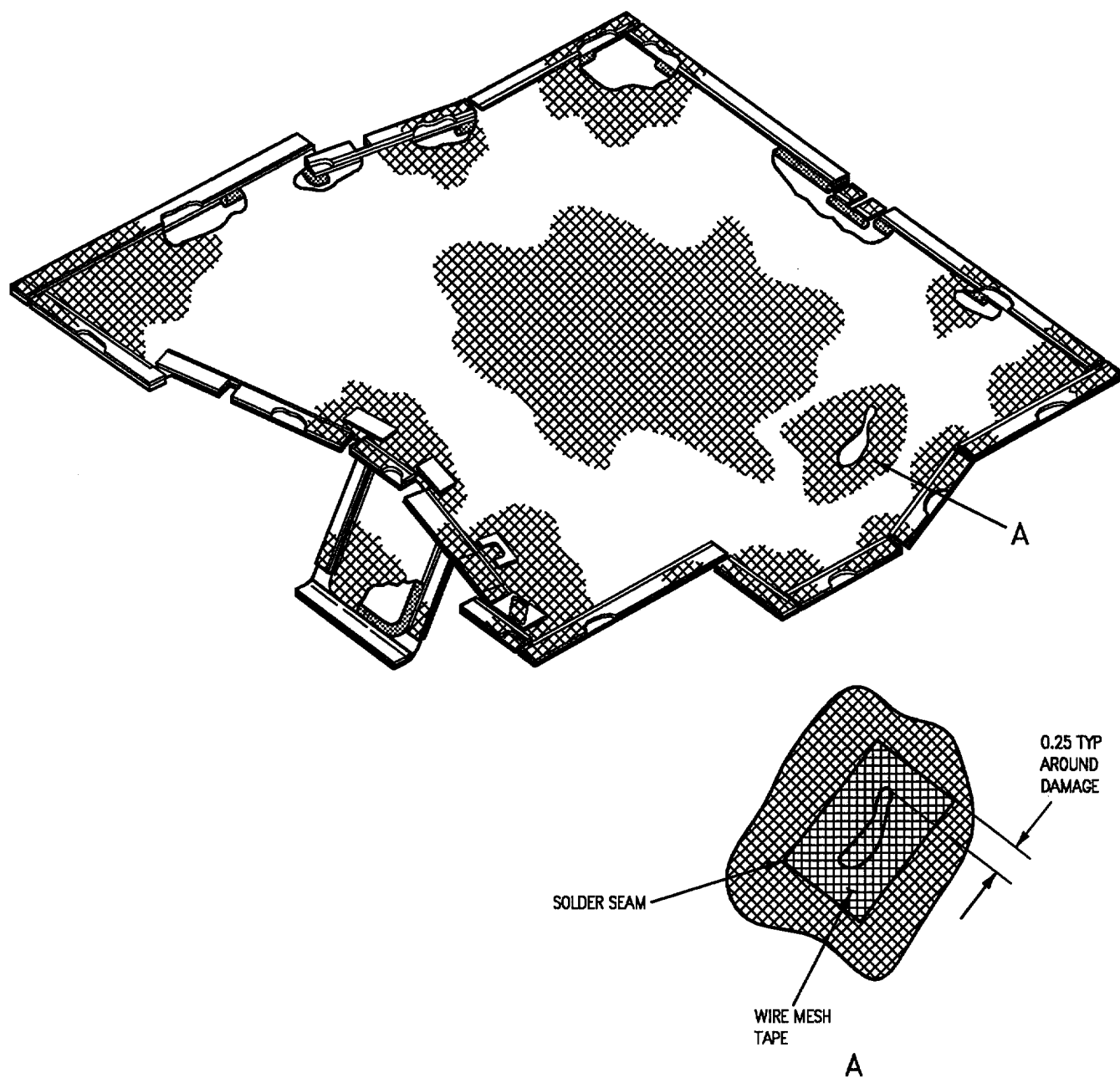


Sealing Compound, MIL-S-81733, Type 4-12

5

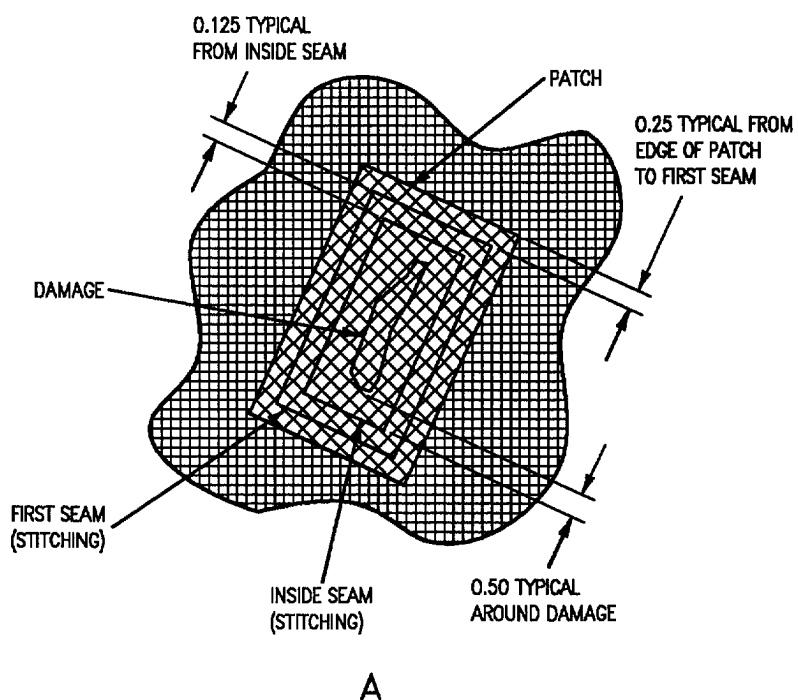
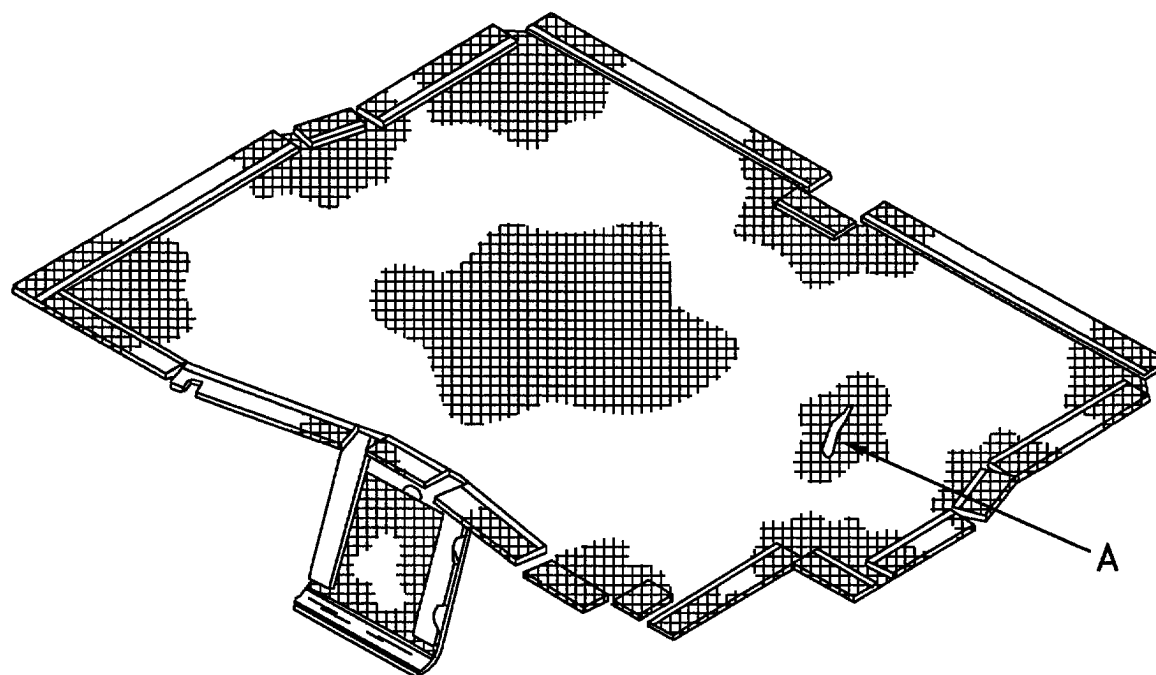
i. Install MS20470AD5 rivets with 4M27C5 washer under rivet head wet with sealing compound (A1-F18AC-SRM-200, WP011 00), detail K.

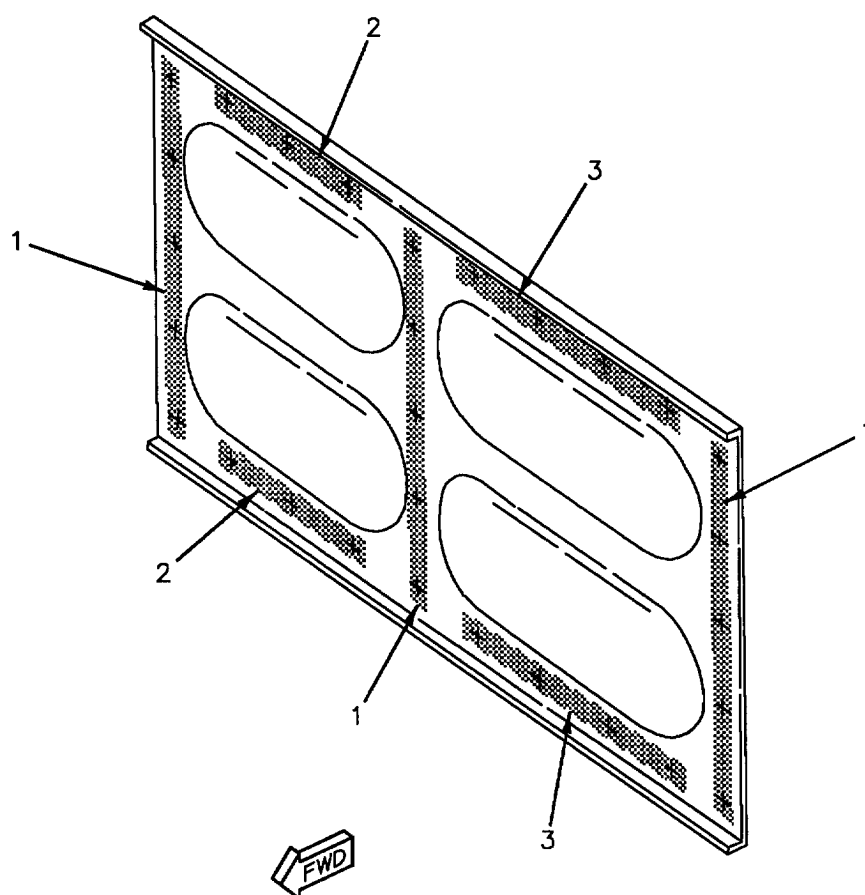
j. Install EMI screen.



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Figure 3. Cover (74A314108) Repair, 161353 THRU 162834

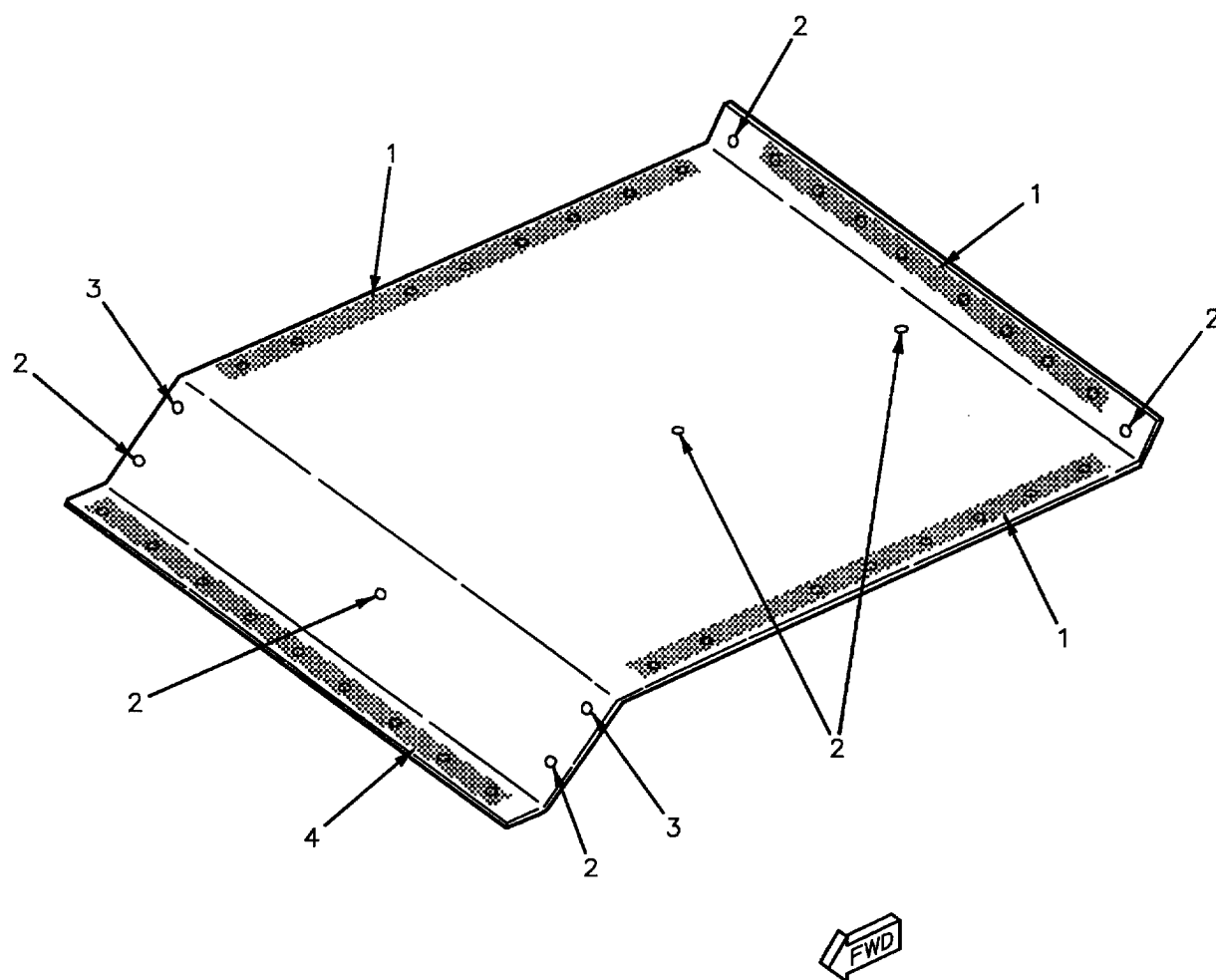
**Figure 4. Cover (74A314108) Repair, 162835 AND UP**



18AC-SRM-222-(67-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Gang Channel	G18421TL1-3-13
2	 	 	Gang Channel Plate Nut	G18421JL1-3-13 F50406-3
3	 	 	Gang Channel Plate Nut	G18421JL1-3-11 F50406-3
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p> <p> F/A-18A 161353 THRU 161359.</p> <p> F/A-18A 161361 AND UP.</p> <p> Attached with NAS1097AD3 rivets, length to be determined on installation.</p>				

Figure 5. Cover (Door CPA) Replacement



18AC-SRM-222-(68-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Gang Channel	G18421JL-1-3-11
2			Plate Nut	MS21060L3
3			Plate Nut	MS21062L3
4			Gang Channel	G18421JL-1-3-12
LEGEND				
Hole diameter is 0.201 +0.007 -0.000.				

Figure 6. Cover (Door CPB) Replacement






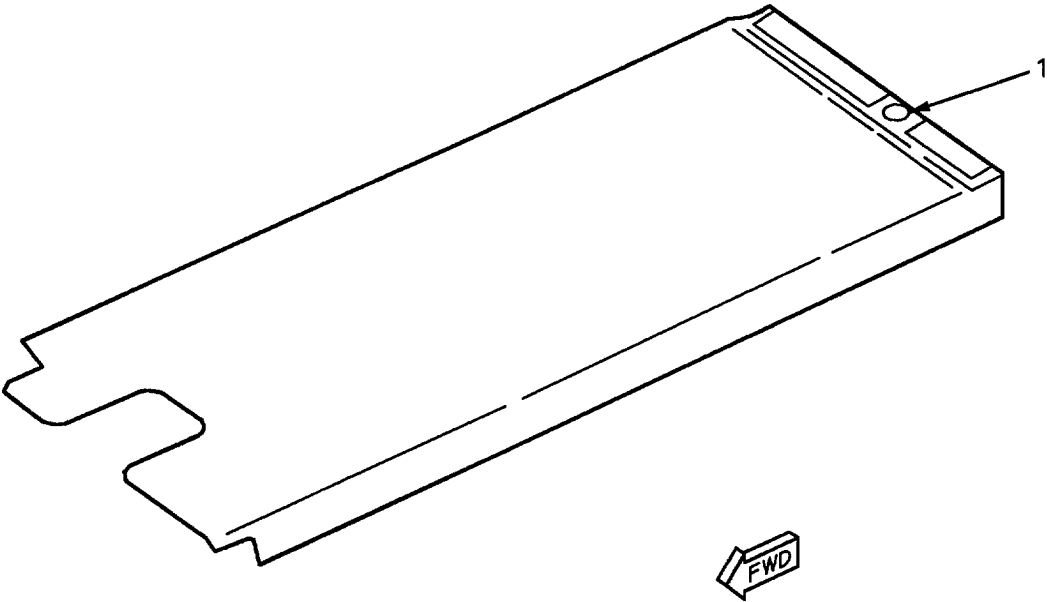
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49249E3-2
2			Plate Nut	F49249E3-1
3			Plate Nut	F49249E3-1
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				
 Hole diameter is 0.195 +0.0025 -0.0000.				

Figure 7. Cover (Door CPI) Replacement (Sheet 2)



18AC-SRM-222-(70-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Receptacle	99833-P130
LEGEND				
Hole diameter is 0.281 +0.007 -0.001.				

Figure 8. Kickshield (Door CPK) Replacement

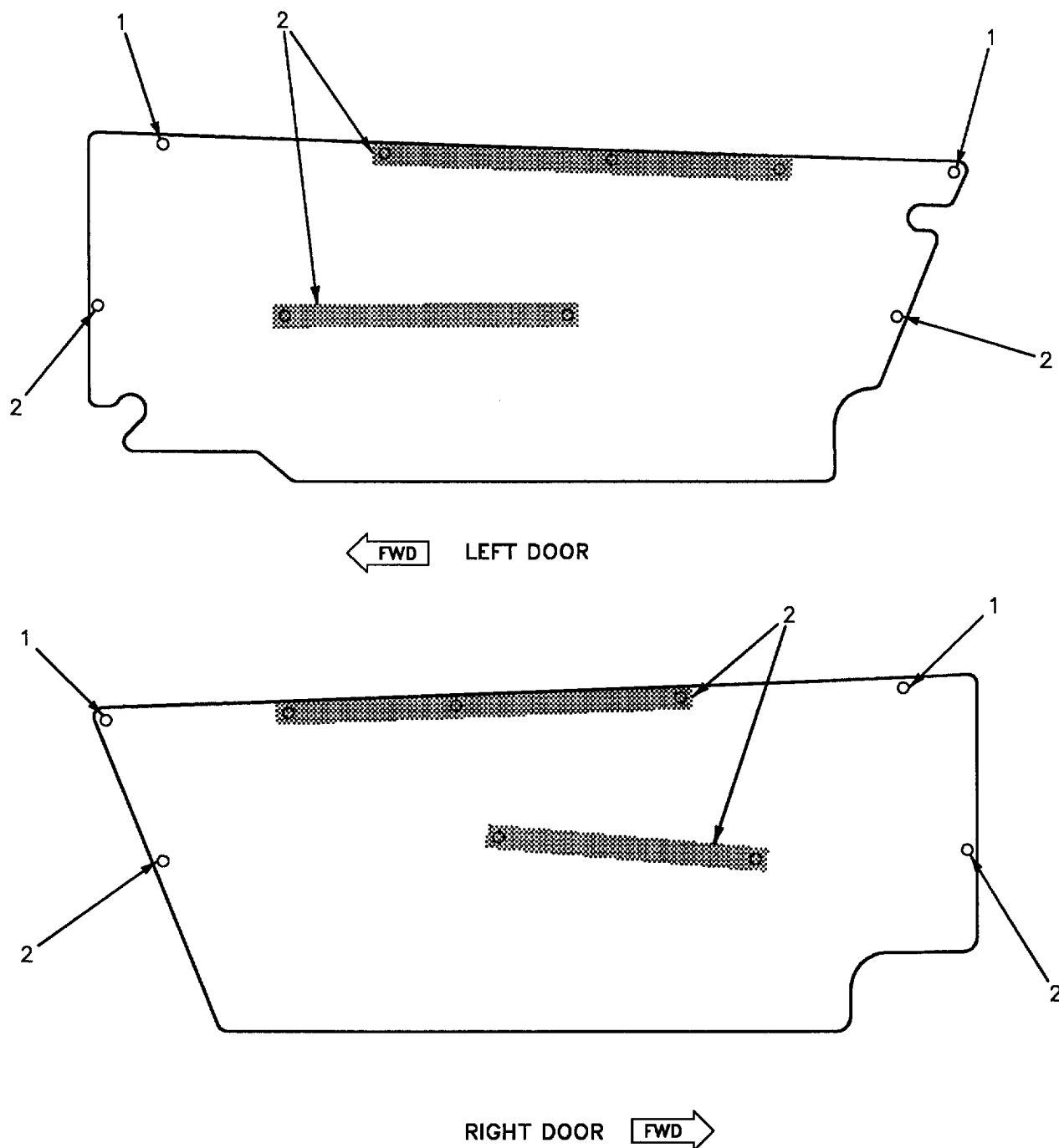


Figure 9. Cover (Door CPP) Replacement (Sheet 1)




IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21062L3
2			Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				

Figure 9. Cover (Door CPP) Replacement (Sheet 2)

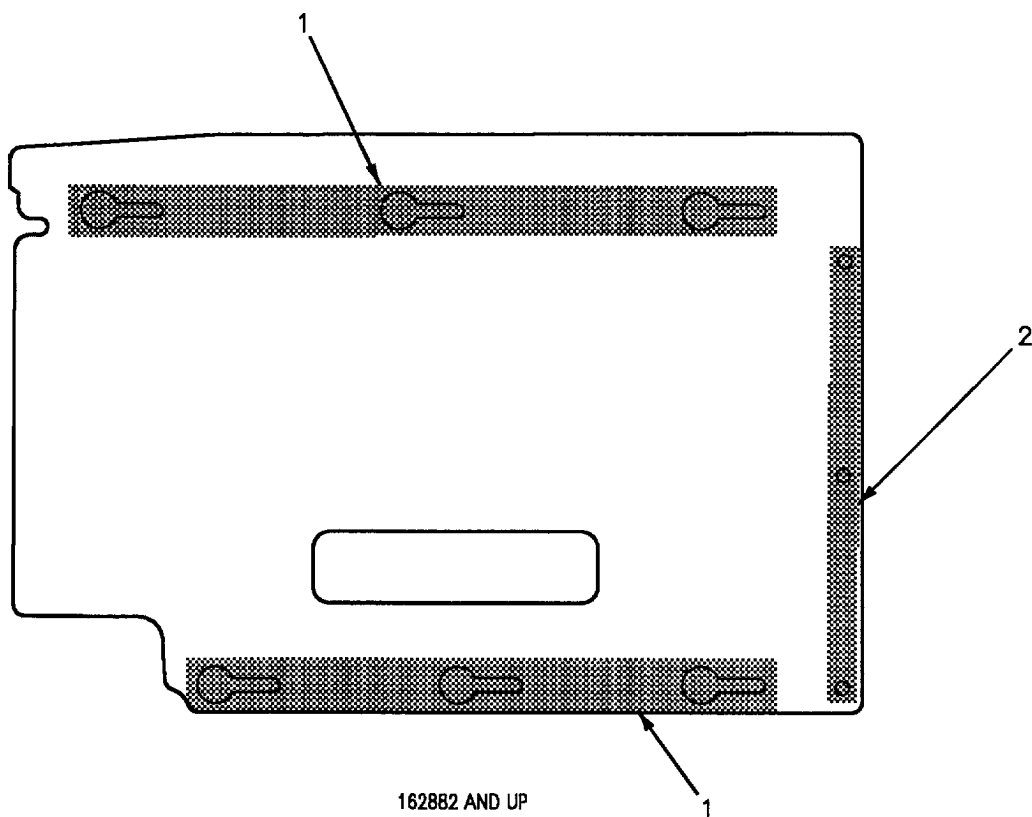
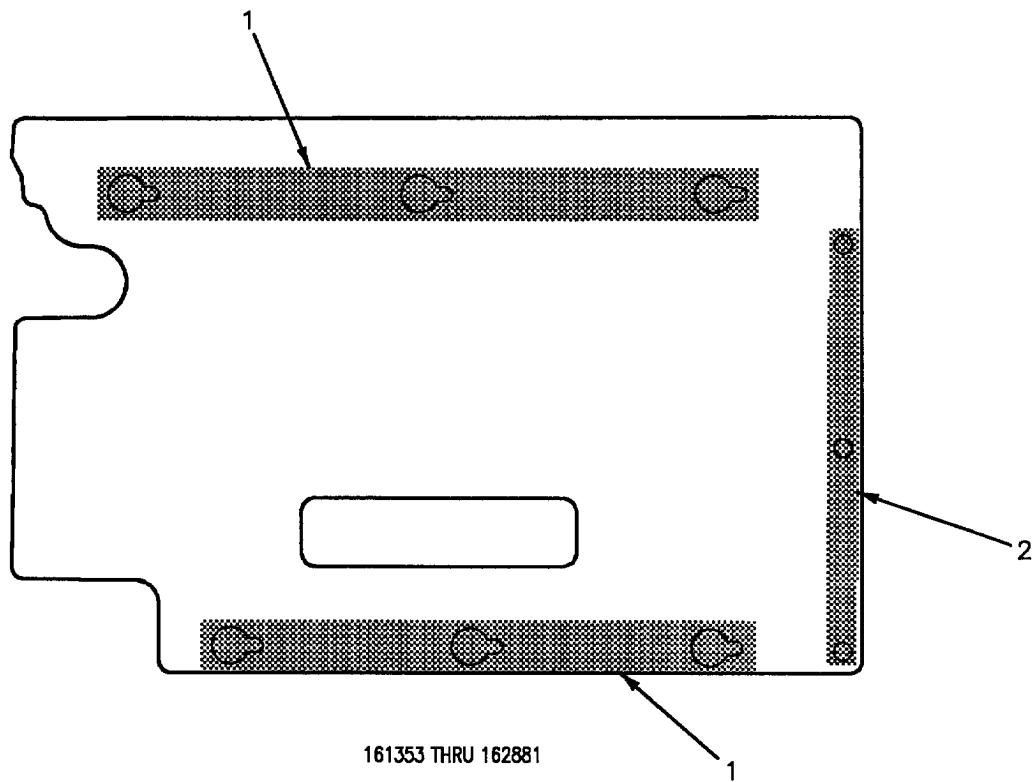


Figure 10. Kickshield (Door CPQ) Replacement (Sheet 1)



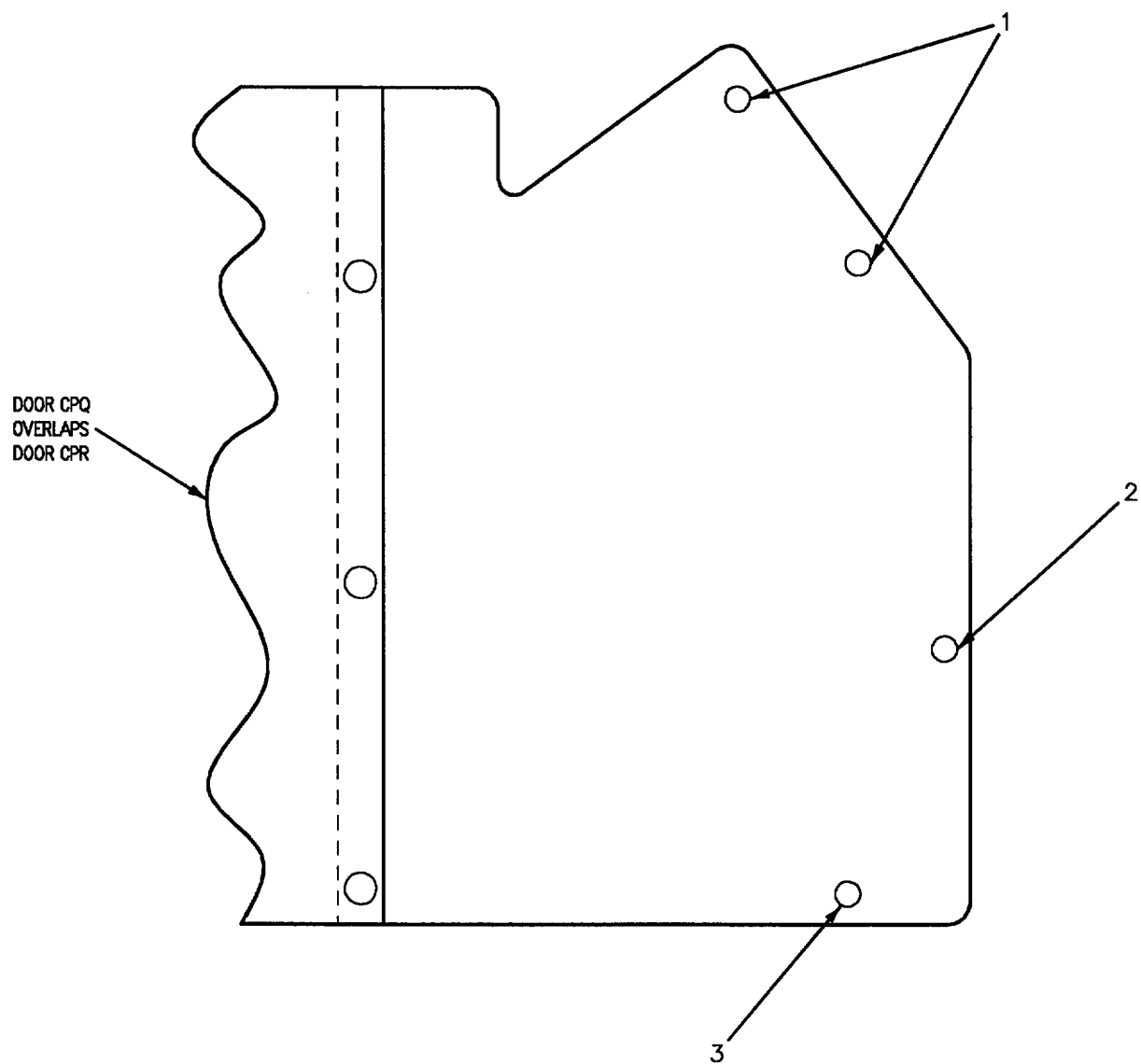
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Nut	NAS679C3MW
2			Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				

Figure 10. Kickshield (Door CPQ) Replacement (Sheet 2)

**Figure 11. Kickshield (Door CPR) Replacement (Sheet 1)**














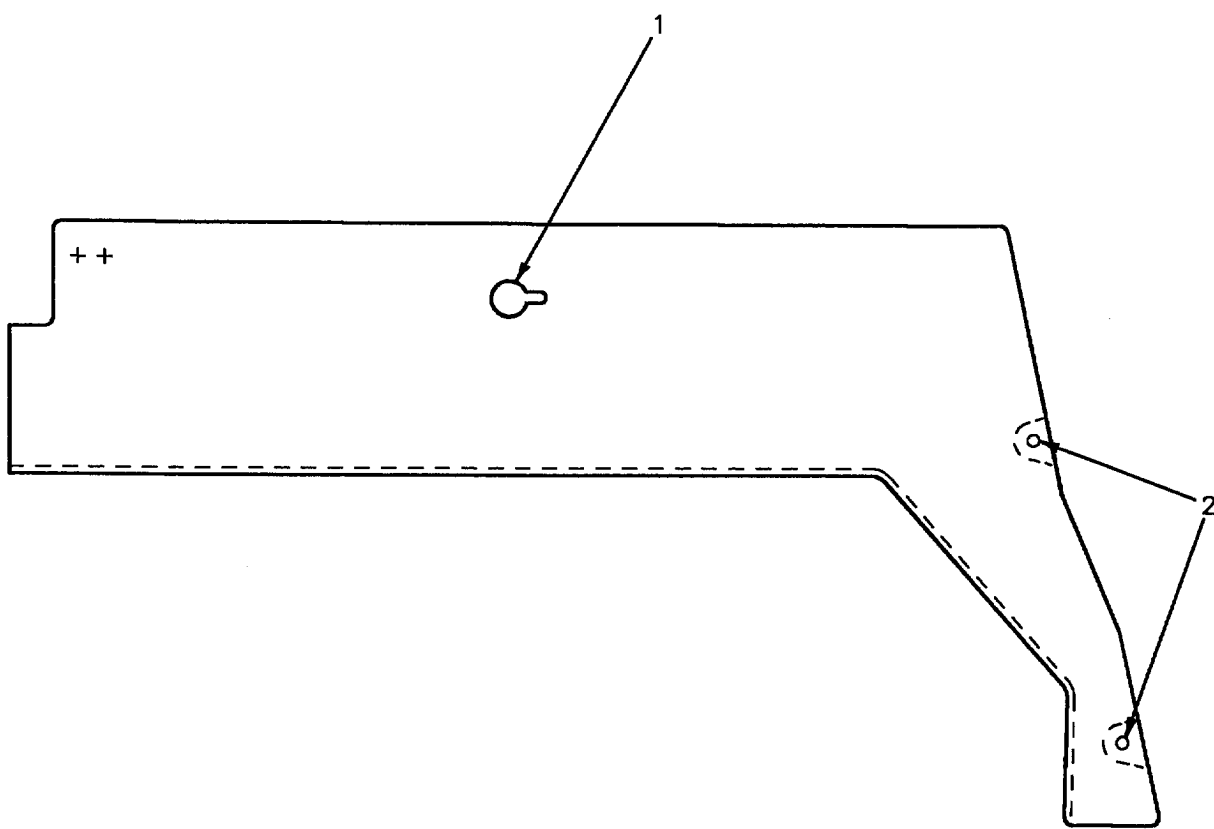
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21062L3
2			Plate Nut	MS21060L3
3	 	 	 Plate Nut  Plate Nut	MS21060L3 MS21060L3
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.205 +0.006 -0.000.</p> <p> Attached with CSR904B3 rivets, length to be determined on installation.</p> <p> Attached with NAS1097AD3 rivets, length to be determined on installation.</p> <p> 161353 THRU 161965.</p> <p> 161966 AND UP.</p>				

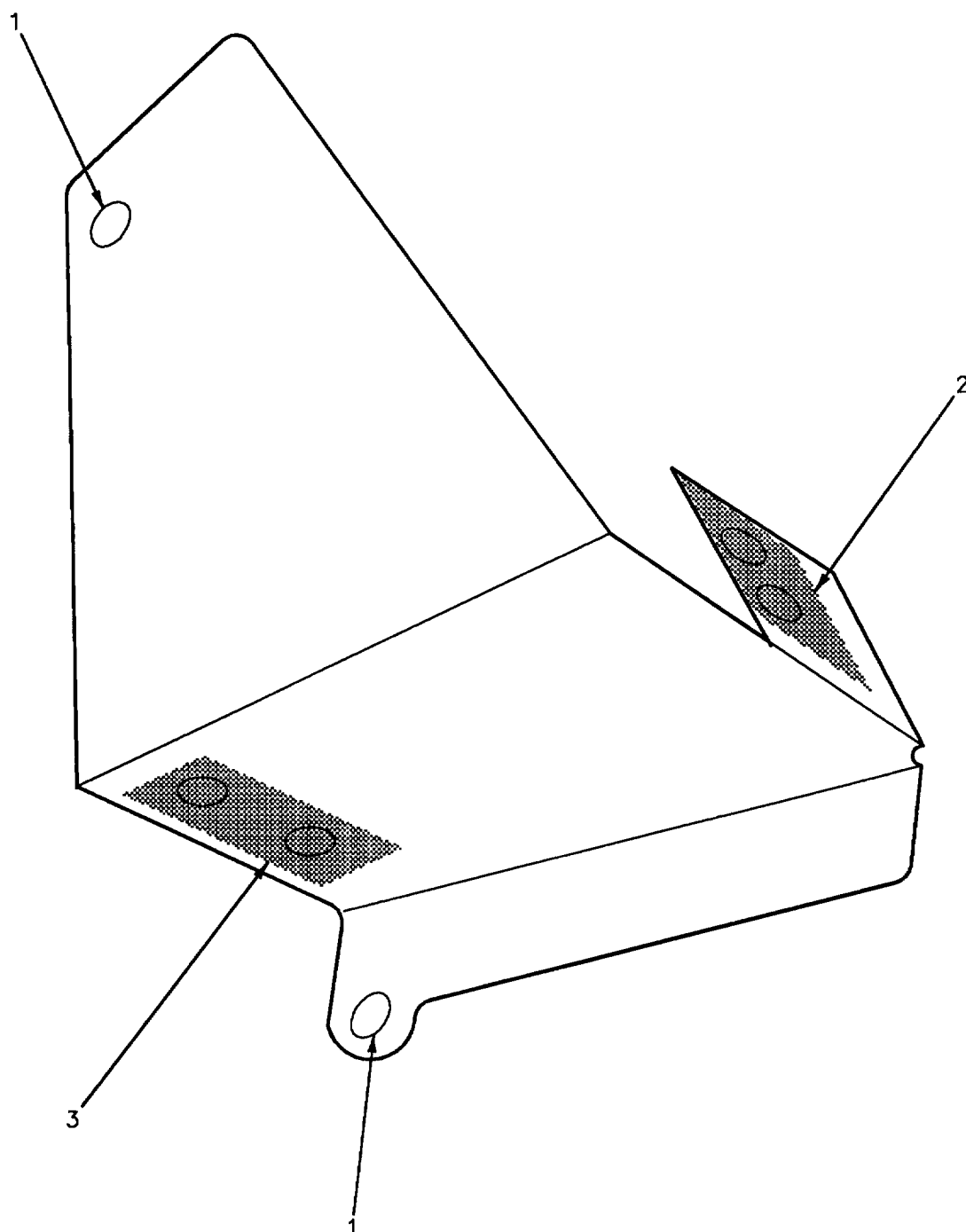
Figure 11. Kickshield (Door CPR) Replacement (Sheet 2)



18AC-SRM-222-(74-1)01-CATI

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Nut	NAS679C3MW
2			Plate Nut	F50403-3-1
LEGEND				
Hole diameter is 0.205 +0.006 -0.000.				

Figure 12. Kickshield (Door CPS) Replacement



18AC-SRM-222-(75-1)01-CATI

Figure 13. Closure (Door CPU) Replacement (Sheet 1)










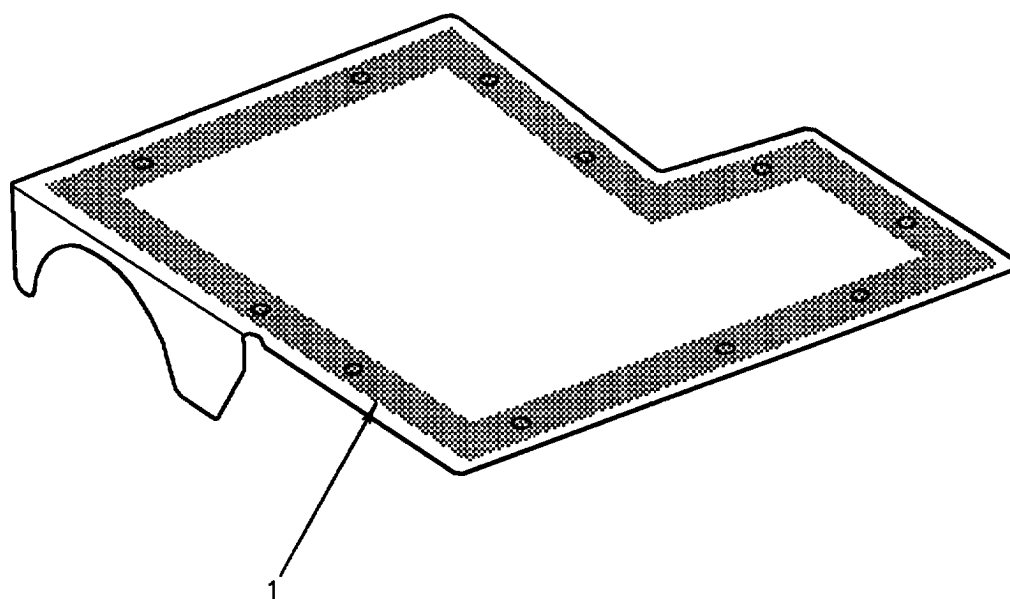
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21061L3
2			Plate Nut	MS21060L3
3	 	 	Plate Nut Gang Channel	F29339-01-3 MS21063L3-12-2
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.205 +0.006 -0.000.</p> <p> 161353 THRU 162445.</p> <p> 162446 AND UP.</p>				

Figure 13. Closure (Door CPU) Replacement (Sheet 2)



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



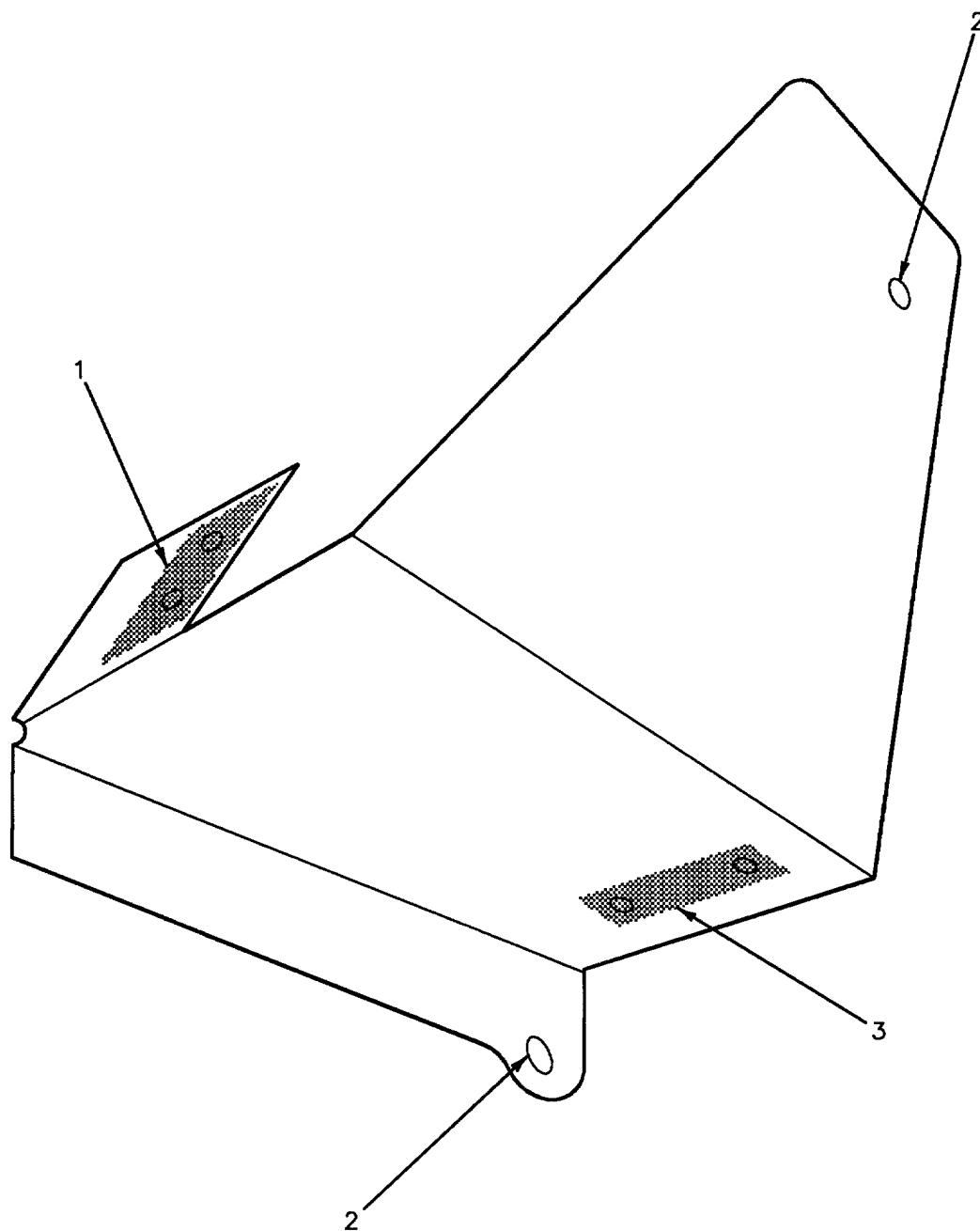
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			 Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				
 Attached with NAS1097AD3 rivets, length to be determined on installation.				

Figure 14. Cover (Door CPV) Replacement



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Figure 15. Closure (Door CPW) Replacement (Sheet 1)





IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21060L3
2			Plate Nut	MS21062L3
3			Plate Nut	F29339-01-3
LEGEND				
 Hole diameter is 0.205 +0.006 -0.000.				

Figure 15. Closure (Door CPW) Replacement (Sheet 2)

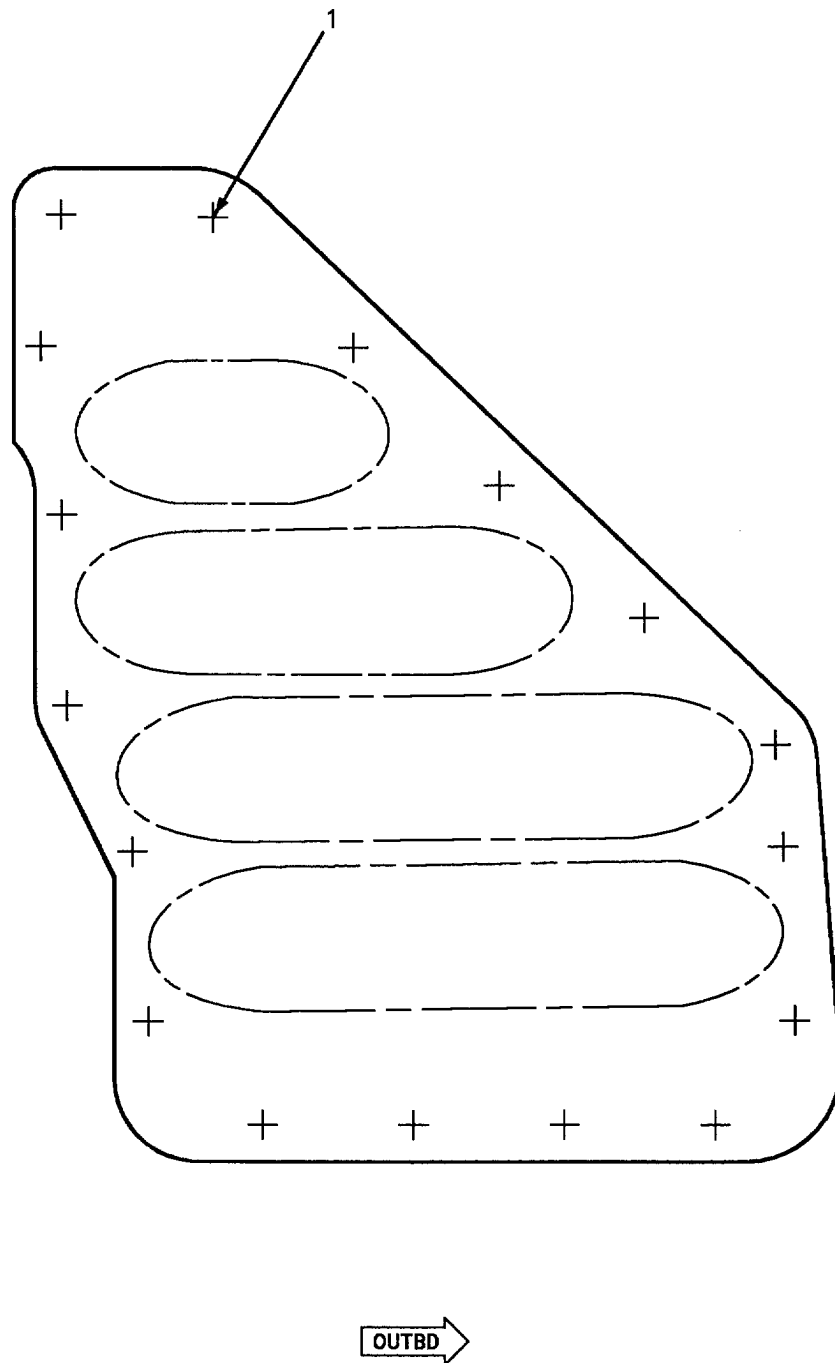


Figure 16. Web (Door NWA) Replacement (Sheet 1)



IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Dome Nut	F50406-3
LEGEND				
 Hole diameter is 0.1895 +0.0025 -0.000.				

Figure 16. Web (Door NWA) Replacement (Sheet 2)

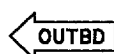
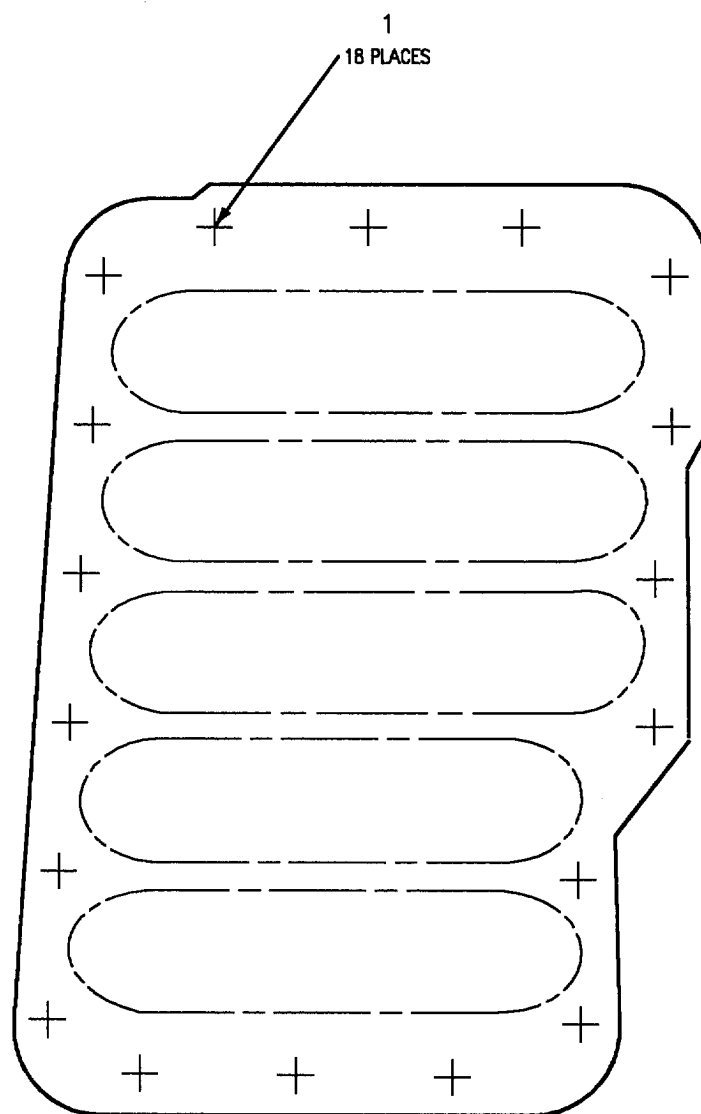


Figure 17. Web (Door NWB) Replacement (Sheet 1)



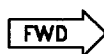
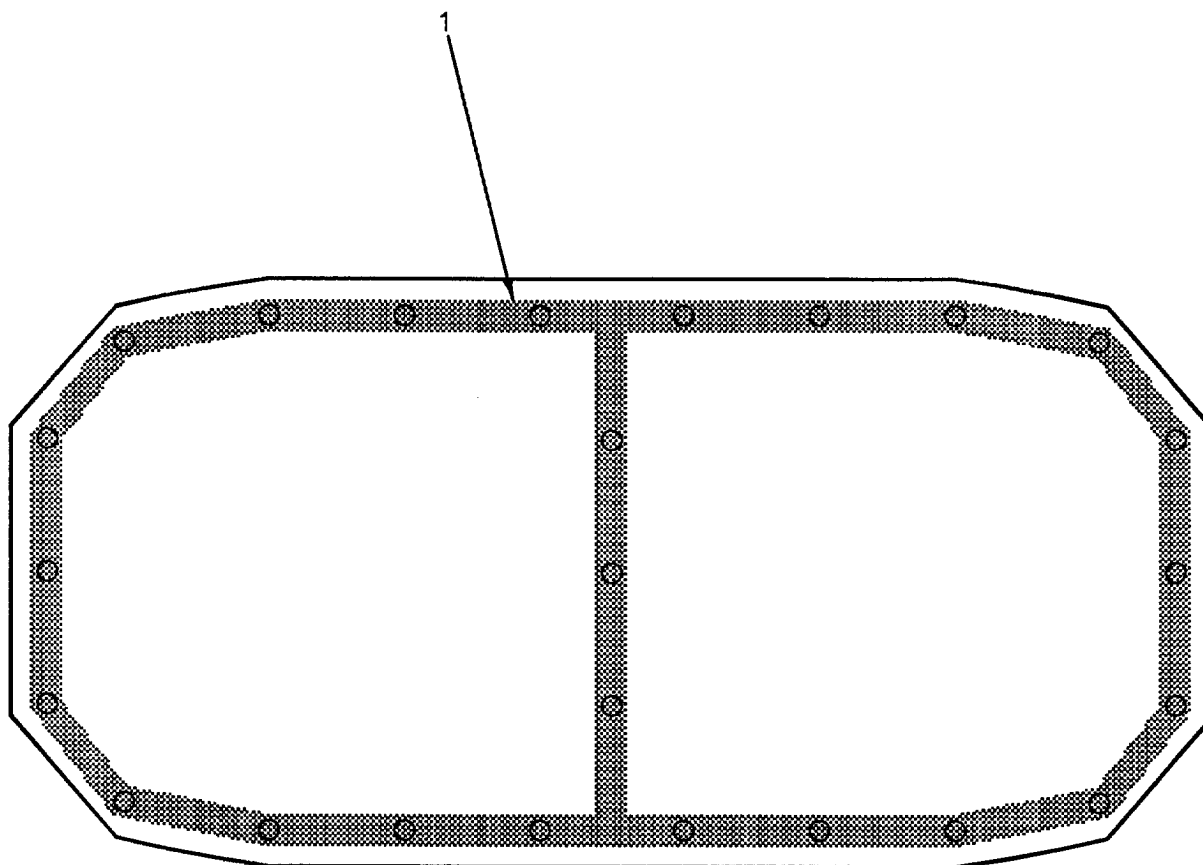
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Dome Nut	FS0406-3
LEGEND				
 Hole diameter is 0.1895 +0.0025 -0.0000.				

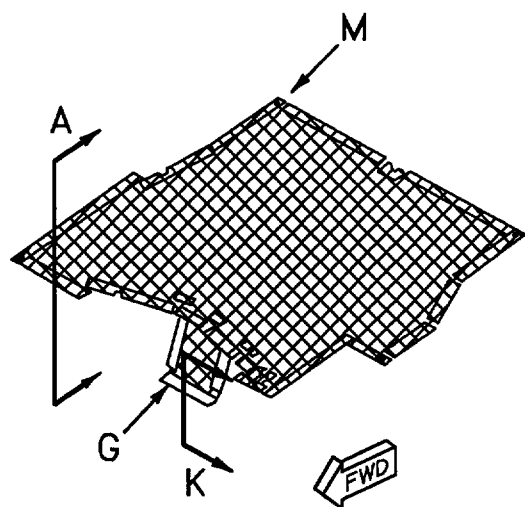
Figure 17. Web (Door NWB) Replacement (Sheet 2)



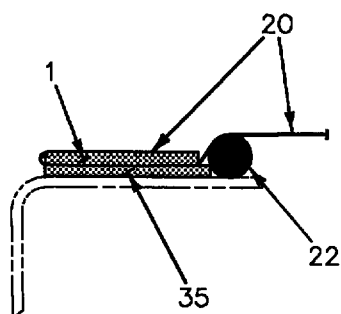
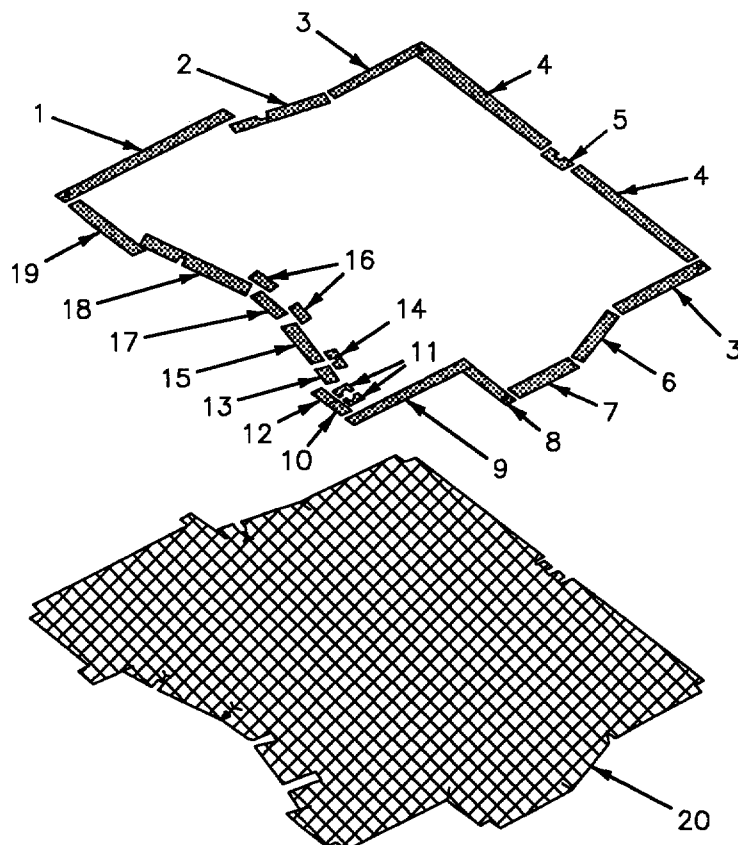
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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50339-3-1
LEGEND				
Hole diameter is 0.195 +0.007 -0.000. Attached with CSR904B3 rivets, length to be determined on installation.				

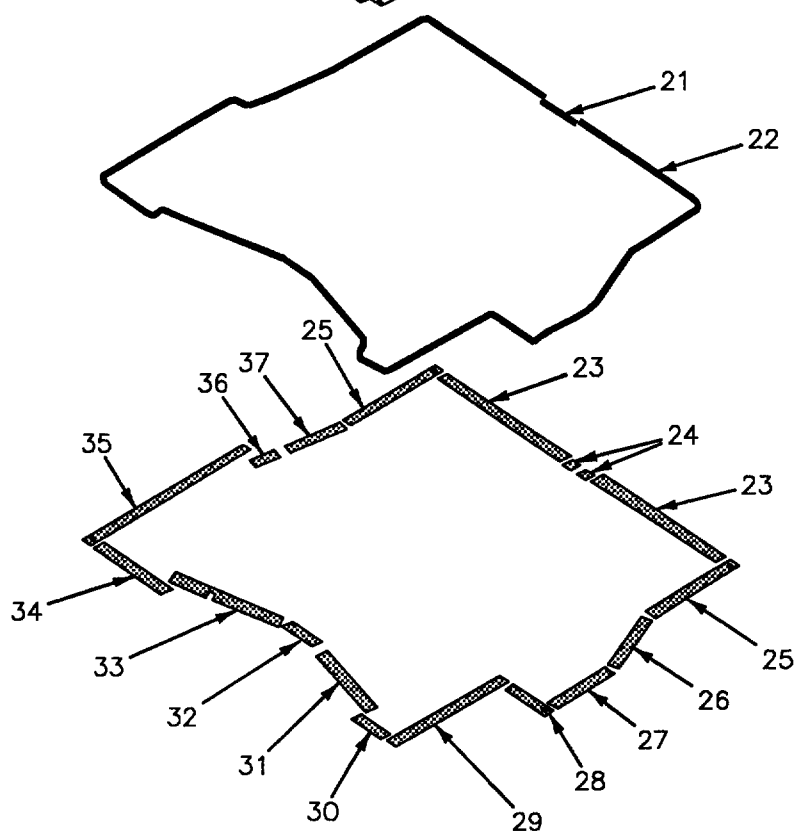
Figure 18. Cover (Door NWC) Replacement



F/A-18A 161353 THRU 161519



A



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Figure 19. EMI Shield, Material Index (Sheet 1)

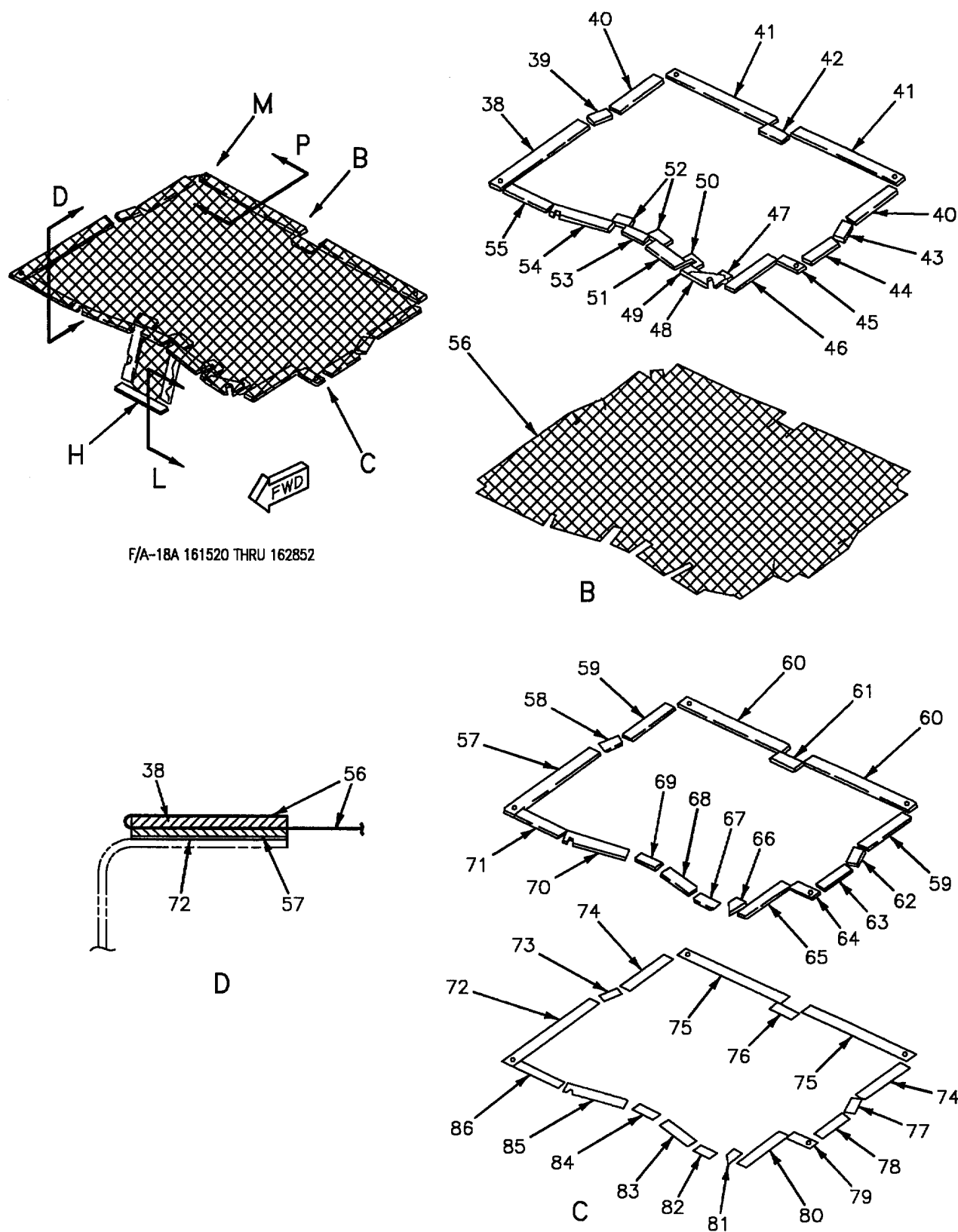


Figure 19. EMI Shield, Material Index (Sheet 2)

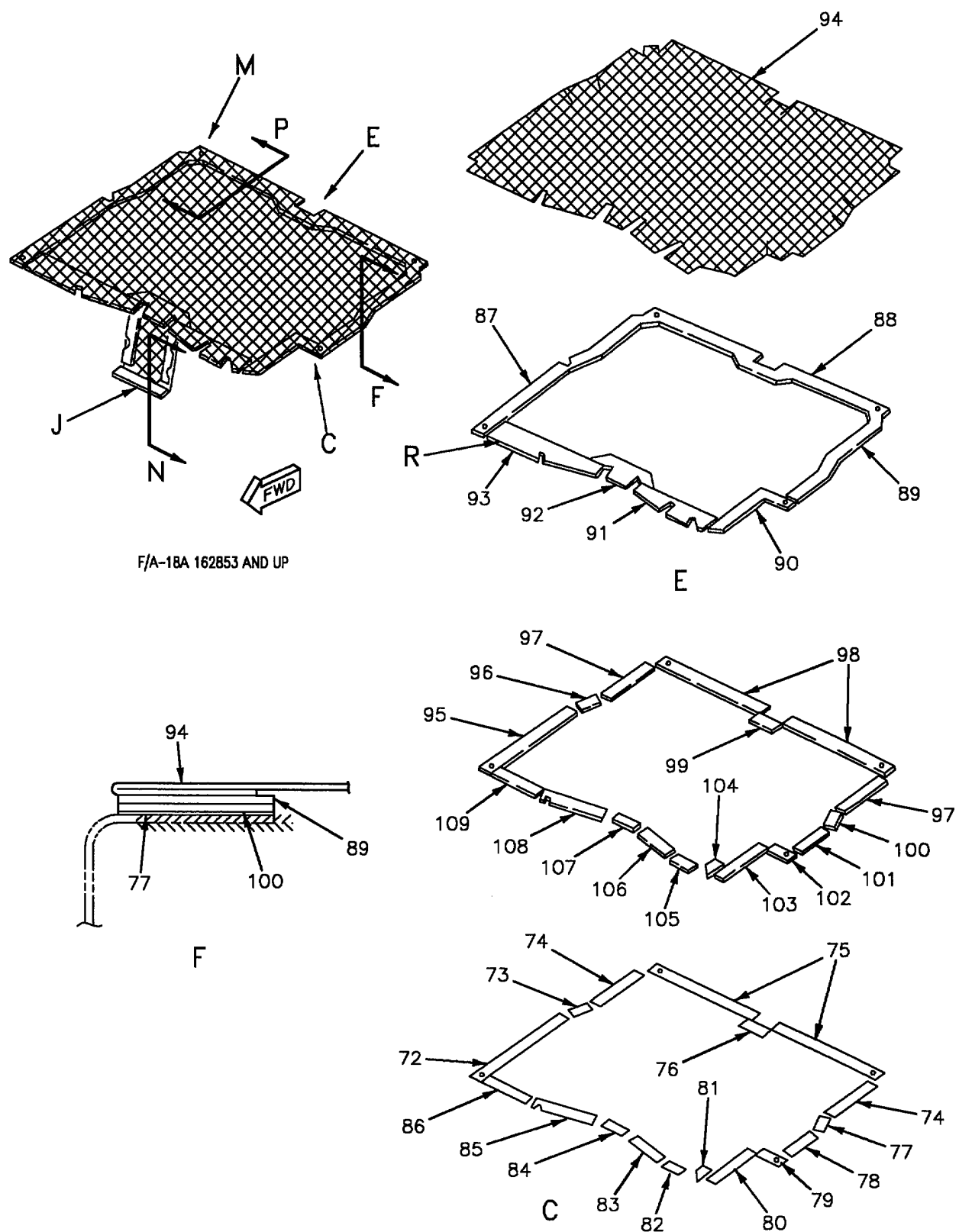


Figure 19. EMI Shield, Material Index (Sheet 3)

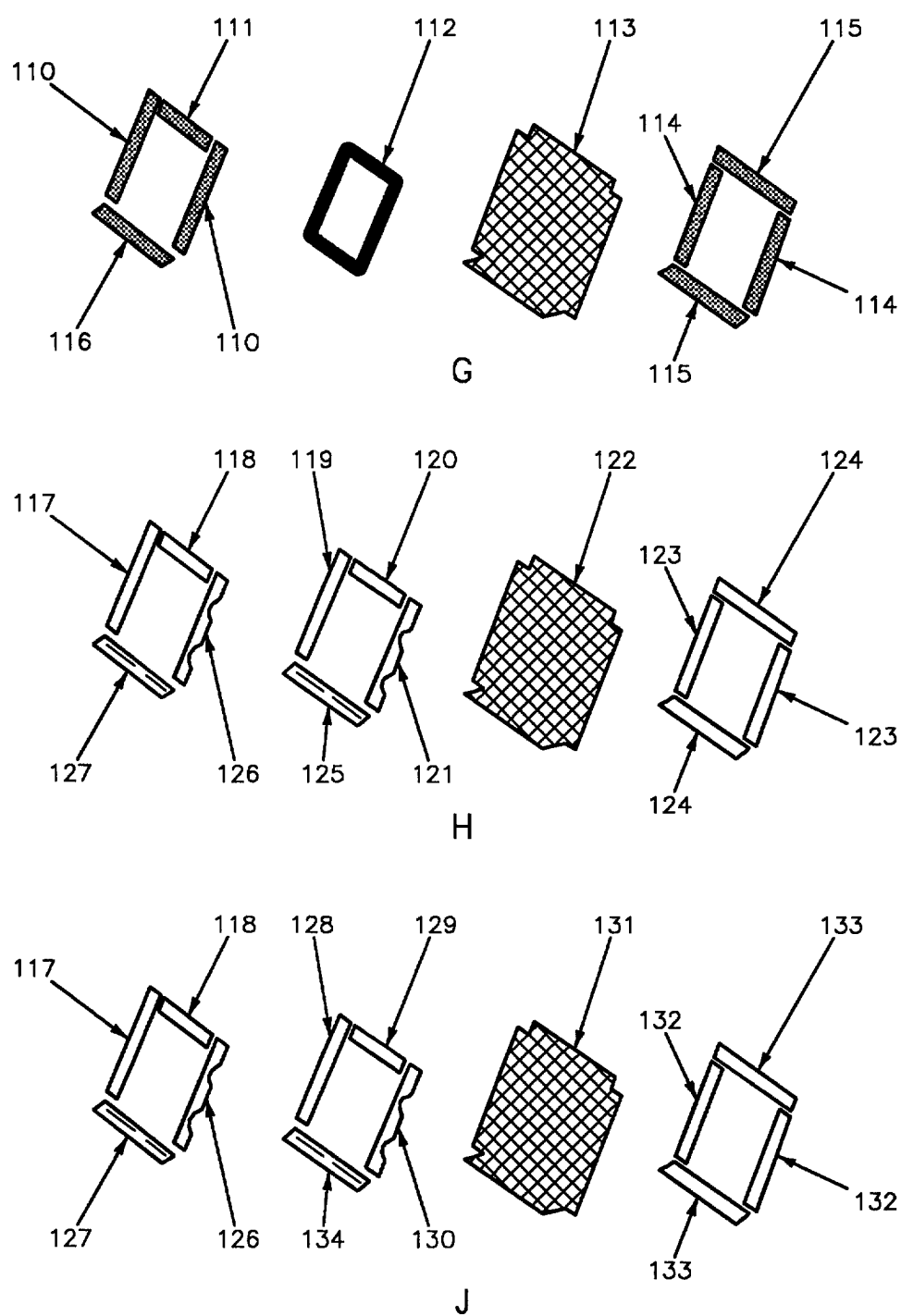


Figure 19. EMI Shield, Material Index (Sheet 4)

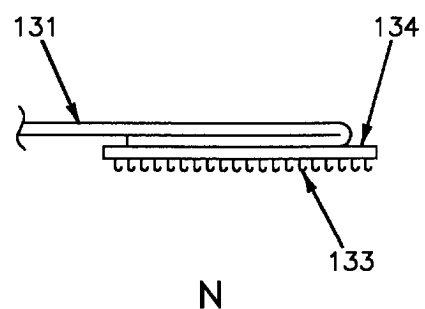
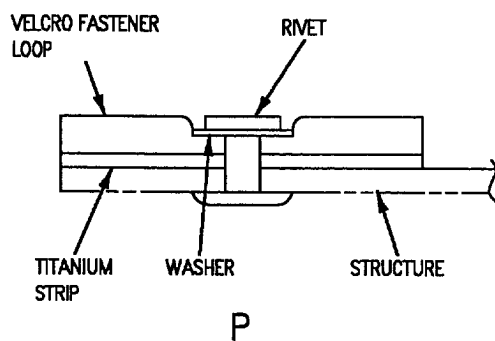
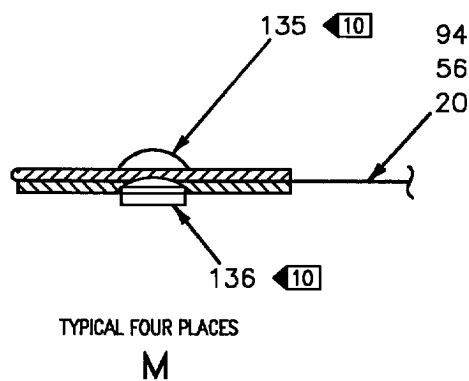
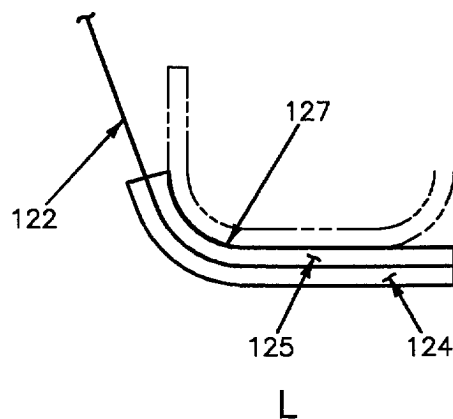
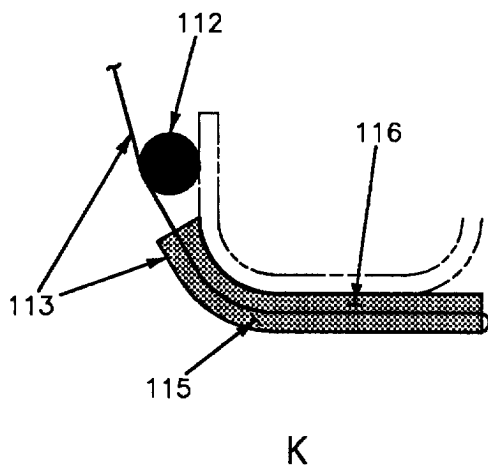
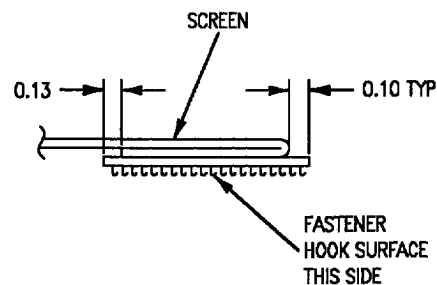
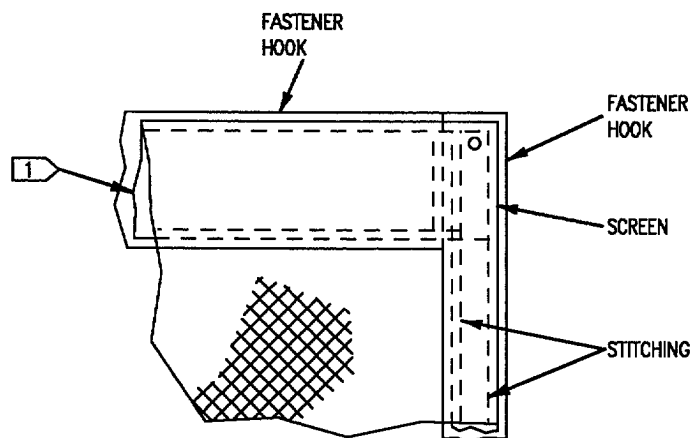
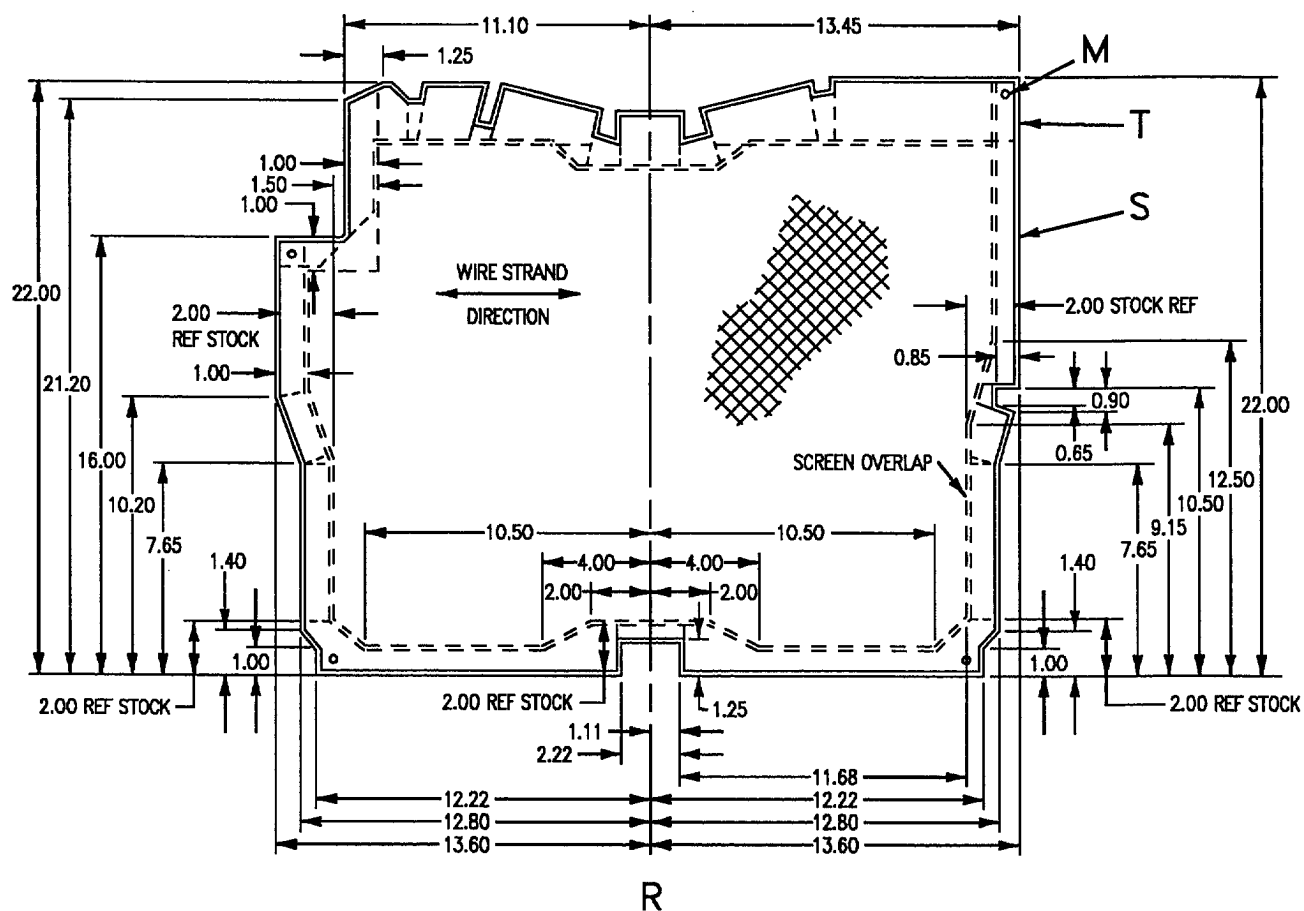


Figure 19. EMI Shield, Material Index (Sheet 5)



S
TYPICAL SCREEN TO FASTENER
EDGING CONFIGURATION

LEGEND

- 1** SEW TWO STRIPS OF 1 INCH FASTENER HOOK TOGETHER FOR FASTENER HOOK SECTIONS REQUIRING GREATER THAN 1 INCH

Figure 19. EMI Shield, Material Index (Sheet 6)





































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Fastener Hook 74A314108-2041	0.75 X 11.75	 191034 Velcro
2		Fastener Hook 74A314108-2037	0.75 X 6.10	 191034 Velcro
3		Fastener Hook 74A314108-2035	0.75 X 6.30	 191034 Velcro
4		Fastener Hook 74A314108-2033	0.75 X 10.85	 191034 Velcro
5		Fastener Hook 74A314108-2039	0.75 X 2.00	 191034 Velcro
6		Fastener Hook 74A314108-2057	0.75 X 5.00	 191034 Velcro
7		Fastener Hook 74A314108-2107	0.75 X 4.65	 191034 Velcro
8		Fastener Hook 74A314108-2111	0.75 X 3.66	 191034 Velcro
9		Fastener Hook 74A314108-2113	0.75 X 8.05	 191034 Velcro
10		Fastener Hook 74A314108-2109	0.75 X 1.25	 191034 Velcro
11		Fastener Hook 74A314108-2087	0.75 X 1.35	 191034 Velcro
12		Fastener Hook 74A314108-2083	0.75 X 1.50	 191034 Velcro
13		Fastener Hook 74A314108-2051	0.75 X 1.55	 191034 Velcro
14		Fastener Hook 74A314108-2091	0.75 X 1.50	 191034 Velcro
15		Fastener Hook 74A314108-2049	0.75 X 4.20	 191034 Velcro
16		Fastener Hook 74A314108-2089	0.75 X 1.60	 191034 Velcro
17		Fastener Hook 74A314108-2047	0.75 X 2.65	 191034 Velcro
18		Fastener Hook 74A314108-2045	0.75 X 7.00	 191034 Velcro

Figure 19. EMI Shield, Material Index (Sheet 7)


































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Fastener Hook 74A314108-2043	0.75 X 6.45	 191034 Velcro
20		Screen 74A314108-2095	25.00 X 34.00	Wire Mesh
21		Gasket 74A314108-2005	11M989-1 Extr	Silicone Rubber
22		Gasket 74A314108-2097	11M989-1 Extr	Silicone Rubber
23		Fastener Pile 74A314108-2009	0.75 X 10.80	 190960 Velcro
24		Fastener Pile 74A314108-2007	0.75 X 0.75	 190960 Velcro
25		Fastener Pile 74A314108-2011	0.75 X 6.30	 190960 Velcro
26		Fastener Pile 74A314108-2029	0.75 X 4.40	 190960 Velcro
27		Fastener Pile 74A314108-2103	0.75 X 4.50	 190960 Velcro
28		Fastener Pile 74A314108-2105	0.75 X 3.66	 190960 Velcro
29		Fastener Pile 74A314108-2099	0.75 X 8.05	 190960 Velcro
30		Fastener Pile 74A314108-2101	0.75 X 2.75	 190960 Velcro
31		Fastener Pile 74A314108-2025	0.75 X 6.30	 190960 Velcro
32		Fastener Pile 74A314108-2023	0.75 X 2.55	 190960 Velcro
33		Fastener Pile 74A314108-2021	0.75 X 6.70	 190960 Velcro
34		Fastener Pile 74A314108-2075	0.75 X 6.40	 190960 Velcro
35		Fastener Pile 74A314108-2017	0.75 X 11.75	 190960 Velcro
36		Fastener Pile 74A314108-2015	0.75 X 1.70	 190960 Velcro

Figure 19. EMI Shield, Material Index (Sheet 8)




































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
37		Fastener Pile 74A314108-2013	0.75 X 3.35	 Velcro
38		Fastener Hook 74A314108-2231	1.00 X 11.50	 191034 Velcro
39		Fastener Hook 74A314108-2205	1.00 X 2.00	 191034 Velcro
40		Fastener Hook 74A314108-2203	1.00 X 6.25	 191034 Velcro
41		Fastener Hook 74A314108-2197	1.00 X 11.10	 191034 Velcro
42		Fastener Hook 74A314108-2199	1.00 X 2.40	 191034 Velcro
43		Fastener Hook 74A314108-2207	1.00 X 2.50	 191034 Velcro
44		Fastener Hook 74A314108-2209	1.00 X 3.90	 191034 Velcro
45		Fastener Hook 74A314108-2213	1.00 X 2.40	 191034 Velcro
46		Fastener Hook 74A314108-2215	1.00 X 5.80	 191034 Velcro
47		Fastener Hook 74A314108-2217	1.00 X 2.00	 191034 Velcro
48		Retainer 74A314108-2233	0.040 Sheet	6Al-4V Ti Anl
49		Fastener Hook 74A314108-2219	1.00 X 2.50	 191034 Velcro
50		Fastener Hook 74A314108-2221	1.00 X 1.50	 191034 Velcro
51		Fastener Hook 74A314108-2223	1.00 X 4.00	 191034 Velcro
52		Fastener Hook 74A314108-2211	1.00 X 1.60	 191034 Velcro
53		Fastener Hook 74A314108-2225	1.00 X 2.50	 191034 Velcro
54		Fastener Hook 74A314108-2227	1.00 X 5.40	 191034 Velcro

Figure 19. EMI Shield, Material Index (Sheet 9)



































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
55		Fastener Hook 74A314108-2229	1.00 X 5.00	 191034 Velcro
56		Screen 74A314108-2201	24.00 X 30.00	Wire Mesh
57		Fastener Loop 74A314108-2127	1.00 X 11.50	 190960 Velcro
58		Fastener Loop 74A314108-2121	1.00 X 2.00	 190960 Velcro
59		Fastener Loop 74A314108-2119	1.00 X 6.10	 190960 Velcro
60		Fastener Loop 74A314108-2115	1.00 X 11.20	 190960 Velcro
61		Fastener Loop 74A314108-2117	1.00 X 2.40	 190960 Velcro
62		Fastener Loop 74A314108-2123	1.00 X 2.60	 190960 Velcro
63		Fastener Loop 74A314108-2125	1.00 X 3.90	 190960 Velcro
64		Fastener Loop 74A314108-2141	1.00 X 2.35	 190960 Velcro
65		Fastener Loop 74A314108-2143	1.00 X 5.80	 190960 Velcro
66		Fastener Loop 74A314108-2139	1.00 X 2.00	 190960 Velcro
67		Fastener Loop 74A314108-2137	1.00 X 1.80	 190960 Velcro
68		Fastener Loop 74A314108-2135	1.00 X 4.40	 190960 Velcro
69		Fastener Loop 74A314108-2133	1.00 X 2.50	 190960 Velcro
70		Fastener Loop 74A314108-2131	1.00 X 5.30	 190960 Velcro
71		Fastener Loop 74A314108-2129	1.00 X 5.00	 190960 Velcro
72		Strip 74A314108-2153	0.020 Sheet	6Al-4V Ti Anl

Figure 19. EMI Shield, Material Index (Sheet 10)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
73	8	Strip 74A314108-2151	0.020 Sheet	6Al-4V Ti Anl
74	8	Strip 74A314108-2149	0.020 Sheet	6Al-4V Ti Anl
75	8	Strip 74A314108-2147	0.020 Sheet	6Al-4V Ti Anl
76	8	Strip 74A314108-2145	0.020 Sheet	6Al-4V Ti Anl
77	8	Strip 74A314108-2173	0.020 Sheet	6Al-4V Ti Anl
78	8	Strip 74A314108-2171	0.020 Sheet	6Al-4V Ti Anl
79	8	Strip 74A314108-2169	0.020 Sheet	6Al-4V Ti Anl
80	8	Strip 74A314108-2167	0.020 Sheet	6Al-4V Ti Anl
81	8	Strip 74A314108-2165	0.020 Sheet	6Al-4V Ti Anl
82	8	Strip 74A314108-2161	0.020 Sheet	6Al-4V Ti Anl
83	8	Strip 74A314108-2163	0.020 Sheet	6Al-4V Ti Anl
84	8	Strip 74A314108-2159	0.020 Sheet	6Al-4V Ti Anl
85	8	Strip 74A314108-2157	0.020 Sheet	6Al-4V Ti Anl
86	8	Strip 74A314108-2155	0.020 Sheet	6Al-4V Ti Anl
87	7	Fastener Hook 74A314108-2295	2.00 X 20.00	5 191034 Velcro
88	7	Fastener Hook 74A314108-2307	2.00 X 25.60	5 191034 Velcro
89	7	Fastener Hook 74A314108-2305	2.00 X 14.00	5 191034 Velcro
90	7	Fastener Hook 74A314108-2303	2.00 X 6.75	5 191034 Velcro

Figure 19. EMI Shield, Material Index (Sheet 11)




































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
91		Fastener Hook 74A314108-2301	2.00 X 8.33	 191034 Velcro
92		Fastener Hook 74A314108-2299	2.00 X 7.50	 191034 Velcro
93		Fastener Hook 74A314108-2297	2.00 X 10.67	 191034 Velcro
94		Screen 74A314108-2293	23.34 X 28.54	0.011 Knit Weave 304 Cres
95		Fastener Loop 74A314108-2255	1.00 X 11.50	 190960 Velcro
96		Fastener Loop 74A314108-2253	1.00 X 2.00	 190960 Velcro
97		Fastener Loop 74A314108-2251	1.00 X 6.10	 190960 Velcro
98		Fastener Loop 74A314108-2249	1.00 X 11.20	 190960 Velcro
99		Fastener Loop 74A314108-2247	1.00 X 2.40	 190960 Velcro
100		Fastener Loop 74A314108-2275	1.00 X 2.60	 190960 Velcro
101		Fastener Loop 74A314108-2273	1.00 X 3.90	 190960 Velcro
102		Fastener Loop 74A314108-2271	1.00 X 2.35	 190960 Velcro
103		Fastener Loop 74A314108-2269	1.00 X 5.80	 190960 Velcro
104		Fastener Loop 74A314108-2267	1.00 X 2.00	 190960 Velcro
105		Fastener Loop 74A314108-2265	1.00 X 1.80	 190960 Velcro
106		Fastener Loop 74A314108-2263	1.00 X 4.40	 190960 Velcro
107		Fastener Loop 74A314108-2261	1.00 X 2.50	 190960 Velcro
108		Fastener Loop 74A314108-2259	1.00 X 5.30	 190960 Velcro

Figure 19. EMI Shield, Material Index (Sheet 12)































IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
109		Fastener Loop 74A314108-2257	1.00 X 5.00	 190960 Velcro
110		Fastener Pile 74A314108-2071	0.75 X 5.10	 Velcro
111		Fastener Pile 74A314108-2073	0.75 X 3.50	 Velcro
112		Gasket 74A314108-2067	11M989-1 X 16.10 Extr.	Silicone Rubber
113		Screen 74A314108-2081	6.75 X 8.00	Wire Mesh
114		Fastener Hook 74A314108-2077	0.75 X 4.85	 191034 Velcro
115		Fastener Hook 74A314108-2079	0.75 X 5.25	 191034 Velcro
116		Fastener Pile 74A314108-2069	0.75 X 5.15	 191034 Velcro
117		Strip 74A314108-2193	0.020 Sheet	6Al-4V Ti Anl
118		Strip 74A314108-2191	0.020 Sheet	6Al-4V Ti Anl
119		Fastener Loop 74A314108-2187	1.00 X 5.10	 190960 Velcro
120		Fastener Loop 74A314108-2185	1.00 X 3.10	 190960 Velcro
121		Fastener Loop 74A314108-2237	1.00 X 5.10	 190960 Velcro
122		Screen 74A314108-2183	7.00 X 8.50	Wire Mesh
123		Fastener Hook 74A314108-2179	1.00 X 4.75	 191034 Velcro
124		Fastener Hook 74A314108-2181	1.00 X 5.25	 191034 Velcro
125		Fastener Loop 74A314108-2189	1.00 X 5.15	 190960 Velcro
126		Strip 74A314108-2235	0.020 Sheet	6Al-4V Ti Anl

Figure 19. EMI Shield, Material Index (Sheet 13)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
127	8	Strip 74A314108-2195	0.020 Sheet	6Al-4V Ti Anl
128	9	Fastener Loop 74A314108-2279	1.00 X 5.10	5 190960 Velcro
129	9	Fastener Loop 74A314108-2277	1.00 X 3.10	5 190960 Velcro
130	9	Fastener Loop 74A314108-2283	1.00 X 5.15	5 190960 Velcro
131	7	Screen 74A314108-2289	6.59 X 8.09	0.011 Knit Weave 304 Cres
132	7	Fastener Hook 74A314108-2285	1.00 X 4.75	5 191034 Velcro
133	7	Fastener Hook 74A314108-2287	1.00 X 5.25	5 191034 Velcro
134	9	Fastener Loop 74A314108-2281	1.00 X 5.15	5 191034 Velcro
135	10	Fastener, Button MS27980-113	-	-
136	10	Fastener, Socket MS27980-6N	-	-
<p style="text-align: center;">LEGEND</p> <p>1 Fastener Hook, MIL-F-21840, Type 2 Class 1H.</p> <p>2 F/A-18A 161353 THRU 161519.</p> <p>3 Fastener Pile, MIL-F-21840, Class 1P.</p> <p>4 F/A-18A 161520 THRU 162852.</p> <p>5 Base Material in Nylon, with Special Silver Impregnate in Tape.</p> <p>6 F/A-18A 161520 THRU 162834</p> <p>7 F/A-18A 162835 AND UP.</p> <p>8 F/A-18A 161520 AND UP.</p> <p>9 F/A-18A 162853 AND UP.</p> <p>10 F/A-18A 161353 AND UP, AFTER F/A-18 AFC 142.</p>				

Figure 19. EMI Shield, Material Index (Sheet 14)

ORGANIZATIONAL MAINTENANCE**STRUCTURE REPAIR****AFT COCKPIT INTERNAL DOORS AND COVERS**

Reference Material

Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Crew Station Furnishing, Rear Cockpit - Instl of, F/A-18B	FIG 019 00
Fuselage Section - Fwd Fus, Structure	FIG 023 00
Deck Assy - Canopy Sill, Fwd Fus, F/A-18B (Y326.500 to Y365.700)	FIG 036 00
Deck Assy - Canopy Sill, Fwd Fus, F/A-18B (Y365.700 to Y383.000)	FIG 037 00
Plenum, Acoustical - Installation of F/A-18B	FIG 037 05
Fuselage Section - Fwd Fus, Side Panel, Aft	FIG 042 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Structure Repair, General Information	A1-F18AC-SRM-200
Introduction	WP002 00
Locating Blind Holes and Trim Lines	WP004 03
Gang Channel and Plate Nut Identification and Repair	WP004 05
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Aluminum Sheet Edge Repair	WP034 00
Aluminum Sheet Repairs, Across Structure and Lands	WP036 00
Blending	WP038 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Windshield, Canopy, and Cockpit Finish System	WP021 00
Integrated Flight Controls	A1-F18AC-570-300
Rear Cockpit Rudder - Brake Pedal Mechanism and Control Assemblies, F/A-18B	WP020 01

Alphabetical Index

Subject	Page No.
Damage Evaluation	2
Negligible Damage	2
Repairable Damage	2
Repairs	2
Permanent Repairs	2
Cracks	3
Dents	4
Edge	3
Holes	3
Scratches, Nicks, Gouges, or Corrosion	2
Replacement	11

Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F/A-18 AFC 22	1 May 89	Lateral Primary Controls FOD Protection, Improvement of (ECP MDA-F/A-18-00100/C1)	1 Mar 86	-

Support Equipment Required

None

NOTE

The limits in table 2 apply after blending the damage.

Materials Required

None

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figure 1. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Damage not listed or exceeding the following limits require a depot engineering disposition.

3. **NEGLECTIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

c. When rivet tilt is noted, further investigation is needed to determine the effect on sealing.

4. **REPAIRABLE DAMAGE.** The types and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with figure and index numbers in the material index, figure 1.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and lands must have edge cleanup hole at least eight repair fasteners diameters from any land, internal structure, or existing row of fasteners.

(2) Damage to lands, over structure, only one repair per land.

5. **REPAIRS.**

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definition are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

7. **PERMANENT REPAIRS.**8. **Scratches, Nicks, Gouges, or Corrosion.**

Blend scratches, nicks, gouges, or corrosion (A1-F18AC-SRM-250, WP038 00). If, after blending, the damage limits of table 2 are exceeded, repair aluminum sheet as below. Refinish blended areas (A1-F18AC-SRM-500, WP021 00).

a. Scratches - make crack or edge repairs.

b. Nicks, gouges, or corrosion - make hole or edge repair.

9. Cracks.

a. In repair zone A1, repair cracks free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Stop drill ends of crack in repair zone A1.

(2) In repair zone A1, install a lap patch for cracks.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone A1, repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zone A1, make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

c. In repair zone A1, repair cracks in aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zone A1, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

10. Holes.

a. In repair zone A1, repair holes free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) In repair zone A1, install a type one flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone A1, repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zone A1, make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

c. In repair zone A1, repair holes in aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) In repair zone A1, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

11. **Edge.** In repair zone A1, repair edge damage in aluminum sheet (A1-F18AC-SRM-250, WP034 00).

a. Cut out damage.

b. Select and install repair patch.

(1) Corner Damage to Lands.

(2) Corner Damage to Lands and Bays.

(3) Edge Damage to Lands.

(4) Edge Damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

12. Dents.

a. In repair zone A1, repair dents free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) In repair zone A1, install a type one flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

b. In repair zone A1, repair dents across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) In repair zone A1, make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).





c. In repair zone A1, repair dents to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).


(1) Cut out damage.

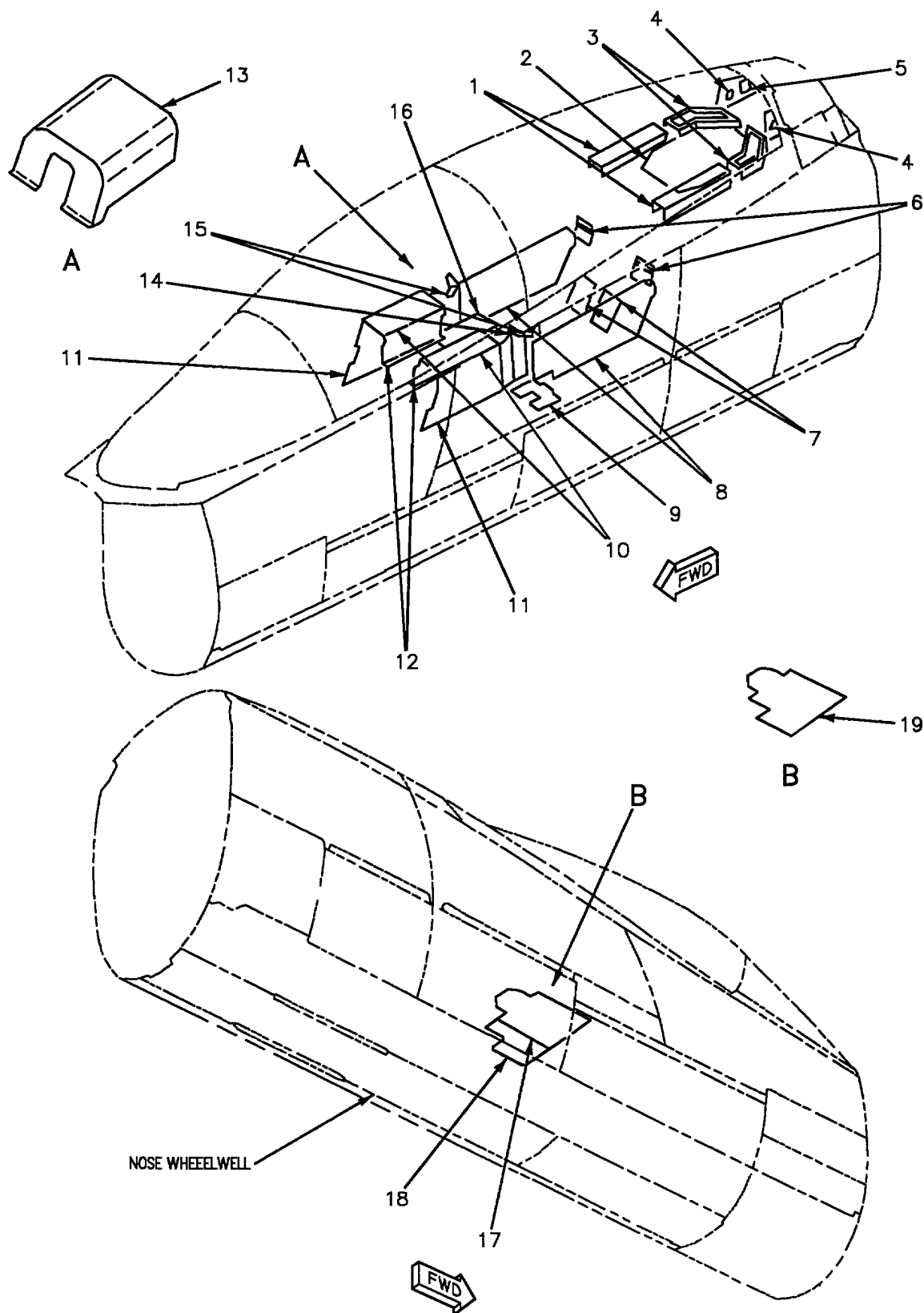
(2) In repair zone A1, install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP021 00).

Table 1. Negligible Damage Limits

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Door (CPF) Zone B4	0.040	0.0006	0.0006	100%	0.020	N/A
Fig 1 (2)	Cove Zone B4	Door (CPJ) 0.110	0.0006	0.0006	100%		N/A
		0.050	0.0006	0.0006	100%	0.025	N/A
	Zone B3	0.110	0.0006	0.0006	100%		N/A
		0.050	0.0006	0.0006	100%	0.025	N/A
Fig 1 (3)	Door (CPE) Zone B3	0.063	0.0006	0.0006	100%		N/A
		0.032	0.0006	0.0006	100%	0.016	N/A
Fig 1 (4)	Door (CPH) Zone B3	0.063	0.0006	0.0006	100%	0.031	N/A
Fig 1 (6)	Door (CPC) Zone B4	0.050	0.0006	0.0006	100%		N/A
		0.032	0.0006	0.0006	100%	0.016	N/A
Fig 1 (7)	Door (CPD) Zone C4	0.040	0.0006	0.0006	100%	0.020	N/A
Fig 1 (9)	Door (CPG) Zone A1	0.040	0.008	0.0006	100%	0.020	N/A

NOTE
 None Allowed.



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Figure 1. Material Index (Sheet 1)

























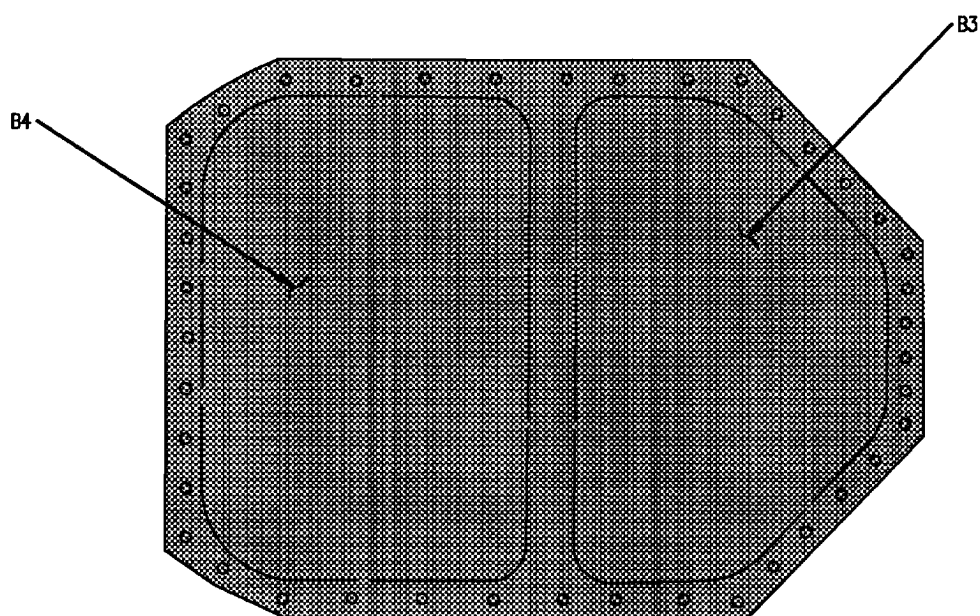
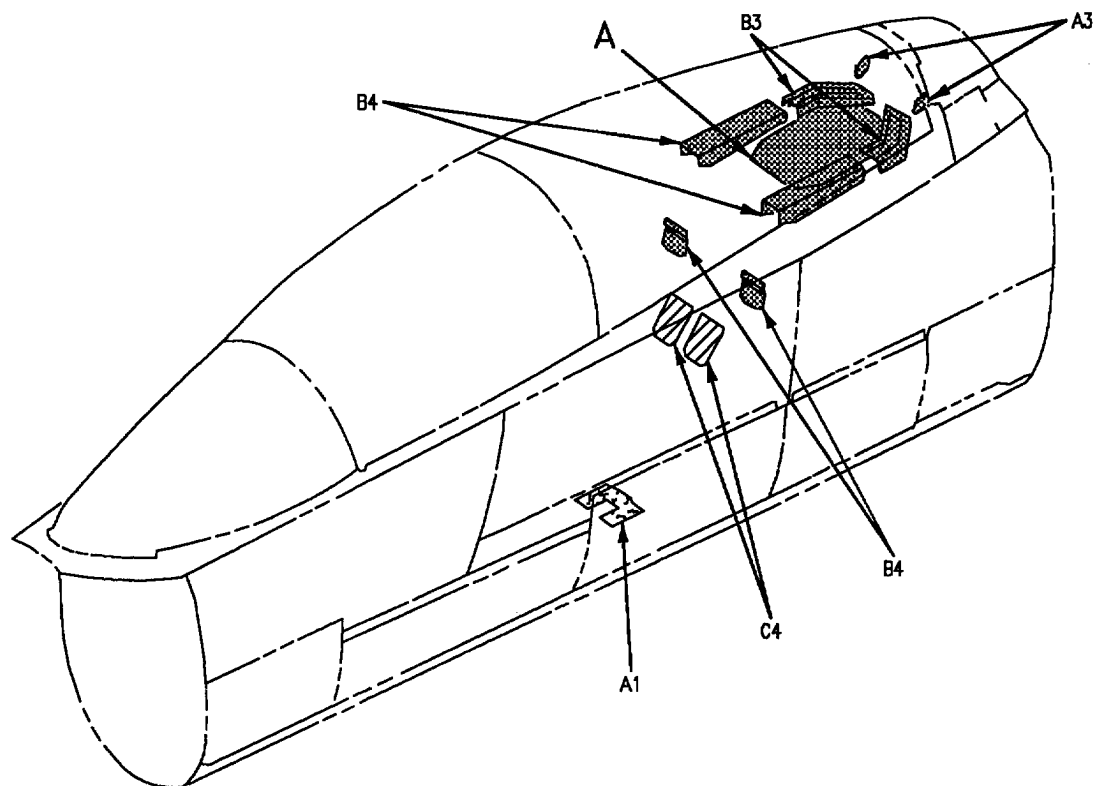
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1		Cover (Door CPF) 74A314856-2011, -2012	0.040 Sheet	7075-T6 Alclad
2	  	Cover (Door CPJ) 74A314847-2003 74A314847-2109 74A314847-2111		7075-T76 Alclad
3		Cover (Door CPE) 74A314856-2005, -2006		7075-T6 Alclad
4		Cover (Door CPH) 74A314846-2005	0.063 Sheet	7075-T6 Alclad
5		Cover (Door CPY) 74A314846-2023	0.063 Sheet	7075-T6 Alclad
6		Cover (Door CPC) 74A314832-2049, -2050		7075-T6 Alclad
7	 	Cover (Door CPD) 74A314832-2027, -2028 74A314832-2295, -2296	0.040 Sheet	7075-T6 Alclad
8	  	Cover (Door CPN) 74A802646-2005, -2006 74A802646-2011, -2006 74A802646-9003, -9004	0.030 Sheet	Thermoplastic
9		Cover (Door CPG) 74A314817-2053	0.040 Sheet	7075-T6 Alclad
10	 	Panel (Door CPT) 74A802613-2015, -2016 74A802613-9003, -9004	Sheet Sheet	Thermoplastic Polycarbonate
11	    	Kickshield (Door CPZ) 74A802615-2019, -2024 74A802615-2019, -2028 74A802615-9009, -9010 74A802615-2039, -2040 74A802615-2037, -2040	Sheet	Thermoplastic
12	 	Kickshield (Door CPX) 74A802614-2011, -2012 74A802614-9015, -9016	Sheet Sheet	Thermoplastic Polycarbonate
13	  	Cover (Door CPL) 74A802616-1001 74A802616-1003 74A802616-1005	0.063 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 2)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
14	<div>20</div> <div>13</div> <div>18</div> <div>19</div>	Kickshield (Door CPAA) 74A802615-2001, -2012 74A802615-9007, -9008 74A802615-2041, -2012 74A802615-2035, -2012	Sheet	Thermoplastic
15	<div>6</div> <div>7</div> <div>10</div>	Closure (Door CPAB) 74A802081-2003, -2004 74A802081-2011, -2012 74A802081-2013, -2014	0.040 Sheet	7075-T6Alclad
16	<div>8</div>	Panel (Door CPAC) 74A620057-2005	0.025 Sheet	7075-T6 Alclad
17	<div>19</div>	Cover 74A314889-2003	0.100 Sheet	7075-T76 Alclad
18	<div>19</div>	Cover 74A314889-2005	0.100 Sheet	7075-T76 Alclad
19	<div>21</div>	Cover 74A314889-2001	0.100 Sheet	7075-T76 Alclad
LEGEND <div>1</div> Land is 0.110, bay is 0.050. <div>2</div> Land is 0.050, bay is 0.032. <div>3</div> F/A-18B 161354 THRU 161360. <div>4</div> F/A-18B 161704 THRU 162885. <div>5</div> F/A-18B 161943 AND UP. <div>6</div> F/A-18B 161354 THRU 161733. <div>7</div> F/A-18B 161740 THRU 161947. <div>8</div> F/A-18B 161932 AND UP; ALSO 161354 THRU 161924 AFTER F18 AFC 22. <div>9</div> F/A-18B 161354 THRU 161947. <div>10</div> F/A-18B 162402 AND UP. <div>11</div> F/A-18B 161704 THRU 161733. <div>12</div> F/A-18B 161354 THRU 162427 and 162885 AND UP. <div>13</div> F/A-18B 162836 THRU 162876. <div>14</div> F/A-18B 161740 AND UP. <div>15</div> Land is 0.063, bay is 0.032. <div>16</div> F/A-18B 161704 THRU 162427 AND 162885 AND UP. <div>17</div> F/A-18B 162402 THRU 162427. <div>18</div> F/A-18B 162885. <div>19</div> F/A-18B 163104 AND UP. <div>20</div> F/A-18B 161354 THRU 162427. <div>21</div> F/A-18B 161354 THRU 162885.				

Figure 1. Material Index (Sheet 3)



A

Figure 2. Repair Zones

13. REPLACEMENT.

14. Fastener attaching hardware is shown for covers as below:

a. Cover (Door CPC) is interchangeable. Fastener attaching hardware is shown on figure 3. For fasteners (A1-F18AC-SRM-420, FIG 023 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

b. Cover (Door CPD) is interchangeable. Fastener attaching hardware is shown on figure 4. For fasteners (A1-F18AC-SRM-420, FIG 023 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

c. Cover (Door CPE) is interchangeable. Fastener attaching hardware is shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 036 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

d. Cover (Door CPF) is interchangeable. Fastener attaching hardware is shown on figure 6. For fasteners (A1-F18AC-SRM-420, FIG 036 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

e. Cover (Door CPG). Fastener attaching hardware is shown on figure 7. For fasteners (A1-F18AC-SRM-420, FIG 042 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

f. Cover (Door CPH) is interchangeable. Fastener attaching hardware is shown on figure 8. For fasteners (A1-F18AC-SRM-420, FIG 037 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

g. Cover (Door CPJ) is interchangeable. Fastener attaching hardware is shown on figure 9. For fasteners (A1-F18AC-SRM-420, FIG 036 00).

h. Cover (Door CPL) is replaceable and requires drilling. For locating blind holes (A1-F18AC-SRM-200, WP004 03). Fastener attaching hardware is shown on figure 10. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

i. Cover (Door CPN) is interchangeable. Fastener attaching hardware is shown in figure 11. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

j. Cover (74A314889). Cover is interchangeable. Fastener attaching hardware is shown on figure 12.

Support Equipment Required

None

Materials Required

None

(1) Remove rear cockpit rudder-brake pedal mechanism (A1-F18AC-570-300, WP020 01).

(2) Remove fasteners attaching door to structure. For replacement fasteners (A1-F18AC-SRM-420, FIG 037 05).

(3) Inspect plate nuts and/or gang channels. Replace any damaged hardware per figure 12.

NOTE

For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05).

(4) Position cover and install fasteners.

(5) Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

(6) Install rear cockpit rudder-brake pedal mechanism (A1-F18AC-570-300, WP020 01).

k. Panel (Door CPT) is interchangeable. Fastener attaching hardware is shown on figure 13.

For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

l. Kickshield (Door CPX) is interchangeable. Fastener attaching hardware is shown on figure 14. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

m. Cover (Door CPY) is interchangeable. Fastener attaching hardware is shown on figure 15. For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

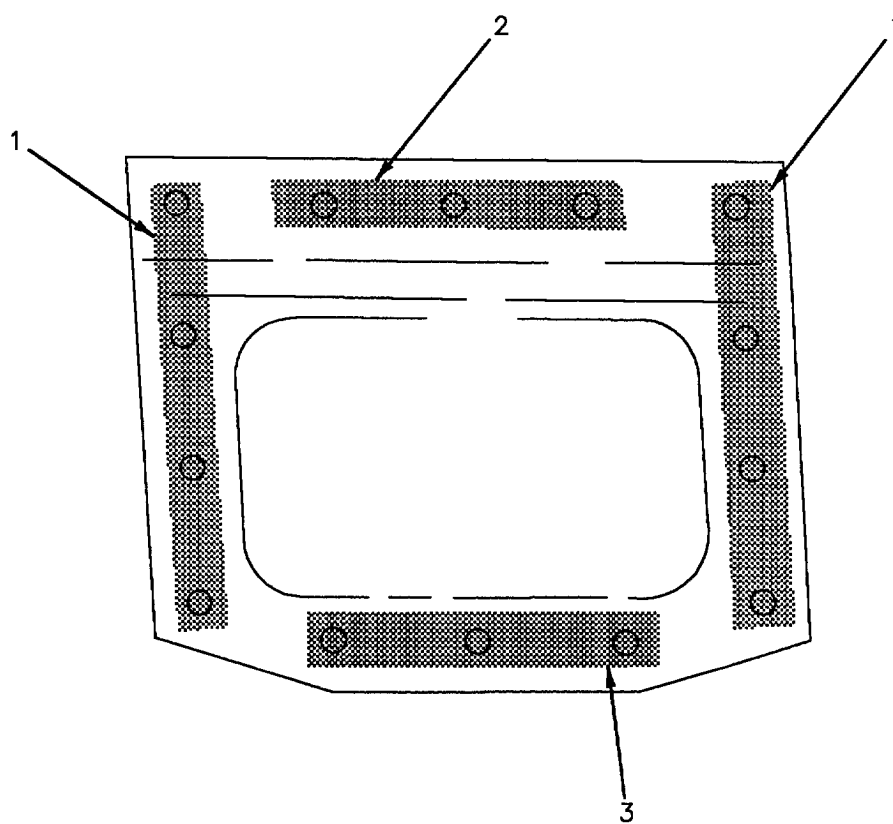
n. Kickshield (Door CPZ) is interchangeable. Fastener attaching hardware is shown on figure 16. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown

(A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

o. Kickshield (Door CPAA) is interchangeable. Fastener attaching hardware is shown on figure 17. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

p. Closure (Door CPAB) is interchangeable. Fastener attaching hardware is shown on figure 18. For fasteners (A1-F18AC-SRM-420, FIG 019 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

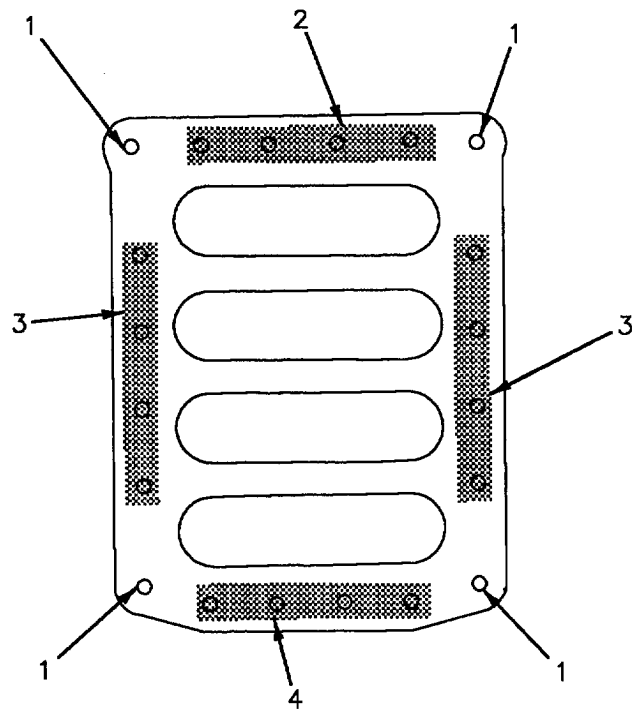
q. Panel (Door CPAC) is interchangeable. Fastener attaching hardware is shown on figure 19. For fasteners (A1-F18AC-SRM-420, FIG 042 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).



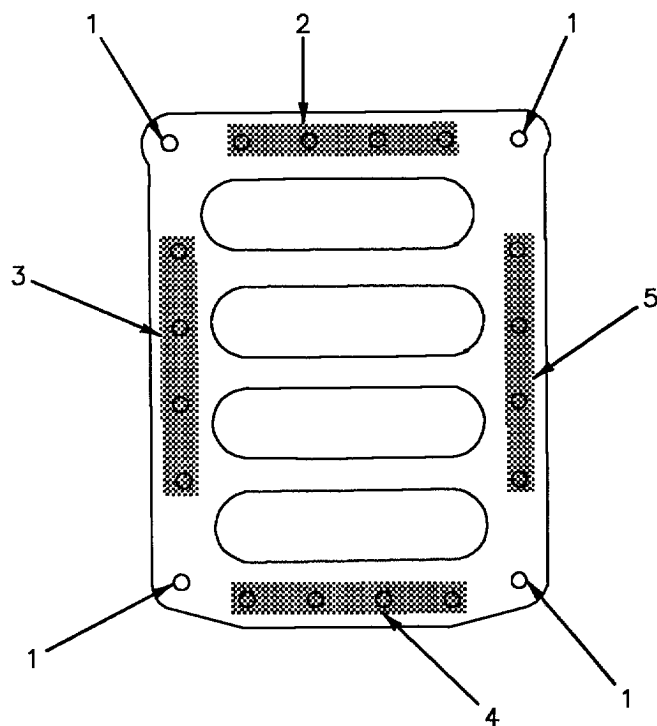
18AC-SRM-222-(84-1)01-SCAN

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2			Gang Channel	G50344-3-2-9
3			Gang Channel	G50344-3-2-10
LEGEND				
Hole diameter is 0.203 +0.006 -0.000.				

Figure 3. Cover (Door CPC) Replacement



LEFT SIDE
LOOKING AFT



RIGHT SIDE
LOOKING AFT

Figure 4. Cover (Door CPD) Replacement (Sheet 1)











IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21060L3
2			Gang Channel	G50344-3-2-8
3		  Gang Channel		G50344-3-2-8
4		  Gang Channel		G50344-3-2-9
5		  Gang Channel		7A4314832-2267
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.203 +0.006 -0.000.</p> <p> Attached with CSR904B3 rivets, length to be determined on installation.</p>				

Figure 4. Cover (Door CPD) Replacement (Sheet 2)

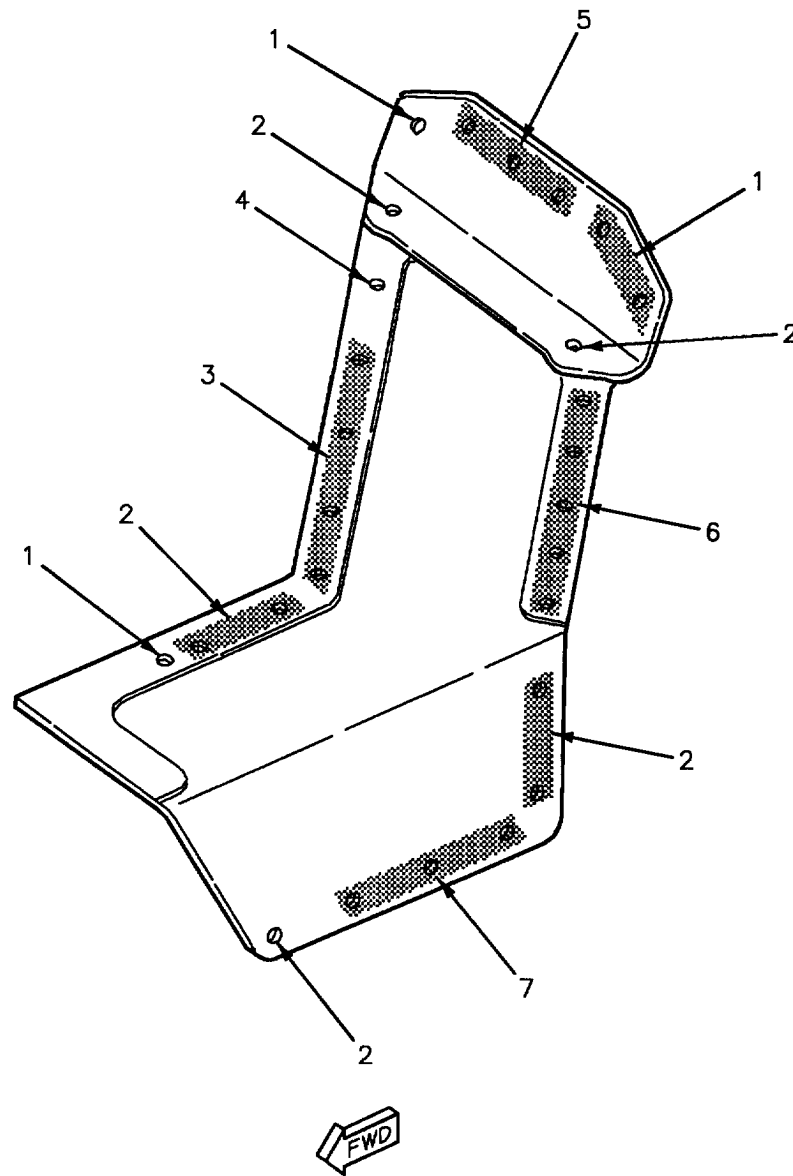


Figure 5. Cover (Door CPE) Replacement (Sheet 1)









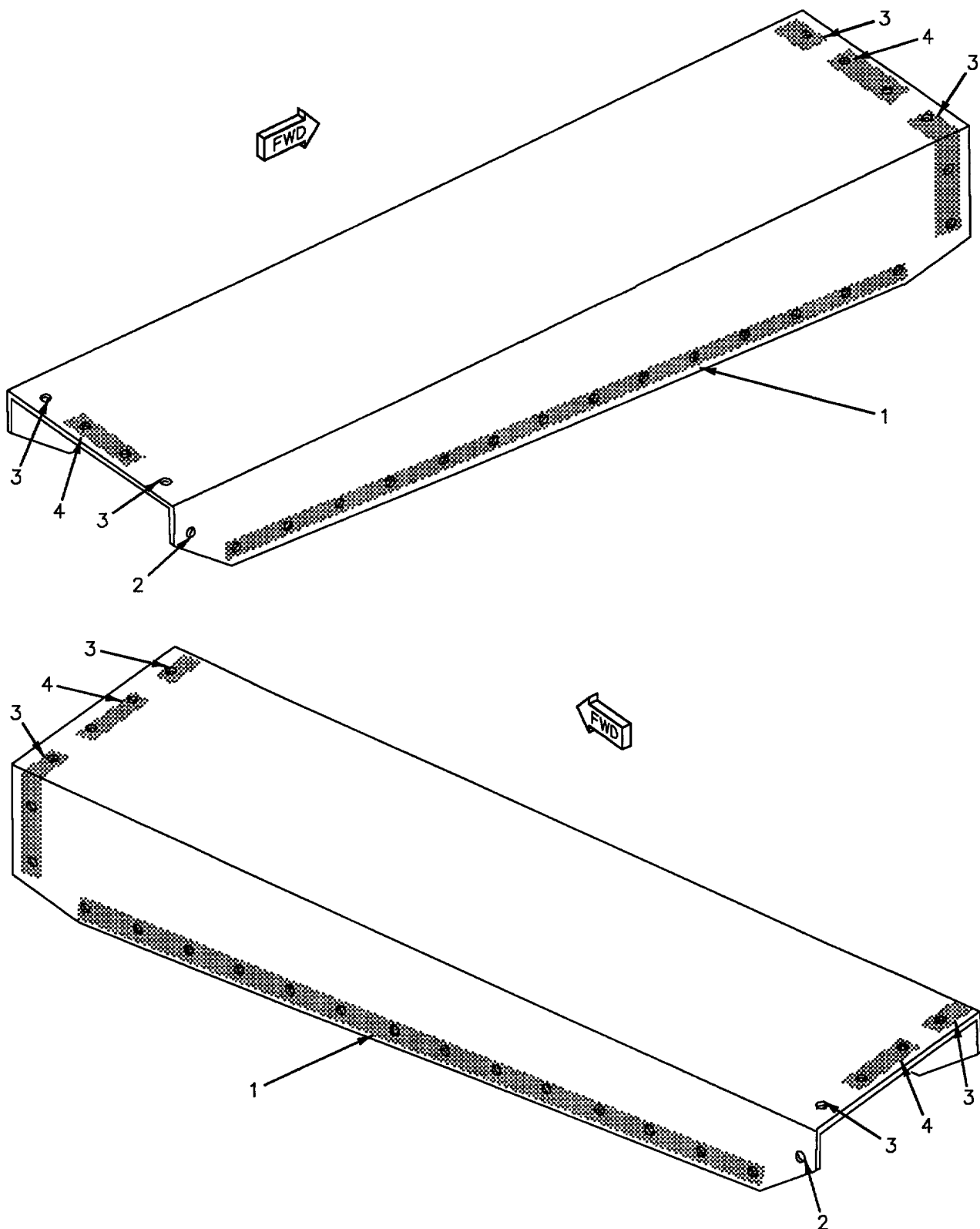
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50339-3-1
2			Plate Nut	F50340-3-1
3			Gang Channel	G1085LJ3-12
4			Plate Nut	F29339-01-3
5			Gang Channel	G10851J3-9
6			Gang Channel	G10851J3-10
7			Gang Channel	G10851J3-11
LEGEND				
 Hole diameter is 0.203 +0.006 -0.000.				

Figure 5. Cover (Door CPE) Replacement (Sheet 2)



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Figure 6. Cover (Door CPF) Replacement (Sheet 1)






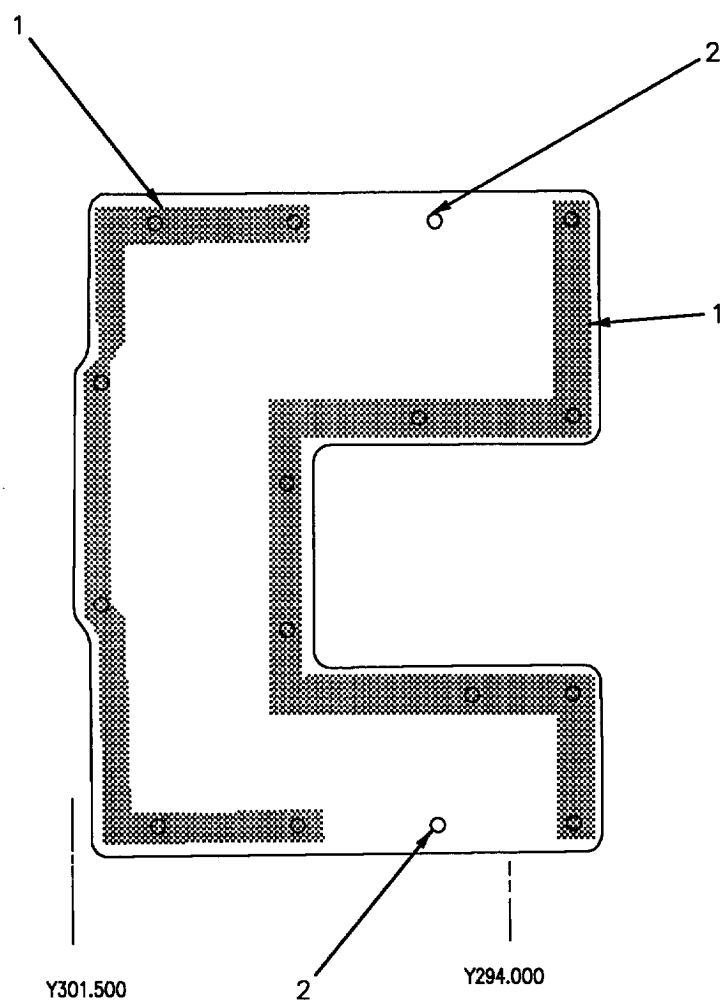
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Gang Channel	G10851J3-10
2			Plate Nut	F29339-01-3
3			Plate Nut	F50340-3-1
4			Plate Nut	F50339-3-1
LEGEND				
 Hole diameter is 0.203 +0.006 -0.000.				

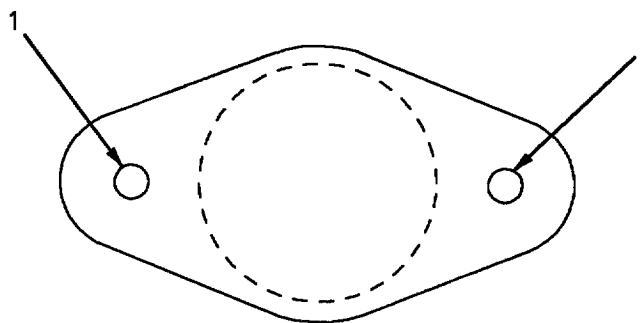
Figure 6. Cover (Door CPF) Replacement (Sheet 2)



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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21060L3
2			Plate Nut	MS21062L3
LEGEND				
Hole diameter is 0.196 +0.006 -0.000.				

Figure 7. Cover (Door CPG) Replacement



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



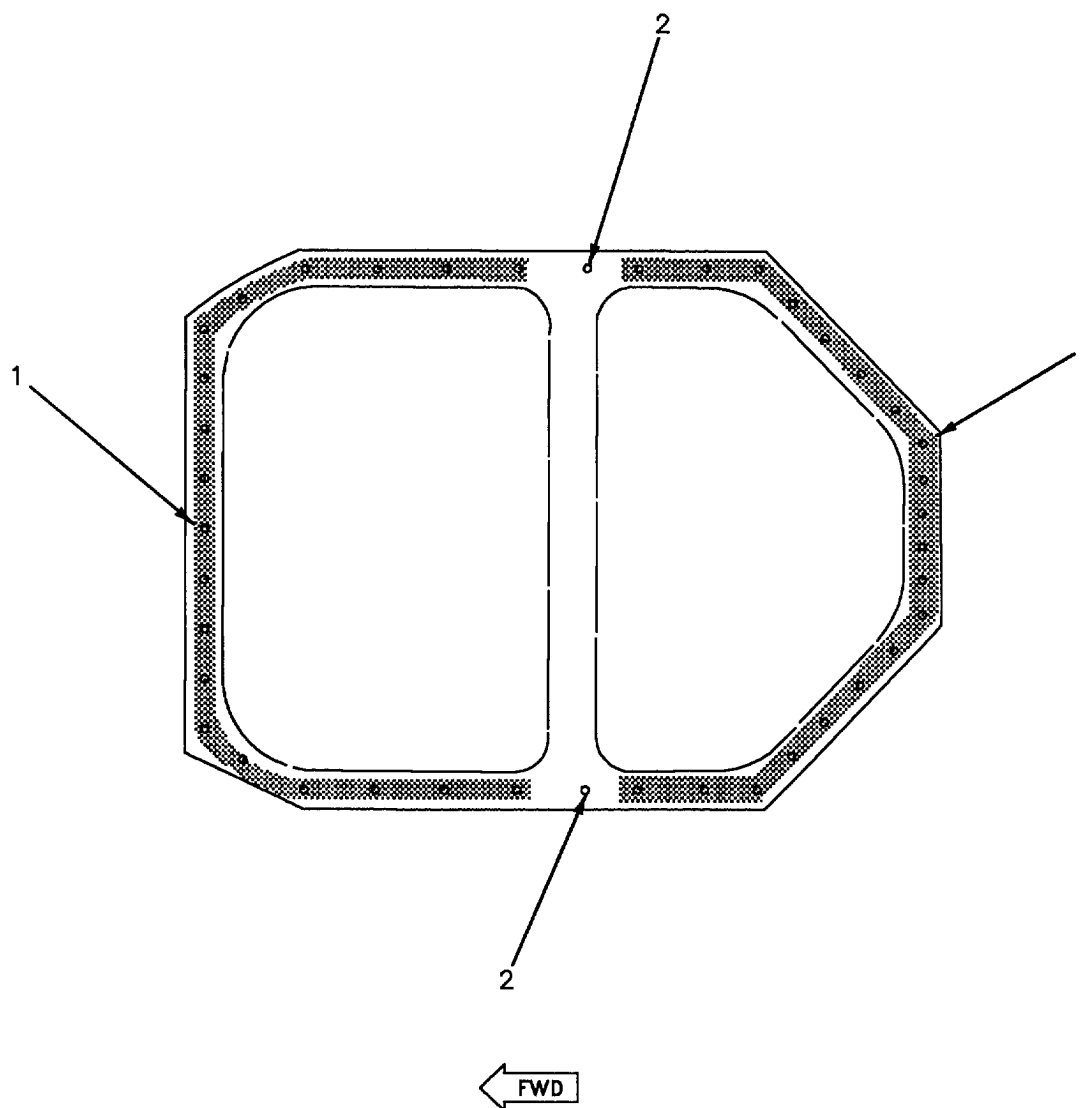
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			 Plate Nut	F39668-4
LEGEND				
 Hole diameter is 0.265 +0.007 -0.000.				
 Attached with CSR904B4 rivets, length to be determined on installation.				

Figure 8. Cover (Door CPH) Replacement



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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut Shim	F50406-4 NAS463XD416
2			Plate Nut	F50406-4
LEGEND				
Hole diameter is 0.250 +0.006 -0.000.				

Figure. 9 Cover (Door CPJ) Replacement

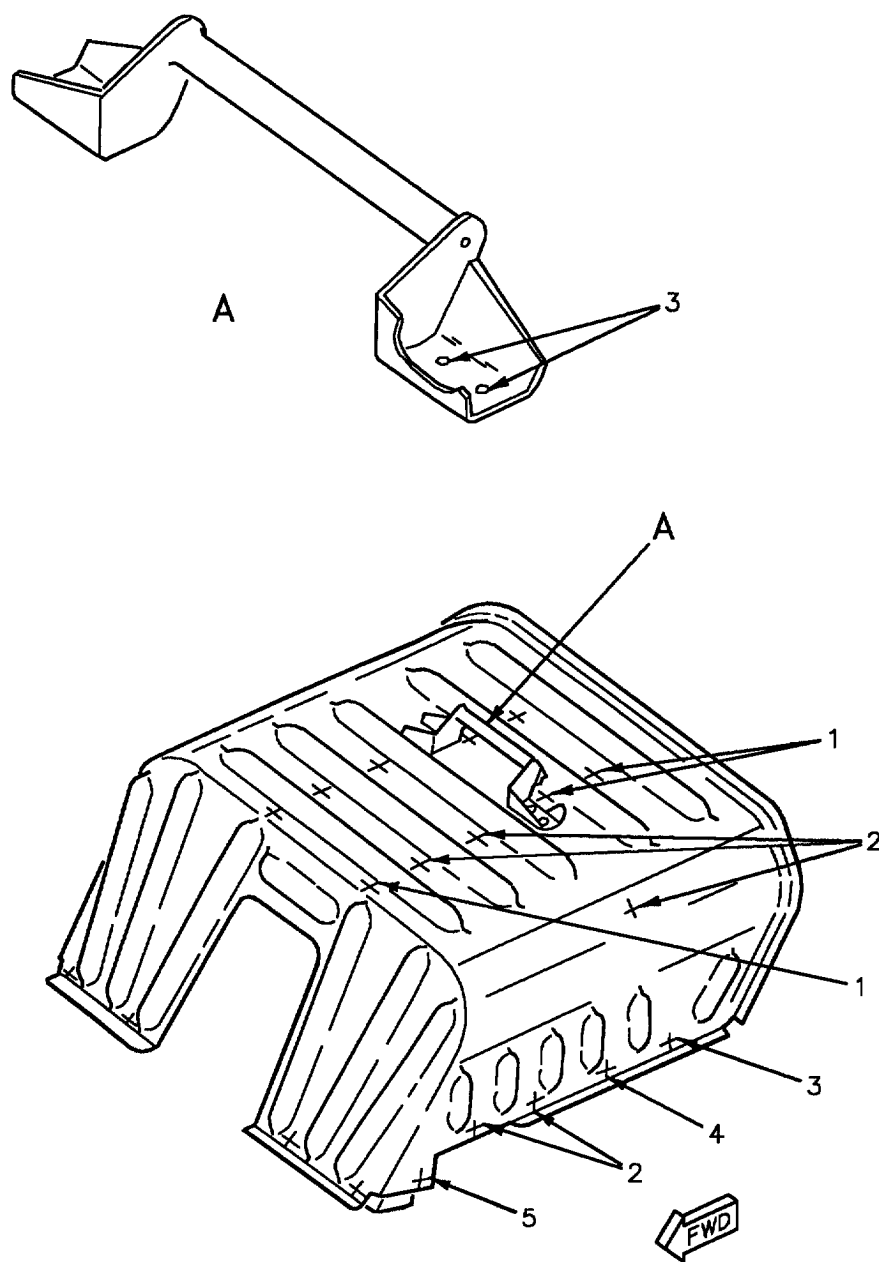


Figure 10. Cover (Door CPL) Replacement (Sheet 1)







IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49251E3-2
2			Plate Nut	F49249E3-2
3			Plate Nut	F49251E3-1
4			Plate Nut	F49249E3-1
5			Plate Nut	MS21062L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				

Figure 10. Cover (Door CPL) Replacement (Sheet 2)

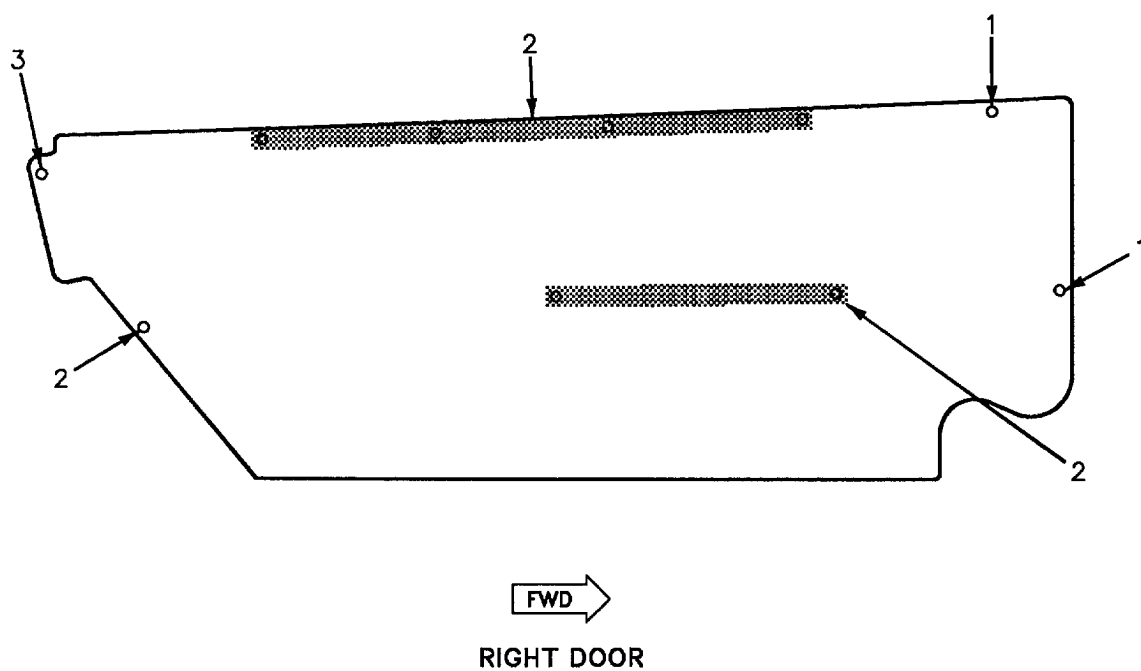
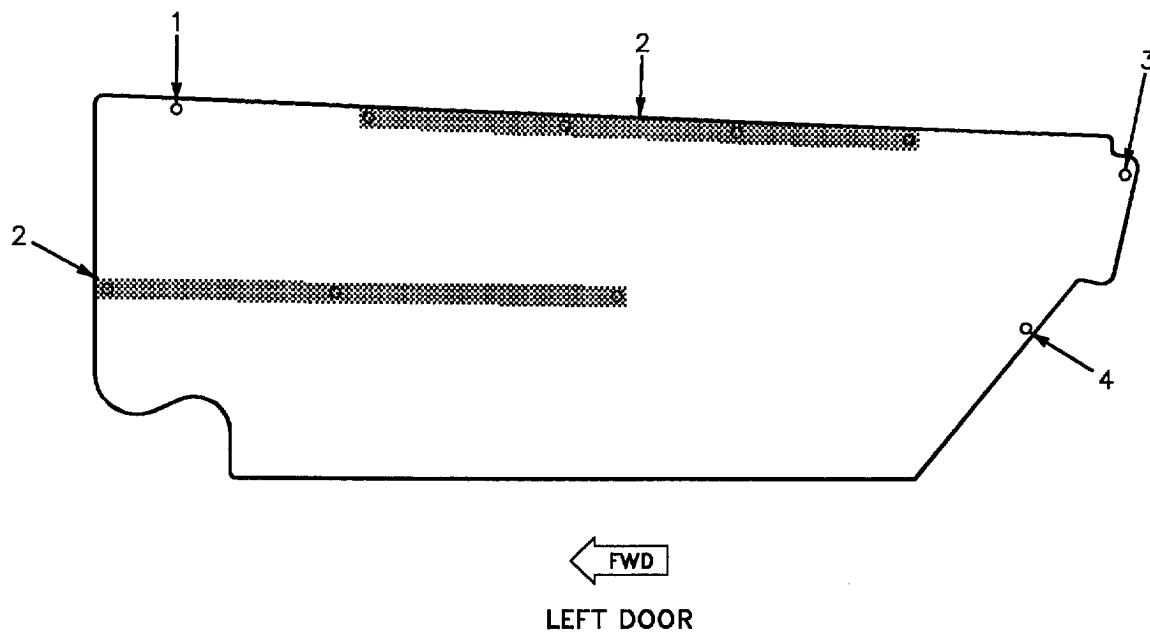


Figure 11. Cover (Door CPN) Replacement (Sheet 1)








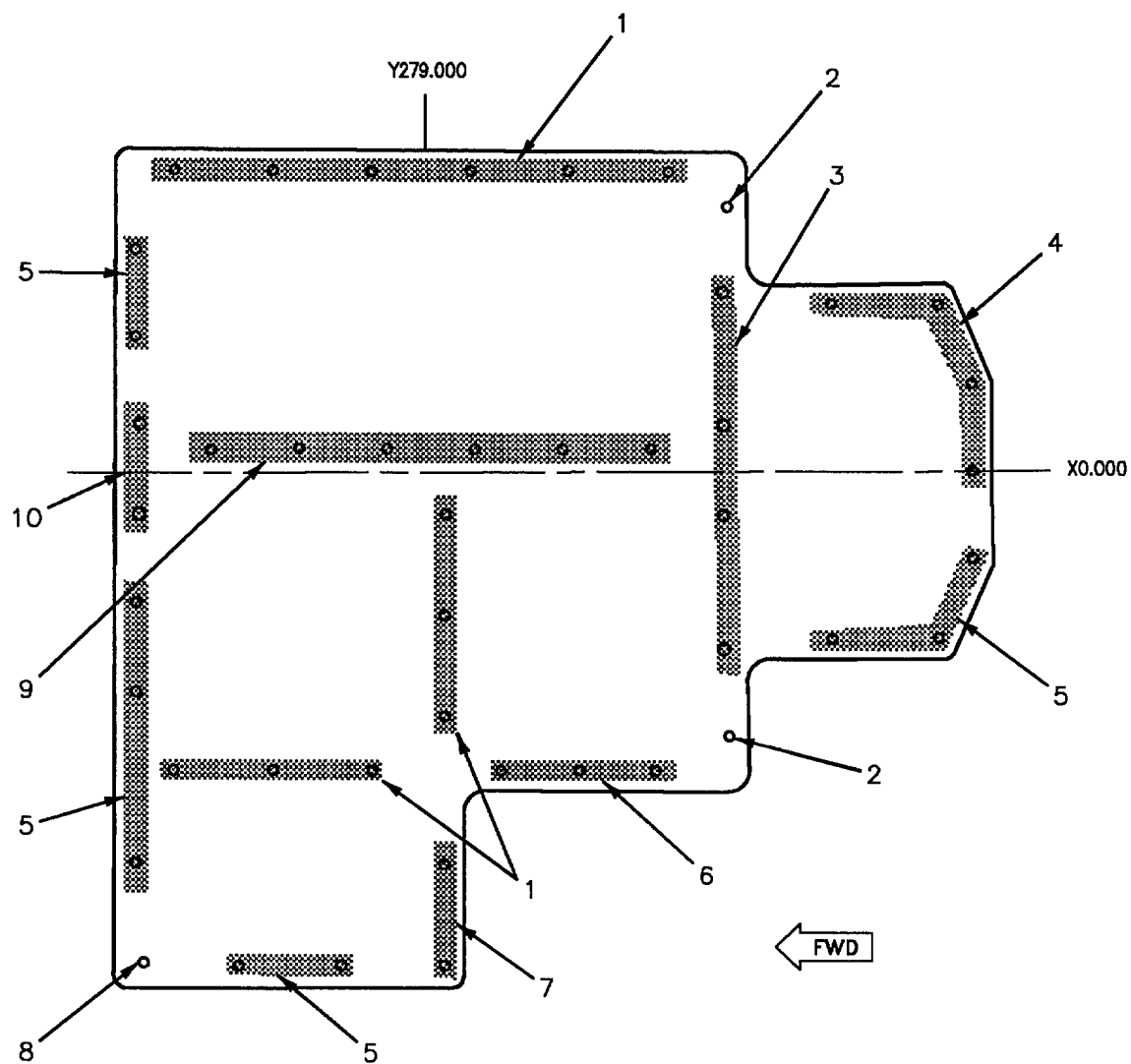
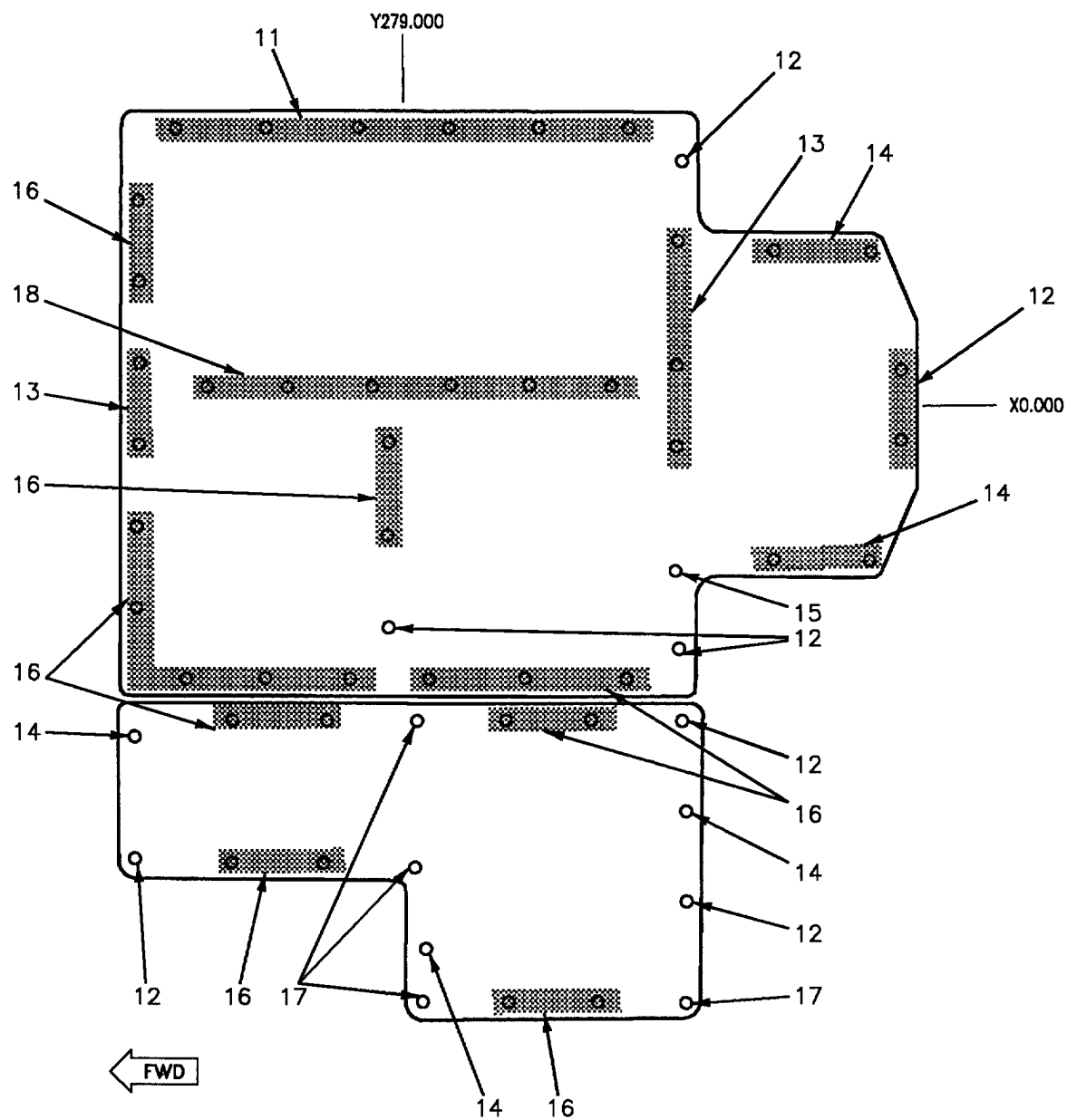
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21062L3
2			Plate Nut	MS21060L3
3			Plate Nut	F50340-3-1
4			 Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				
 Attached with CSR904B3 rivets, length to be determined on installation.				

Figure 11. Cover (Door CPN) Replacement (Sheet 2)



F/A-18B 161354 THRU 162885

Figure 12. Cover (74A314889) Replacement (Sheet 1)



F/A-18B 163104 AND UP

Figure 12. Cover (74A314889) Replacement (Sheet 2)






























































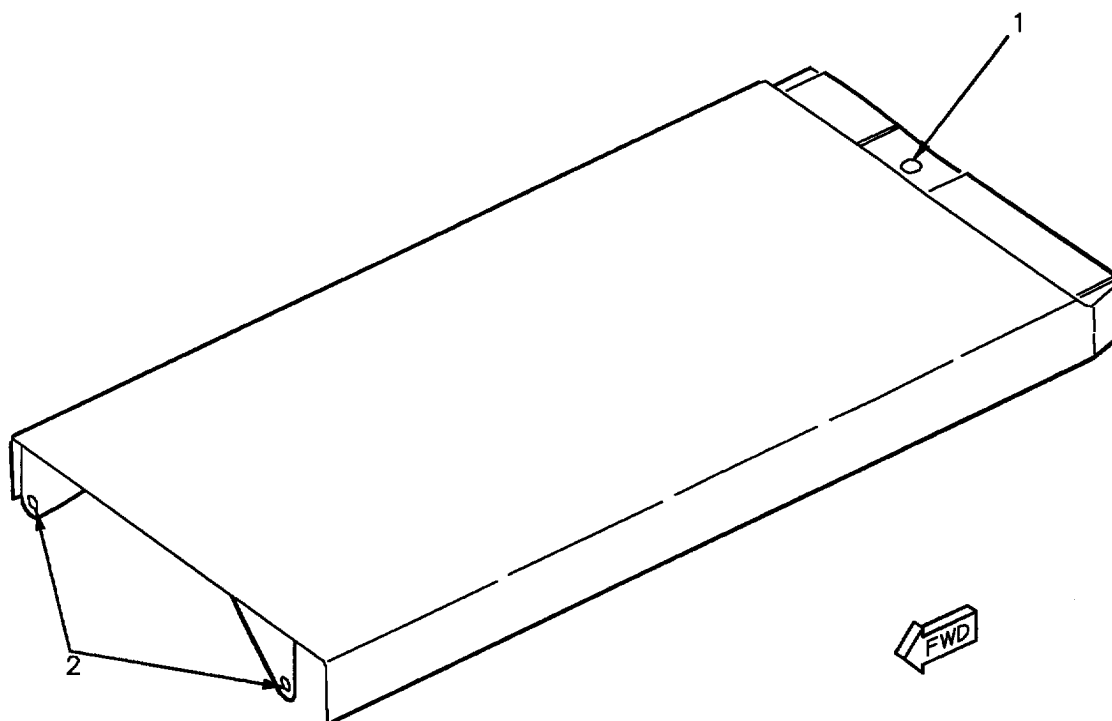
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			 Gang Channel	G18421JL2-3-18
2			 Plate Nut	F49251E3-1
3			 Plate Nut	F49249E4-1
4			 Plate Nut	F49249E3-1
5			 Plate Nut	F49249E3-2
6			 Gang Channel	G18421JL2-3-14
7			 Plate Nut	F49249E3-2
8			 Plate Nut	F49249E3-1
9			 Gang Channel	G18421JL2-3-16
10			 Plate Nut	F49249E4-1
11			 Gang Channel	G18421JL2-3-18
12			 Plate Nut	F49251E3-1
13			 Plate Nut	F49249E4-1
14			 Plate Nut	F49249E3-1
15			 Plate Nut	F49251E4-1
16			 Plate Nut	F49249E3-2
17			 Plate Nut	F49251E3-2
18			 Gang Channel	G18421JL2-3-16
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p> <p> Hole diameter is 0.250 +0.006 -0.000.</p> <p> Attached with CSR904B3 rivets, length to be determined on installation.</p> <p> Attached with RV1241-3 rivets, length to be determined on installation.</p> <p> F/A-18B 161354 THRU 162885.</p> <p> F/A-18B 163104 AND UP.</p> <p> Attached with NAS1097AD3 rivets, length to be determined on installation.</p>				

Figure 12. Cover (74A314889) Replacement (Sheet 3)



18AC-SRM-222-(94-1)01-SCAN



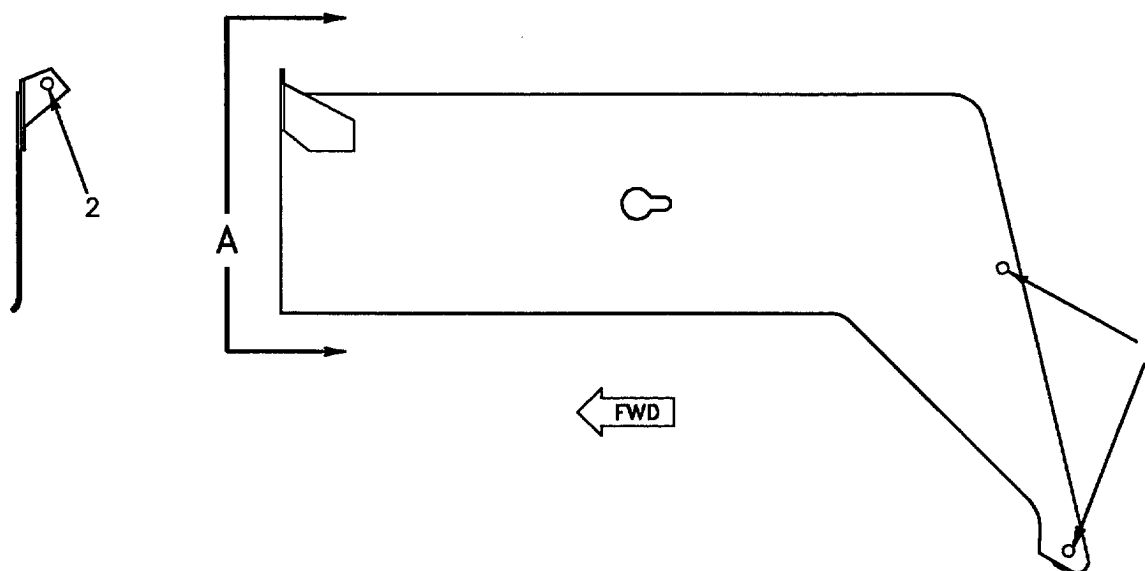
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Receptacle	99833-P130
2			Nut	NAS1291C4M
LEGEND				
 Hole diameter is 0.500 +0.007 -0.001.				
 Hole diameter is 0.227 +0.007 -0.000.				

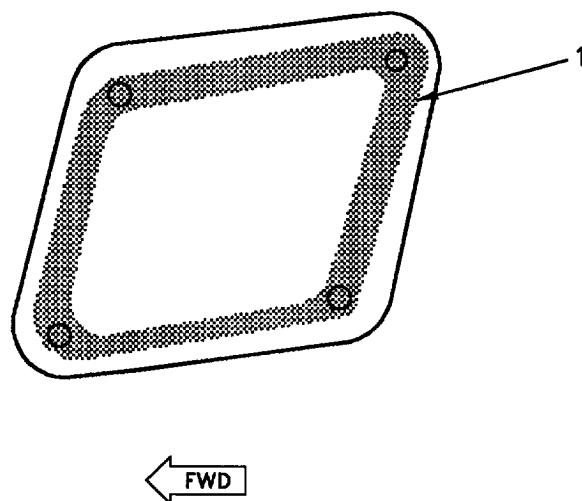
Figure 13. Panel (Door CPT) Replacement



18AC-SRM-222-(95-1)01-CAT1

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F50403-3-1
2			Nut	NAS1291C4M
LEGEND				
Hole diameter is 0.205 +0.006 -0.000.				
Hole diameter is 0.277 +0.007 -0.000.				

Figure 14. Kickshield (Door CPX) Replacement



18AC-SRM-222-(96-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F39668-4
LEGEND				
Hole diameter is 0.265 +0.007 -0.000.				
Attached with CSR904B4 rivets, length to be determined on installation.				

Figure 15. Cover (Door CPY) Replacement

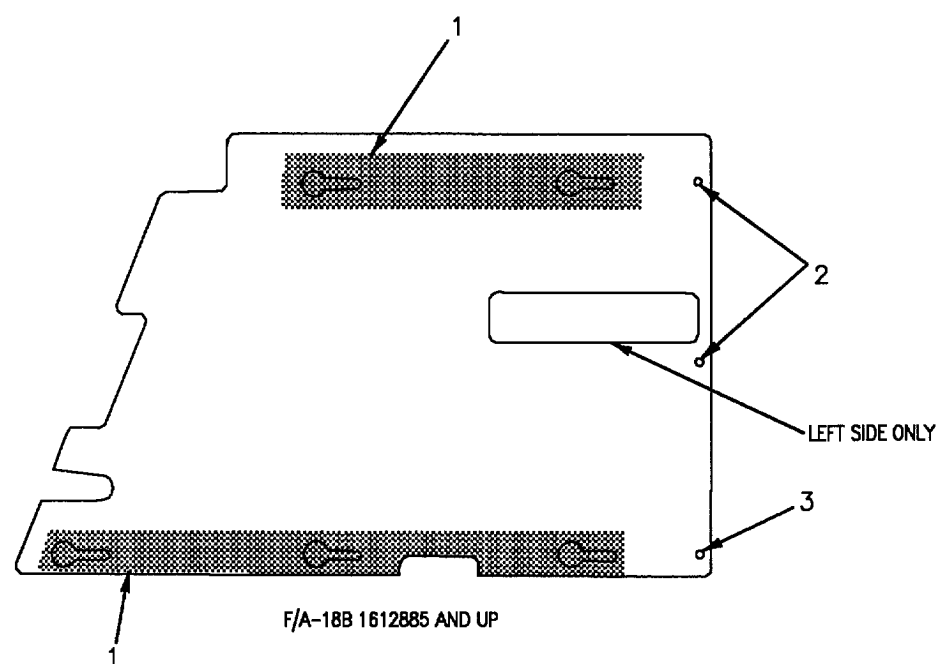
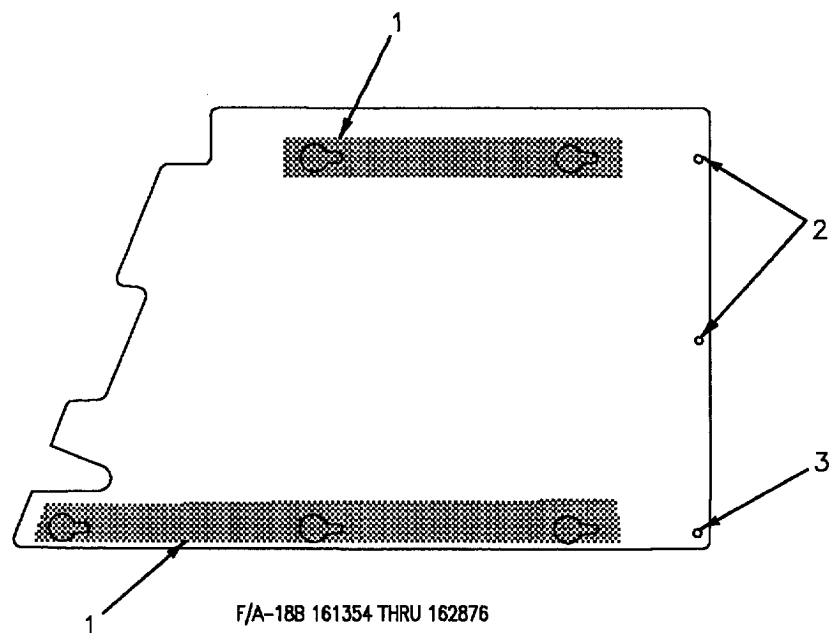


Figure 16. Kickshield (Door CPZ) Replacement (Sheet 1)






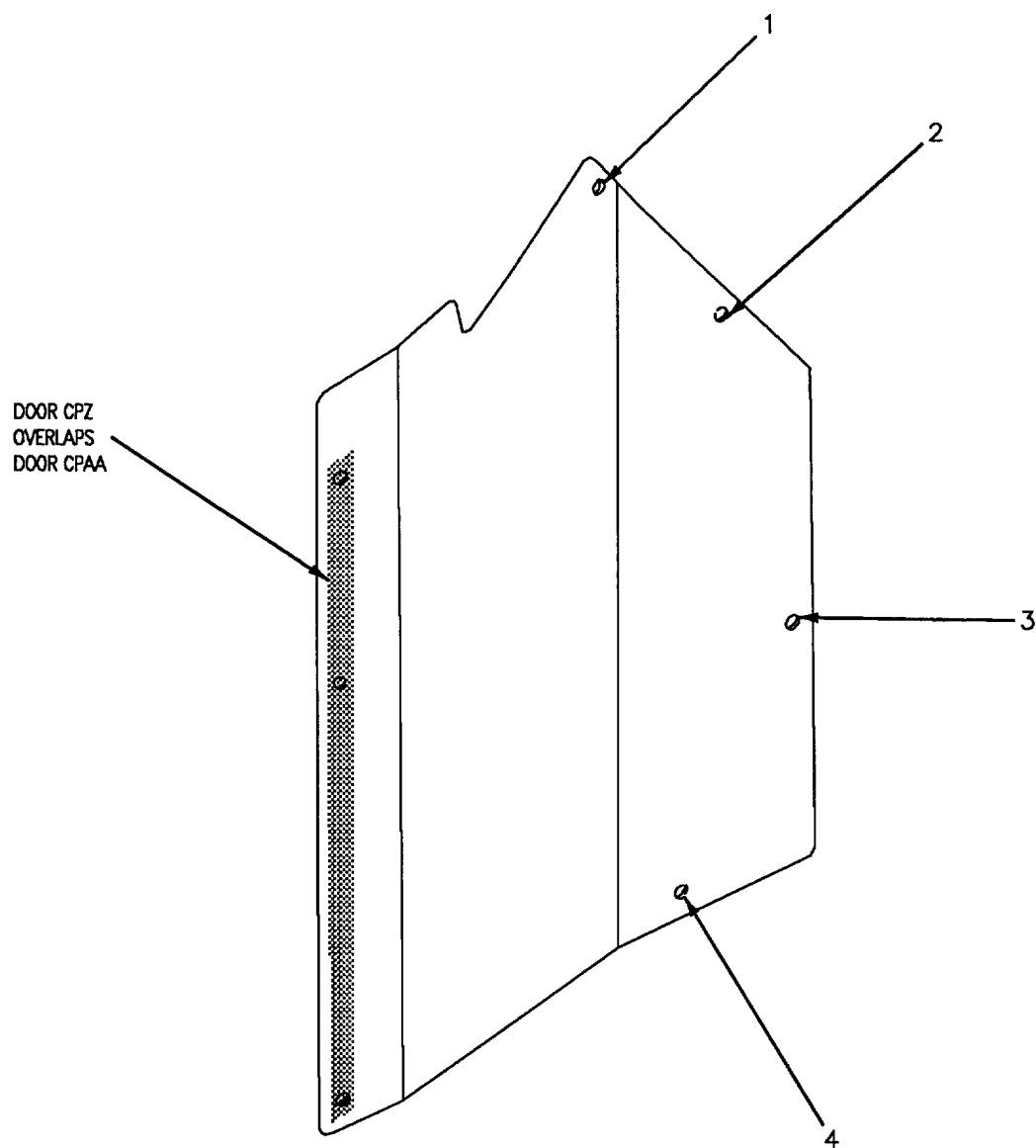
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Nut	NAS1291C3M
2			Plate Nut	MS21062L3
3			 Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.205 +0.006 -0.000.				
 Attached with CSR904B3 rivets, length to be determined on installation.				

Figure 16. Kickshield (Door CPZ) Replacement (Sheet 2)

**Figure 17. Kickshield (Door CPAA) Replacement (Sheet 1)**








IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Nut	NAS21061L3
2			Plate Nut	F29339-01-3
3			Plate Nut	MS21060L3
4			 Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.205 +0.006 -0.000.				
 Attached with CSR904B3 rivets, length to be determined on installation.				

Figure 17. Kickshield (Door CPAA) Replacement (Sheet 2)









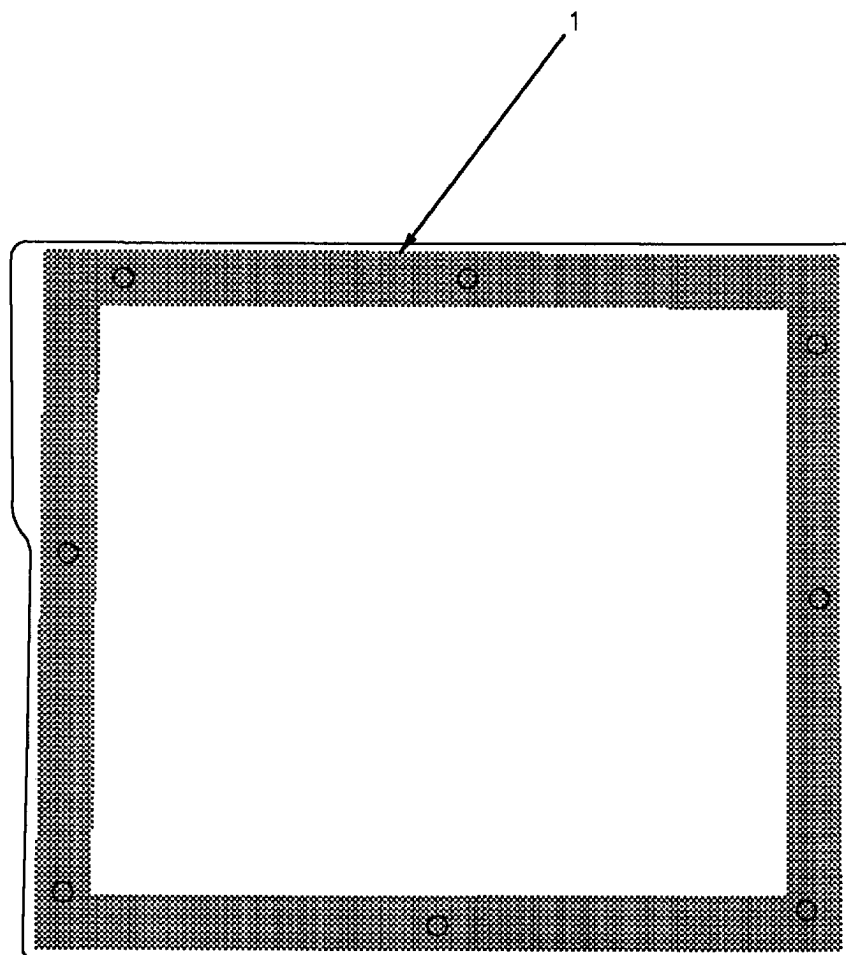
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21061L3
2	 	 	Plate Nut Gang Channel	F29339-01-3 G50344-3-1-10
LEGEND  Hole diameter is 0.195 +0.007 -0.000.  F/A-18B 161354 THRU 161360.  F/A-18B 161704 AND UP.				

Figure 18. Closure (Door CPAB) Replacement (Sheet 2)



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Figure 19. Panel (Door CPAC) Replacement (Sheet 1)





IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			 Plate Nut	MS21060L3
LEGEND				
 Hole diameter is 0.195 +0.007 -0.000.				
 Attached with 1415-0306 rivets.				

Figure 19. Panel (Door CPAC) Replacement (Sheet 2)

ORGANIZATIONAL AND INTERMEDIATE MAINTENANCE**STRUCTURE REPAIR****NOSE LANDING GEAR DOORS**

Reference Material

Structure Repair, General Information	A1-F18AC-SRM-200
Locating Blind Holes and Trim Lines	WP004 03
Drilling and Machining Composite	WP004 08
Aircraft Corrosion Control	A1-F18AC-SRM-500
Landing Gear, Arresting Hook, and Launch Bar, Finish System and Markings	WP042 00
Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Landing Gear, Retractable Nose, (Doors and Fairing) Installation of	FIG022 00
Landing Gear and Related Systems	A1-F18AC-130-300
NLG Left Forward Door	WP028 00
NLG Right Forward Door	WP029 00
NLG Aft Door	WP030 00
NLG Drag Brace Fairing	WP031 00
Nondestructive Inspection	A1-F18AC-SRM-300
Nose Landing Gear Aft Door, Water in Honeycomb	WP079 00
Nose Landing Gear Aft Door, Skin to Core Unbonds and Edge Delaminations	WP079 01
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Water Removal	WP005 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class I Damage Repair	WP012 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class II Damage Repair	WP013 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class III Damage Repair	WP014 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class IV Damage Repair	WP015 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class V Damage Repair	WP016 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class VI Damage Repair	WP017 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class VII Damage Repair	WP018 00
Graphite Epoxy Skin and Aluminum Honeycomb Core, Class IX Damage Repair	WP019 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509

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Record of Applicable Technical Directives

None

1. DAMAGE EVALUATION, COMPOSITE SKIN AND STRUCTURE. See figure 1.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. Locating and determining size of damage by NDI method is intermediate maintenance. Damage not listed or exceeding the limits listed below require a depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** See figure 2. Negligible damage may be allowed to exist as is. Type and limits are as below:

a. Delaminations between skin or formed plies. See section A, G, H and J. Determine size and location of delamination (A1-F18AC-SRM-300, WP079 01).

(1) Delaminations do not extend to edge of skin.

(2) Diameter is 1/2 inch or less.

(3) Distance between delaminations is at least four times the diameter of the largest delamination. Measure distance between delaminations edge to edge.

(4) No more than three delaminations are in a 12 inch diameter circle.

(5) No delaminations within 3 inches of leading edge.

b. Unbonds between skin and honeycomb core. See section B. Determine size and location of unbonds (A1-F18AC-SRM-300, WP079 01).

(1) Unbonds do not extend to edge of skin.

(2) Diameter is 3/4 inch or less.

(3) Distance between unbonds is at least 4 inches. Measure distance between unbonds edge to edge.

(4) No more than three unbonds are in a 12 inch diameter circle.

(5) No unbonds within 3 inches of leading edge.

c. Unbonds between skin and composite rib or closure. See sections C and E.

(1) No unbonds within 3 inches of leading edge.

(2) Diameter is 1/4 inch or less.

(3) No longer than 1 inch.

(4) Unbonds do not extend to edge of skin.

(5) Unbonds are separated by at least eight diameters of largest unbond, measured edge to edge.

(6) Unbond area no greater than 0.20 square inches.

d. Channel to honeycomb core unbonds and/or voids. See section D and F.

(1) No unbonds and/or voids within 3 inches of leading edge.

(2) Total cumulative length of unbonds and/or voids does not exceed 2 inches in 20 inches.

(3) Diameter is 1/2 inch or less.

e. Dents. See section A.

(1) Diameter is less than 3 inches.

(2) Depth is less than 0.015 inches.

4. **REPAIRABLE DAMAGE.** See figure 3. Repairable damage is damage that can be permanently repaired with no adverse affect on structural integrity, flight characteristics, or safety of the aircraft. See figure 4 for repair zones. Any damage occurring in zone C requires depot engineering disposition.

5. **Skin Surface Damage and Dents, Without Honeycomb Core Damage, Class I Damage.** See figure 3, section A. This class of damage does

not require immediate repair but shall be repaired as soon as practical. The damage shall be monitored to make sure limits are not exceeded. Class I damage is skin damage which does not exceed the limits below:

a. Cuts, scratches, pits, erosion, or abrasions.

(1) Depth is no greater than 0.005 inch.

(2) No longer than 5 inches.

b. Dents.

(1) Depth is no greater than 0.05 inch.

(2) Distance between dents is at least two diameters of the largest dent. Measure distance between dents edge to edge.

(3) Skin ply delaminations and/or skin to core unbonds do not exceed negligible damage limits.

(4) Fiber damage is no greater than 0.005 inch deep.

(5) Crushed core is not allowed.

6. **Skin to Honeycomb Core Voids or Unbonds, Class II Damage.** See figure 3, sections B and C. Class II damage is damage which does not exceed the limits listed below:

a. Former to honeycomb core unbonds and/or voids.

(1) Unbonds and/or voids that exceed negligible damage limits.

(2) Unbonds and/or voids are unlimited in size and number.

7. **Skin Delaminations, Unbonds, or Skin to Core Unbonds Not Open to Edge, Class III Damage.** See figure 3, section D. This damage is individual or multiple unbonds or delaminations that are not open to the edge. Determine size and location of unbonds (A1-F18AC-SRM-300, WP079 01). Class III damage shall not exceed limits below:

a. Unbonds between composite skins in the land area may be up to 1 inch wide and 4 inches long. Distance between unbonds shall be at least four diameters of the largest unbond.

b. Unbonds between composite skin and honeycomb core may be up to 2 inches in diameter. Distance between unbonds shall be at least four diameters of the largest unbond.

c. Delaminations between the composite skin plies in the land area should meet requirements below:

(1) Not open to the edge.

(2) No more than 3 inches in diameter.

(3) Distance between delamination is four times the diameter of the largest delamination.

8. Skin Delaminations or Unbonds Open to Edge, Class IV Damage. See figure 3, section E, F and G. Class IV damage is damage which does not exceed the limits below:

a. Skin to former unbonds.

(1) Unbonds that are open to the edge of skin.

(2) Unbonds that are not into honeycomb core.

(3) Unbond is less than 1/2 inch wide.

(4) No longer than 4 inches.

(5) Unbonds not related to any other damage.

(6) Minimum spacing is four times the length of the largest unbond.

b. Delaminations between skin plies. Determine size and location of delaminations (A1-F18AC-SRM-300, WP079 01).

(1) Delaminations that are open to the edge of skin.

(2) Delamination is less than 1/2 inch wide.

(3) No longer than 4 inches.

(4) Distance between delaminations is at least four times the length of the largest delamination.

c. Inner and outer skin unbonds.

(1) Unbonds that are open to the edge of skin.

(2) Width is 3/4-inch or less.

(3) No longer than 4 inches.

(4) Distance between unbonds is at least 4 times the diameter of the largest unbond.

9. Fiber Damage Around Fastener Holes, Surface Rips, Class V Damage. See figure 3, section H. This damage is damaged fibers around fastener holes, surface ply rips, or damaged fastener holes. Class V damage is skin damage which does not exceed the limits below:

a. Loose or broken fibers, missing fibers and/or skin abrasion around fastener holes and/or countersinks.

(1) Depth is no greater than 0.014 inch (one ply).

(2) Width is no greater than 1/4 inch.

(3) No longer than 1/2 inch.

b. Surface ply rip at edge of part.

(1) Depth is no greater than 0.014 inch (one ply).

(2) Width is no greater than 1/4 inch.

(3) No longer than 1/2 inch.

10. Skin Damage Without Penetration, Class VI Damage. See figure 3, section J. Class VI damage is damage which does not exceed the limits listed below:

a. Cracks, cuts, scratches, or erosion.

(1) Depth that is greater than 0.005 inch, but less than full skin penetration.

(2) Diameter is 2.75 inches or less.

(3) The required patch must not lap over any abrupt surface break (discontinuity), or sharp curvature that may prevent the patch from easily conforming to the skin surface. The patch may not interfere with attaching structure or cover any fasteners.

(4) Distance between damages is at least four times the diameter of the largest damage.

(5) Crushed core up to 0.015 inch deep is allowable.

b. Delaminations over core.

(1) Delaminations between skin plies not open to the edge. Damage may be up to 2.75 inches in diameter.

(2) Distance between delaminations shall be at least four diameters of the largest delamination.

(3) Depth more than 0.005 inch deep, but less than full penetration.

(4) Distance to edge of damage is at least 1-1/2 inches from fastener holes.

(5) Crushed core is not allowed.

11. Skin Damage With Penetration and Dents With Honeycomb Core Damage, Class VII Damage. See figure 3, section K. Class VII damage is damage which does not exceed the limits listed below

a. Skin and/or Honeycomb core damage.

(1) Full penetration of one and/or both skins.

(2) Honeycomb core damage is allowable.

(3) Diameter is 2.75 inch or less.

(4) Net edge distance of cleaned up damaged hole in the inner skin should be no closer than one diameter of the damaged hole from edge of skin, or closer than one diameter of the damaged hole from tangency point of the honeycomb core ramp, (example: abrupt break in skin), or extend beyond areas where the skin is not immediately adjacent to the core, (example: faying surface).

(5) Distance between damages is at least four times the diameter of the largest damage.

(6) The requirements are the same for the outer skin except the core ramp net edge distance restriction is not applicable.

(7) The required patch must not lap over any abrupt surface break (discontinuity), or sharp curvature that may prevent the patch from easily conforming to the skin surface. The patch may not interfere with attaching structure or cover any fasteners.

12. Water in Honeycomb Core, Class VIII Damage. Class VIII damage is water trapped in hon-

eycomb core. Inspect for water in honeycomb core (A1-F18AC-SRM-300, WP079 00).

13. Edge Damage, Class IX Damage. See figure 3, section L. Class IX damage is damage which does not exceed the limits listed below:

a. Skin damage.

(1) Depth of damage is no greater than 0.20 inches.

(2) Length of damage is no greater than 4.00 inches.

(3) Edge to edge spacing is no less than four times the length of the largest of two nearest damages.

(4) Class IV damage with this damage is acceptable if the class IV limitations are not exceeded.

14. REPAIRS. Classes I, II, III, IV, V, VI, VIII AND IX are organizational maintenance. Class VII damage of 1.5 inches in diameter or less is organizational maintenance, over 1.5 inches in diameter is intermediate maintenance. Classes I, II, III, IV, V, VI, VII, VIII and IX may be repaired per the procedures referenced below:

a. Repair class I damage (A1-F18AC-SRM-250, WP012 00).

b. Repair class II damage (A1-F18AC-SRM-250, WP013 00).

c. Repair class III damage (A1-F18AC-SRM-250, WP014 00).

d. Repair class IV damage (A1-F18AC-SRM-250, WP015 00).

e. Repair class V damage (A1-F18AC-SRM-250, WP016 00).

f. Repair class VI damage (A1-F18AC-SRM-250, WP017 00). Select Patch for class VI damage per paragraph 15.

g. Repair class VII damage (A1-F18AC-SRM-250, WP018 00). Select Patch for class VII damage per paragraph 15.

h. Repair class VIII damage (A1-F18AC-SRM-250, WP005 00).

i. Repair class IX damage (A1-F18AC-SRM-250, WP019 00).

15. **Patch Selection.** Use table 1 to select applicable patch. Use EA9321 A/B or FM300 adhesive. Repairs occurring in zone C require a depot engineering disposition, see figure 4.

16. **DAMAGE EVALUATION, METAL SKIN AND STRUCTURE.** See figure 1.

17. Damage is classified as negligible and repairable. The types of materials used are shown on figure 1. Repair zones are shown on figure 5. Allowable damage limits within repair zones are listed in table 2. Damage not listed or exceeding the following limits require a depot engineering disposition.

18. **NEGLECTIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. Preventive maintenance for temporary corrosion arrestment should be done to scratches (NAVAIR 01-1A-509). The type and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

19. **REPAIRABLE DAMAGE.** Damage requires a depot engineering disposition.

20. **REPAIRS.** Repairs require an depot engineering disposition.

Table 1. Patch Selection for Class VI and VII Damage





Damage Size (Diameter, Inch)	Graphite Epoxy Patch		Titanium Patch	
	 No.	Dia.	 No.	Dia.
0.00 to 0.25	-1001	2.75	-2001	2.75
0.25 to 1.50	-1007	4.00	-2005	4.00
1.50 to 2.75	-1009	5.25	-2007 -2009	5.25
NOTE  Dash number of 74K000002 kit.  Dash number of 74K000003 kit.				

Table 2. Negligible Damage Limits







Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Skin (Outer) Zone A4	0.040	0.0006	0.0006	100%	0.020	10%
Fig 1 (2)	Beam Zone A4	0.040	0.0006	0.0006	100%	0.020	10%
Fig 1 (3)	Rib Zone A4	0.032	0.0006	0.0006	100%	0.016	10%
Fig 1 (4)	Rib Zone A4	0.050	0.010	0.010	100%	0.025	10%
Fig 1 (5)	Plate Zone A4	0.125	0.025	0.025	100%	0.070	N/A
Fig 1 (6)	Rib Zone A4	0.025	0.005	0.005	100%	0.012	10%
Fig 1 (7)	Rib Zone A4	0.050	0.010	0.010	100%	0.025	10%
Fig 1 (9)	Intercostal Zone A4	0.032	0.0006	0.0006	100%	0.016	10%
Fig 1 (12)	Rib Zone A4	0.032	0.0006	0.0006	100%	0.016	10%
Fig 1 (13)	Rib Zone A4	0.040	0.0006	0.0006	100%	0.020	10%
Fig 1 (16)	Hinge Zone A4	1.50	0.0006	0.0006	100%		
Fig 1 (17)	Beam Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (18)	Hinge Zone A4	1.00	0.0006	0.0006	100%		
Fig 1 (20)	Intercostal Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (20)	Hinge Zone A4	1.00	0.0008	0.0008	100%		

Table 2. Negligible Damage Limits (Continued)















Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (23)	Rib Zone A4	Pressing	0.0006	0.0006	100%		
Fig 1 (18)	Skin Zone A4	0.025	0.0006	0.0006	100%	0.012	10%
		0.040	0.0006	0.0006	100%	0.012	10%
Fig 1 (19)	Support Zone A4	1.00	0.0006	0.0006	100%		
Fig 1 (29)	Arm Zone A4	3.75	0.0006	0.0006	100%		
Fig 1 (21)	Skin Zone A4	0.125	0.0006	0.0006	100%	0.020	10%
		0.040	0.0006	0.0006	100%	0.020	10%
Fig 1 (31)	Beam Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (32)	Rib Zone A4	0.025	0.0006	0.0006	100%	0.012	10%
Fig 1 (33)	Rib Zone A4	0.025	0.005	0.005	100%	0.012	10%
Fig 1 (34)	Rib Zone A4	0.025	0.0006	0.0006	100%	0.012	10%
Fig 1 (35)	Rib Zone A4	0.040	0.0006	0.0006	100%	0.020	10%
Fig 1 (37)	Intercostal Zone A4	0.032	0.0064	0.0064	100%	0.016	10%
Fig 1 (38)	Hinge Zone A4	2.00	0.0006	0.0006	100%		
Fig 1 (40)	Beam Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (41)	Intercostal Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (43)	Hinge Zone A4	1.50	0.0006	0.0006	100%		

Table 2. Negligible Damage Limits (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (44)	Rib Zone A4	0.040	0.008	0.008	100%	0.020	10%
Fig 1 (51)	Skin (Inner) Zone A4	0.025	0.0006	0.0006	100%	0.012	10%
		0.032	0.0006	0.0006	100%	0.012	10%
Fig 1 (36)	Support Zone A4	1.00	0.0006	0.0006	100%		
Fig 1 (56)	Bracket Zone A4	0.071	0.0006	0.0006	100%	0.020	N/A
Fig 1 (58)	Bracket Zone A4	0.071	0.0006	0.0006	100%	0.020	N/A
Fig 1 (63)	Bracket Zone A4	0.071	0.0006	0.0006	100%	0.020	N/A
Fig 1 (65)	Louver Zone A4	Casting	0.0006	0.0006	100%		N/A
Fig 1 (56)	Fairing Zone A4	1.00	0.0006	0.0006	100%	0.016	N/A
NOTE							
 None allowed.							

21. REPLACEMENT.**22. NLG LEFT FORWARD DOOR (74A460700).**

Door is replaceable and requires trimming. Door is spared with 0.250 inch excess material on forward and aft edge of part. See figure 6, detail A.

Support Equipment Required

None

Materials Required

None

a. Temporarily install door (A1-F18AC-130-300, WP028 00).

b. Manually rotate door to closed position.

c. Locate trim line to clearances specified on figure 6, detail D. For locating trim line (A1-F18AC-SRM-200, WP004 03).

d. Trim door.

e. Apply finish system as required (A1-F18AC-SRM-500, WP042 00).

f. Install door (A1-F18AC-130-300, WP028 00).

23. NLG RIGHT FORWARD DOOR (74A460800).

Door is replaceable and requires trimming. Door is spared with 0.250 inch excess material on forward and aft edge of part. See figure 6, detail B.

Support Equipment Required

None

Materials Required

None

- a. Temporarily install door (A1-F18AC-130-300, WP029 00).
 - b. Manually rotate door to closed position.
 - c. Locate trim line to clearances specified on figure 6, detail D. For locating trim line (A1-F18AC-SRM-200, WP004 03).
 - d. Trim door.
 - e. Apply finish system as required (A1-F18AC-SRM-500, WP042 00).
 - f. Install door (A1-F18AC-130-300, WP029 00).
24. **NLG AFT DOOR (74A460900).** Door is replaceable and requires trimming. Door is spared with excess material on forward edge and edge opposite hinge. See figure 6, detail C.

Support Equipment Required

None

Materials Required

None

- a. Temporarily install door (A1-F18AC-130-300, WP030 00).
 - b. Manually rotate door to closed position.
 - c. Locate trim line to clearances specified on figure 6, detail D. For locating trim line (A1-F18AC-SRM-200, WP004 03).
 - d. Trim door. For trimming of composites (A1-F18AC-SRM-200, WP004 08).
 - e. Apply finish system as required (A1-F18AC-SRM-500, WP042 00).
 - f. Install door (A1-F18AC-130-300, WP030 00).
25. **NLG DRAG BRACE FAIRING (74A461009).** (A1-F18AC-130-300, WP031 00).
26. **PLATE, 74A460820.** Fastener attaching hardware is shown on figure 7. For fasteners (A1-F18AC-SRM-420, FIG022 00).

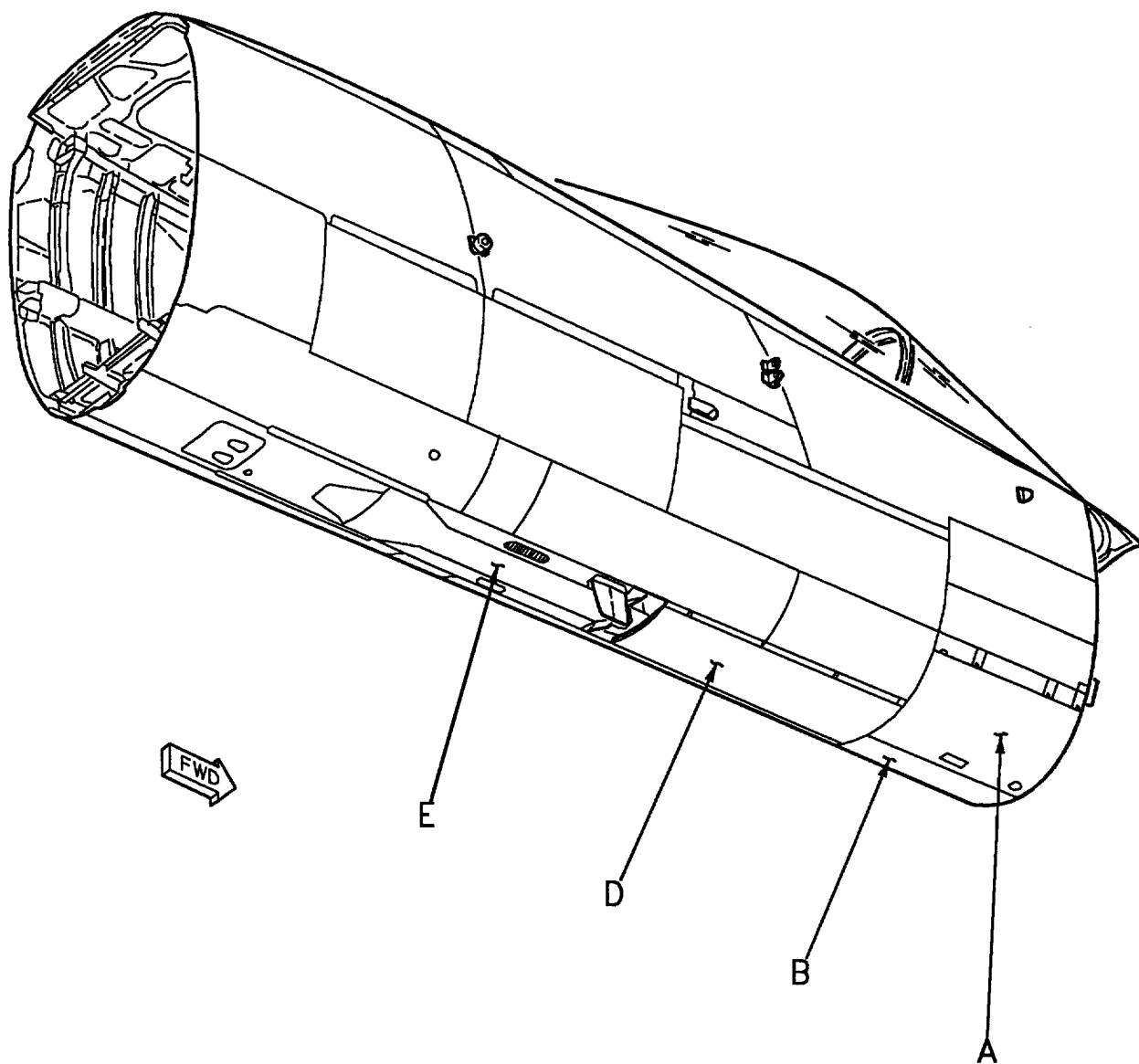
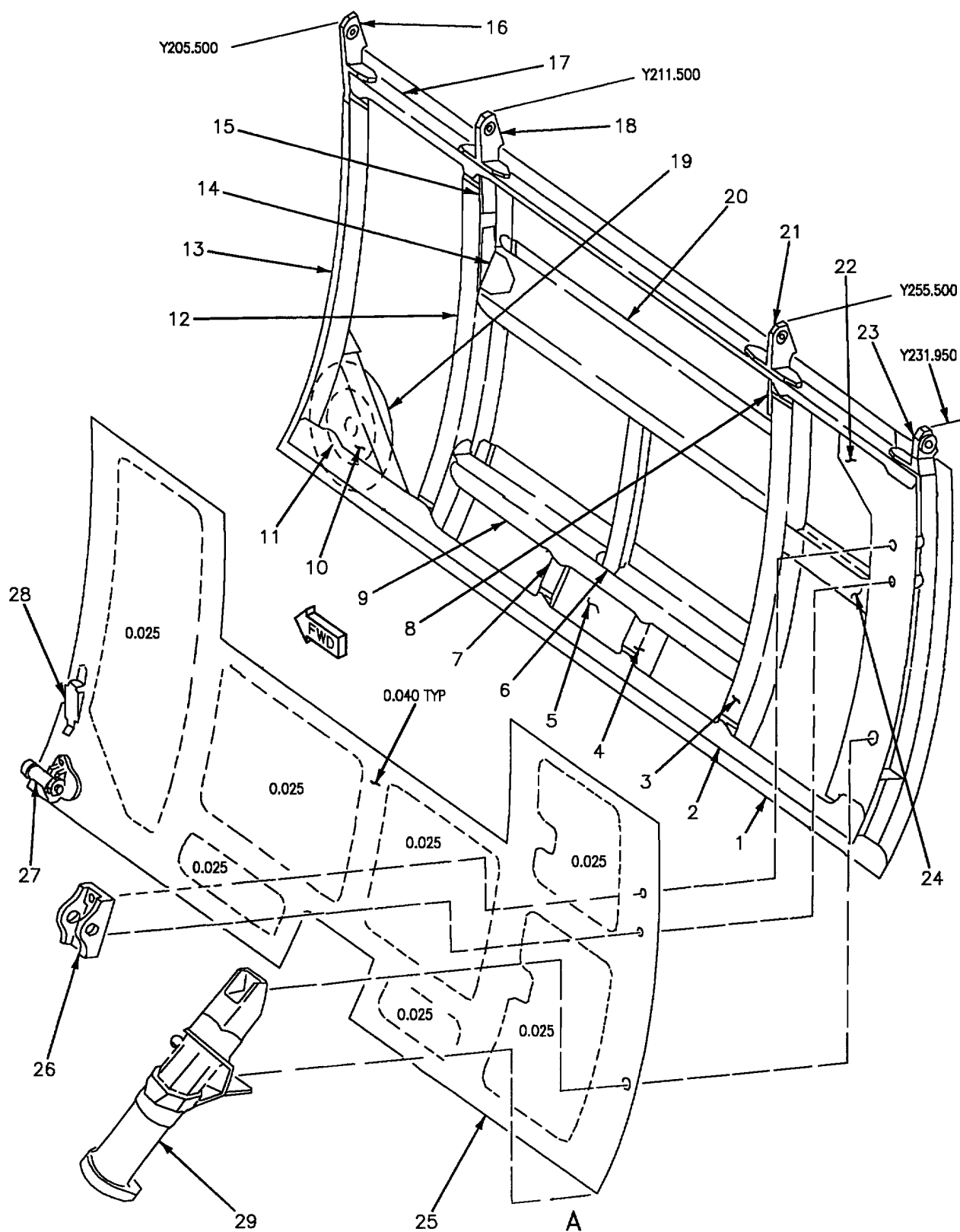


Figure 1. Material Index (Sheet 1)



18AC-SRM-222-(101-2)01-SCAN

Figure 1. Material Index (Sheet 2)

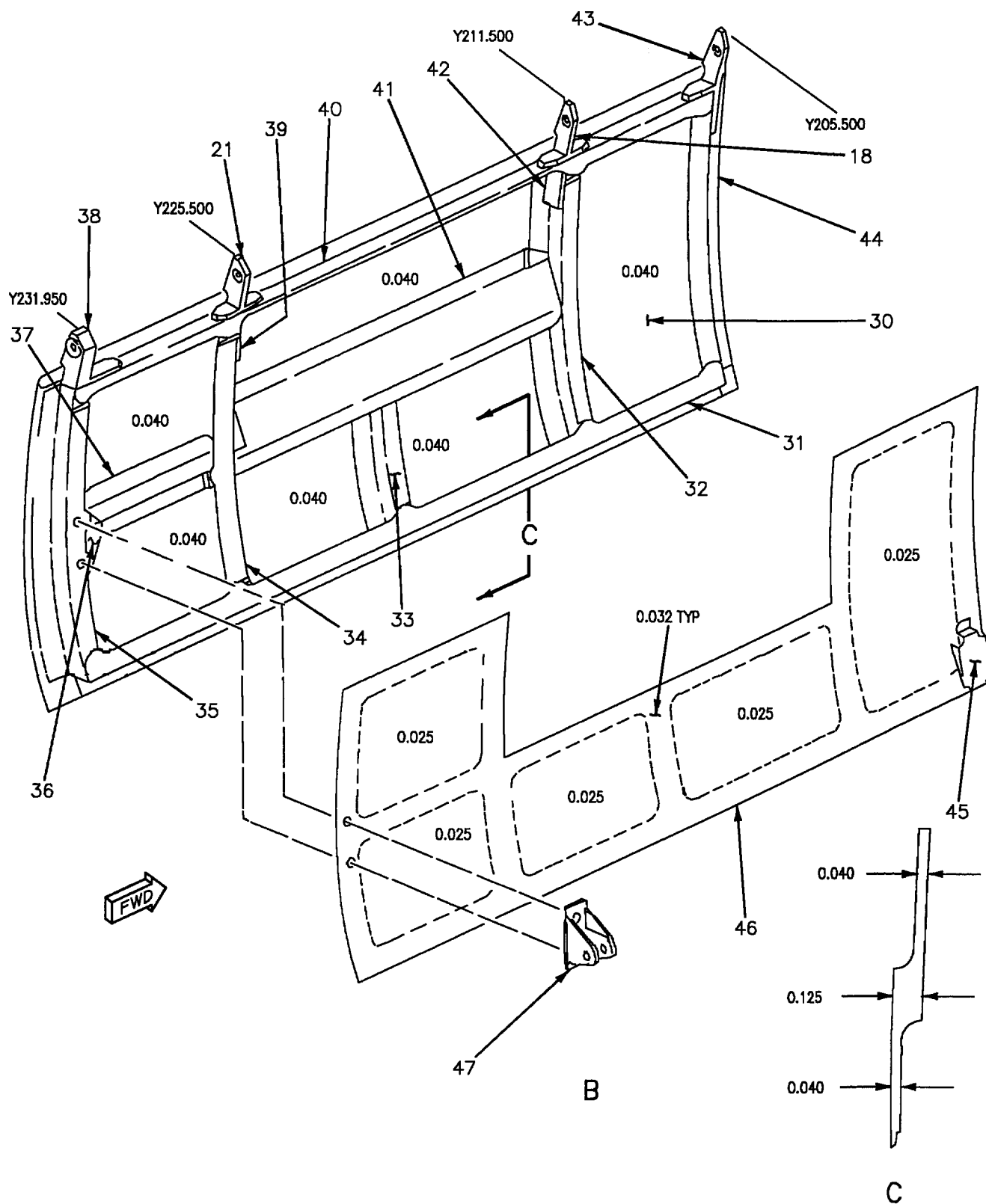


Figure 1. Material Index (Sheet 3)

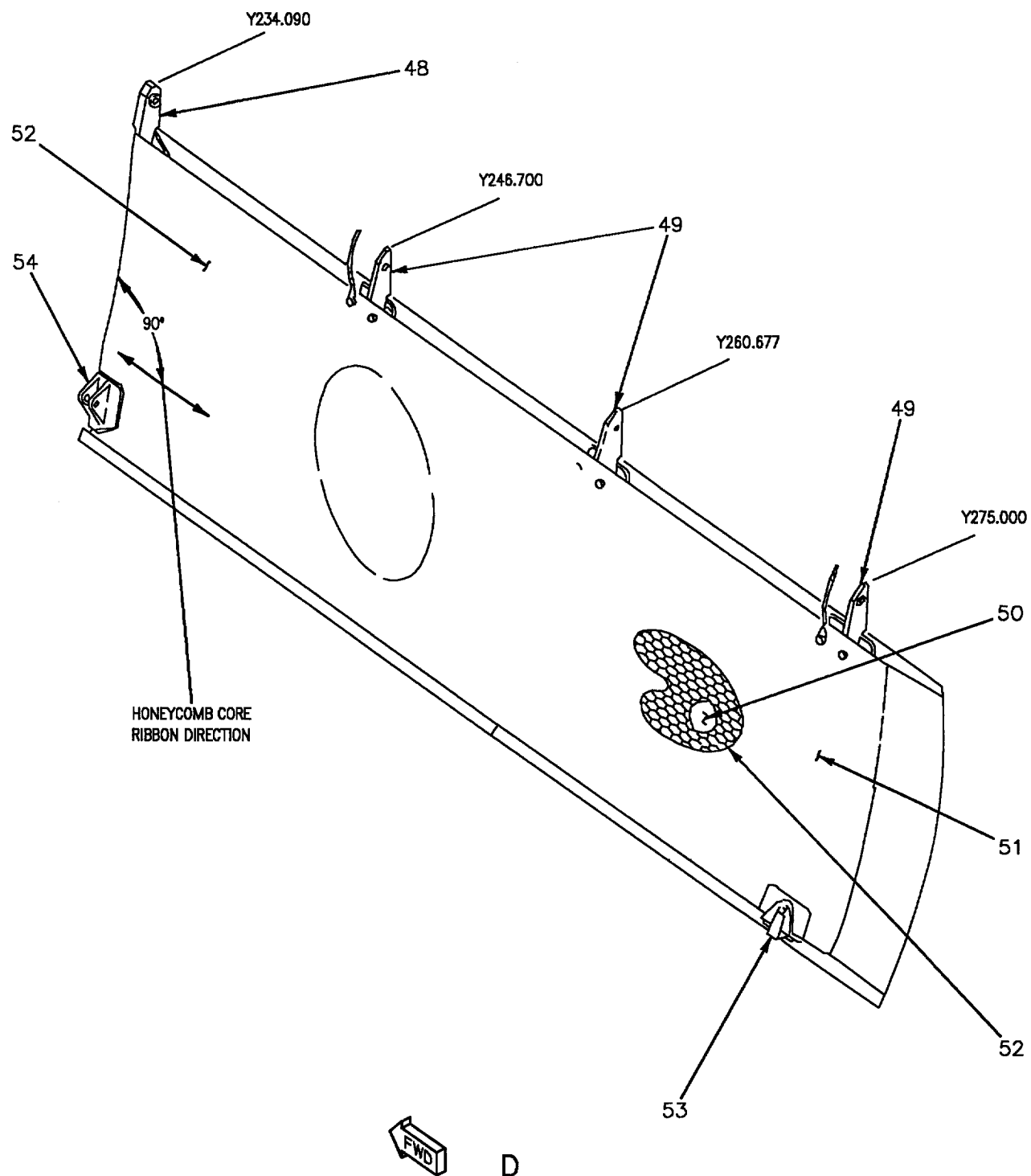


Figure 1. Material Index (Sheet 4)

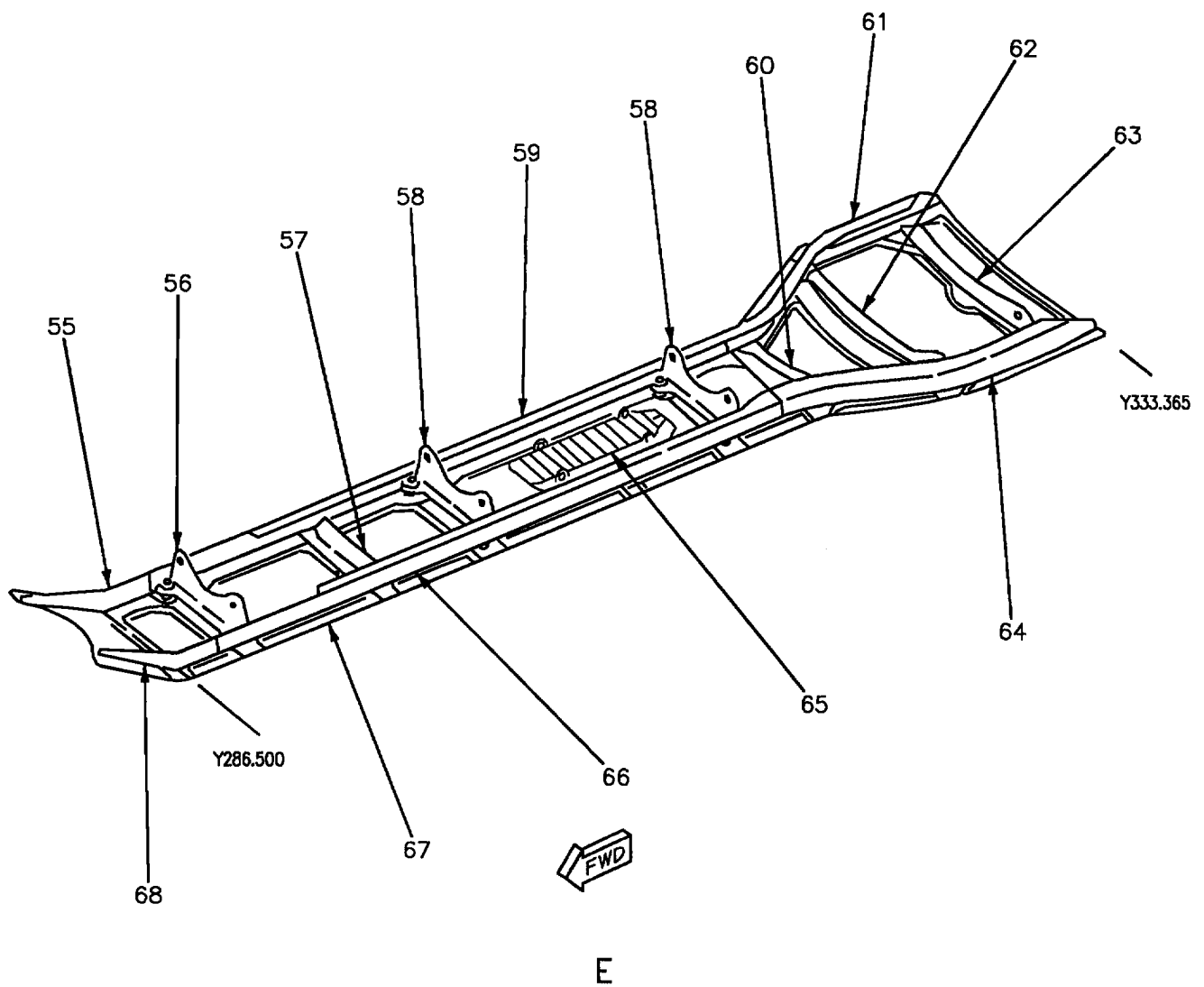


Figure 1. Material Index (Sheet 5)




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1		Skin (Outer) 74A460800-2067	0.040 Sheet	7075-T6 Alclad
2		Beam 74A460800-2013	0.040 Sheet	7075-T6 Alclad
3		Rib 74A460800-2011	0.032 Sheet	7075-T6 Alclad
4		Rib 74A460800-2025	0.050 Sheet	7075-T6 Alclad
5		Plate  5 74A460820-2001	0.125 Sheet	7075-T76 Alclad
6		Rib 74A460800-2027	0.025 Sheet	7075-T6 Alclad
7		Rib 74A460800-2023	0.050 Sheet	7075-T6 Alclad
8		Support 74A460814-2002	2.00 Plate	7075-T7351 Al Aly
9		Intercostal 74A460800-2019	0.032 Sheet	7075-T6 Alclad
10		Angle 74A460800-2021	0.040 Sheet	7075-T6 Alclad
11		Cover 9M789-181-4	0.040 Sheet	7075-T6 Alclad
12		Rib 74A460800-2009	0.032 Sheet	7075-T6 Alclad
13		Rib 74A460800-2007	0.040 Sheet	7075-T6 Alclad
14		Angle 74A460800-2031	0.040 Sheet	7075-T6 Alclad
15		Support 74A460813-2002	2.00 Plate	7075-T7351 Al Aly
16	 8  9	Hinge 74A460805-2004 74A460805-2006	1.50 Plate	7075-T7351 Al Aly
17		Beam 74A460800-2015	0.040 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 6)





IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
18	 	Hinge 74A460809-2003 74A460809-2005	1.00 Plate	7075-T7351 Al Aly
19		Doubler 74A460800-2041	0.040 Sheet	7075-T6 Alclad
20		Intercostal 74A460800-2017	0.040 Sheet	7075-T6 Alclad
21		Hinge 74A460810-2001	1.00 Plate	7076-T7351 Al Aly
22		Doubler 74A460800-2037	0.040 Sheet	7076-T6 Alclad
23		Rib 74A460811-2009	Pressing	7075-T73 Al Aly
24		Intercostal 74A460816-2001	Pressing	7075-T73 Al Aly
25		Skin (Inner) 74A460800-2061	 Sheet	7075-T6 Alclad
26		Support 74A460804-2003	1.00 Plate	7075-T7351 Al Aly
27		Support 74A460806-2001	Casting	A356-T61 Al Aly
28		Hardpoint 74A460800-2049	0.063 Sheet	7075-T6 Alclad
29		Arm 74A460815-2001	3.75 Plate	7075-T7351 Al Aly
30		Skin (Outer) 74A460700-2033		7075-T76 Alclad
31		Beam 74A460700-2013	0.040 Sheet	7075-T6 Alclad
32		Rib 74A460700-2009	0.025 Sheet	7075-T6 Alclad
33		Rib 74A460700-2021	0.025 Sheet	7075-T6 Alclad
34		Rib 74A460700-2011	0.025 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
35		Rib 74A460700-2037	0.040 Sheet	7075-T6 Alclad
36		Support 74A460706-2001	Pressing	7075-T73 Al Aly
37		Intercostal 74A460700-2039	0.032 Sheet	7075-T6 Alclad
38		Hinge 74A460705-2001	2.00 Plate	7075-T7351 Al Aly
39		Support 74A460814-2001	2.00 Plate	7075-T7351 Al Aly
40		Beam 74A460700-2015	0.040 Sheet	7076-T6 Alclad
41		Intercostal 74A460700-2017	0.040 Sheet	7075-T6 Alclad
42		Support 74A460813-2001	2.00 Plate	7075-T7351 Al Aly
43	8 9	Hinge 74A460805-2003 74A460806-2005	1.50 Plate	7075-T7351 Al Aly
44		Rib 74A460700-2007	0.040 Sheet	7075-T6 Alclad
45		Hardpoint 74A460700-2029	0.050 Sheet	7075-T6 Alclad
46		Skin (Inner) 74A460700-2035	7 Sheet	7075-T6 Alclad
47		Support 74A460704-2001	1.00 Plate	7075-T7351 Al Aly
48		Hinge 74A460905-2001	Pressing	7075-T73 Al Aly
49		Hinge 74A460902-2003	1.50 Plate	7075-T7351
50		Skin (Outer) 74A460910-2001	2 Sheet	Graphite/Epoxy Laminate
51		Skin (Inner) 74A460911-2003	2 Sheet	Graphite/Epoxy Laminate

Figure 1. Material Index (Sheet 8)

















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
52		Flexcore 74A460912-2003	1.46 Thick Hex Cell	5056/F40 Al Honeycomb
53		Bumper 74A460906-2003	Casting	A356-T61 Al Aly
54		Bracket 74A460913-2001	1.50 Plate	7075-T7351 Al Aly
55	 	Angle 74A461009-2004 74A461009-2034	0.032 Sheet	7075-T6 Alclad
56		Bracket 74A461003-2005	0.071 Sheet	2024-T72 Alclad
57	 	Angle 74A461009-2007 74A461009-2037	0.032 Sheet	7075-T6 Alclad
58		Bracket 74A461003-2003	0.071 Sheet	2024-T72 Alclad
59	 	Channel 74A461009-2013 74A461009-2043	0.032 Sheet	7075-T6 Alclad
60	 	Angle 74A461009-2009 74A461009-2043	0.032 Sheet	7075-T6 Alclad
61	 	Channel 74A461009-2019 74A461009-2045	0.063 Sheet	7075-T6 Alclad
62	 	Angle 74A461009-2011 74A461009-2041	0.032 Sheet	7075-T6 Alclad
63		Bracket 74A461002-2003	0.071 Sheet	2024-T72 Alclad
64	 	Channel 74A461009-2027 74A461009-2047	0.032 Sheet	7075-T6 Alclad
65		Louver 74A314362-2003	Casting	A356-T61 Al Aly
66	 	Channel 74A461009-2005 74A461009-2035	0.032 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 9)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
67	<div>3</div> <div>4</div>	Fairing 74A461009-2001 74A461009-2031	1.00 Plate	7075-T76 Alclad
68	<div>3</div> <div>4</div>	Angle 74A461009-2003 74A461009-2033	0.032 Sheet	7075-T6 Alclad
LEGEND <div>1</div> The bays are 0.025 and the lands are 0.040. <div>2</div> Skin is fabricated of varying plies of graphite laminate. <div>3</div> 161353 THRU 161528. <div>4</div> 161702 AND UP. <div>5</div> Used only when antenna is removed. <div>6</div> The bays are 0.040 and the lands are 0.125. <div>7</div> The bays are 0.025 and the lands are 0.032. <div>8</div> 161353 THRU 162444. <div>9</div> 162445 AND UP.				

Figure 1. Material Index (Sheet 10)

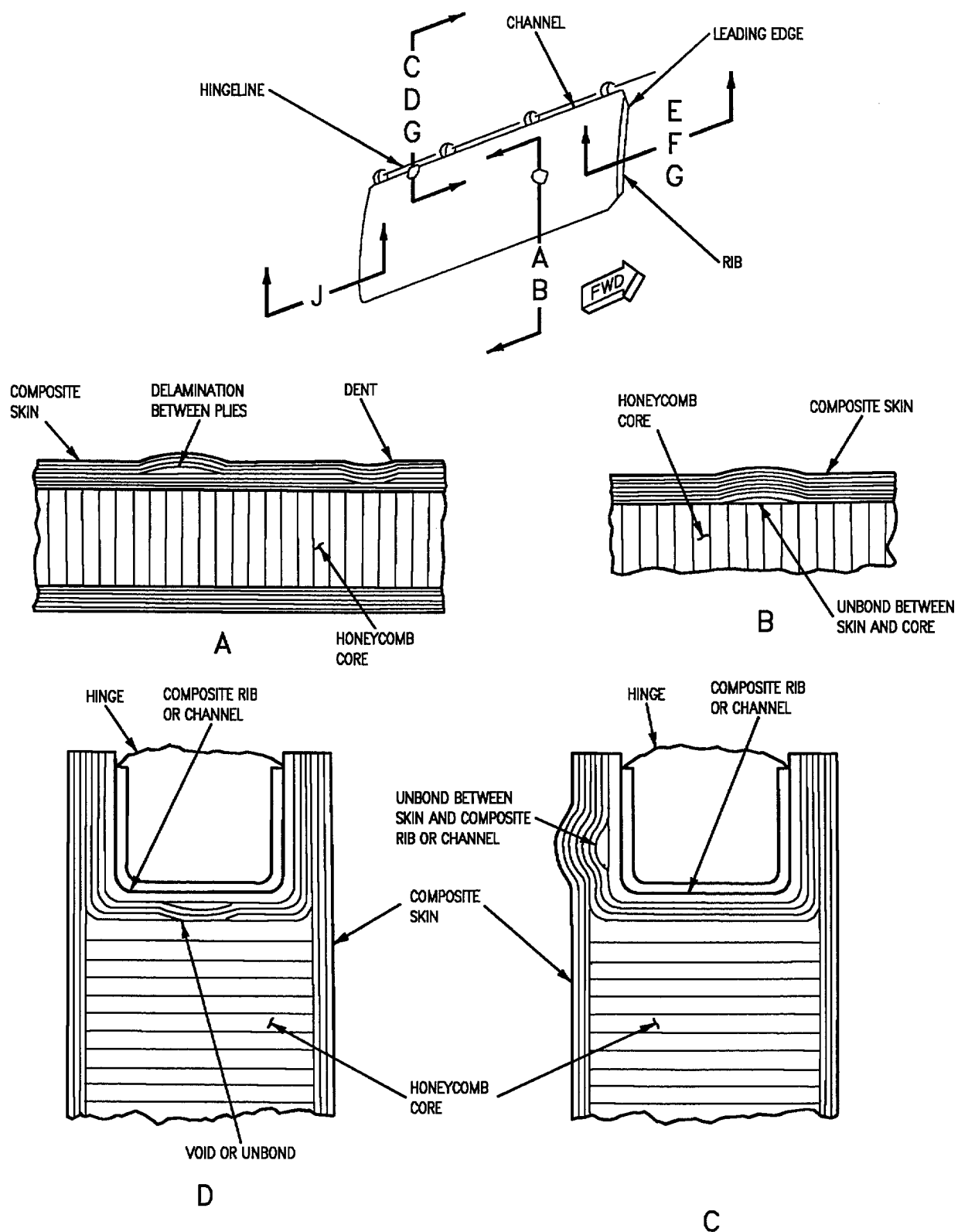


Figure 2. Negligible Damage (Sheet 1)

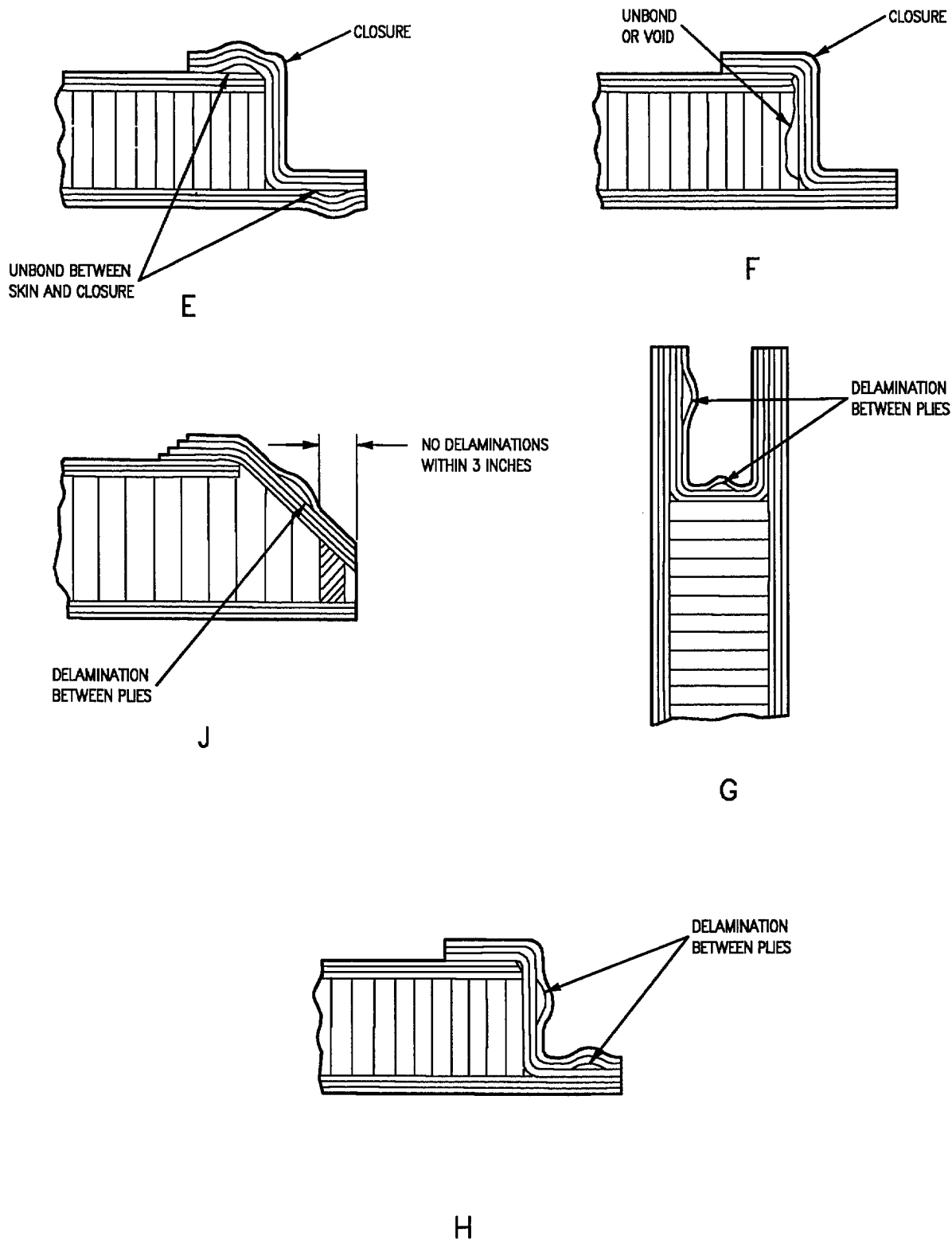
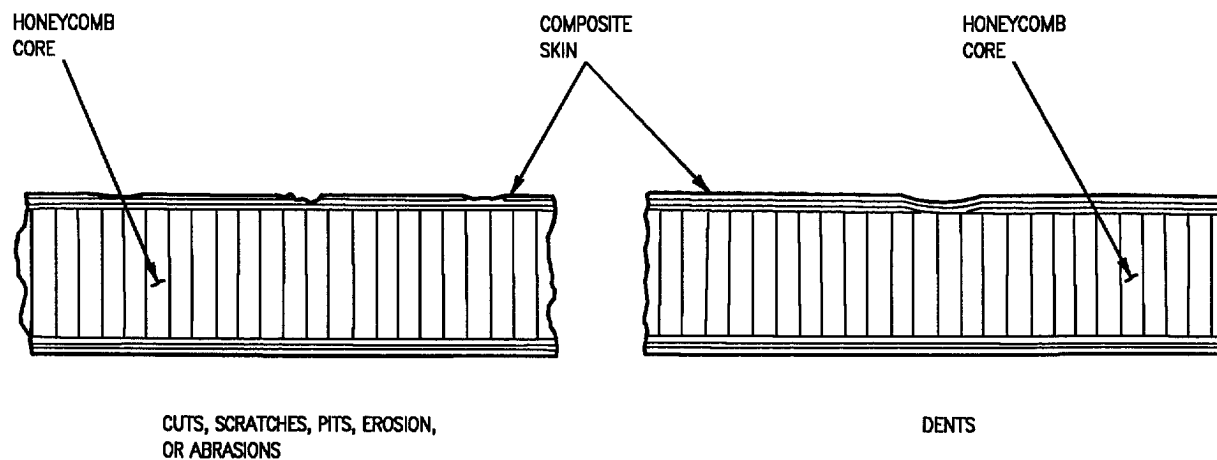
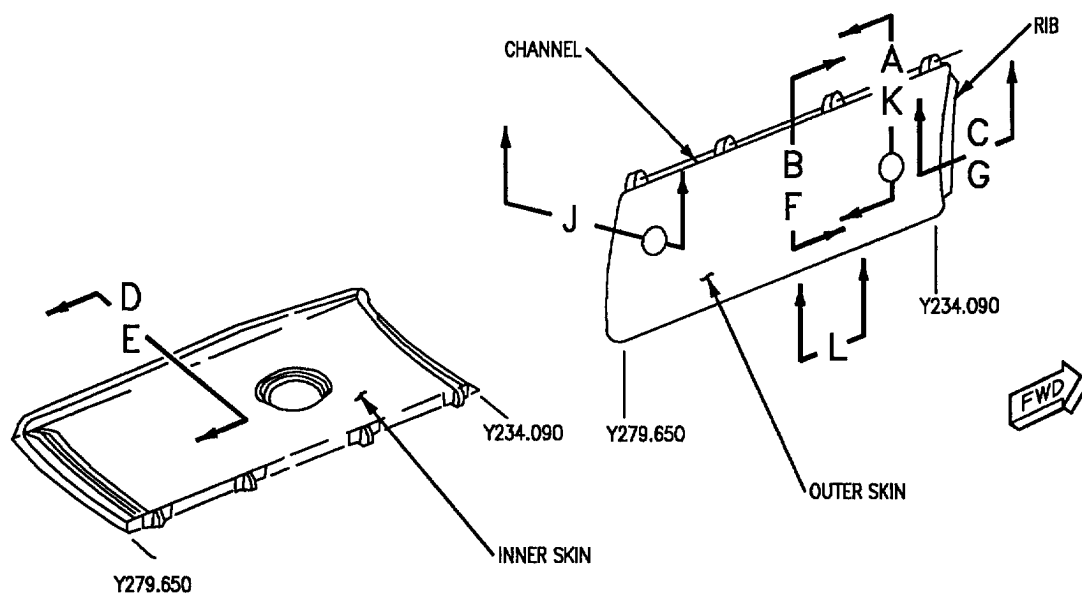
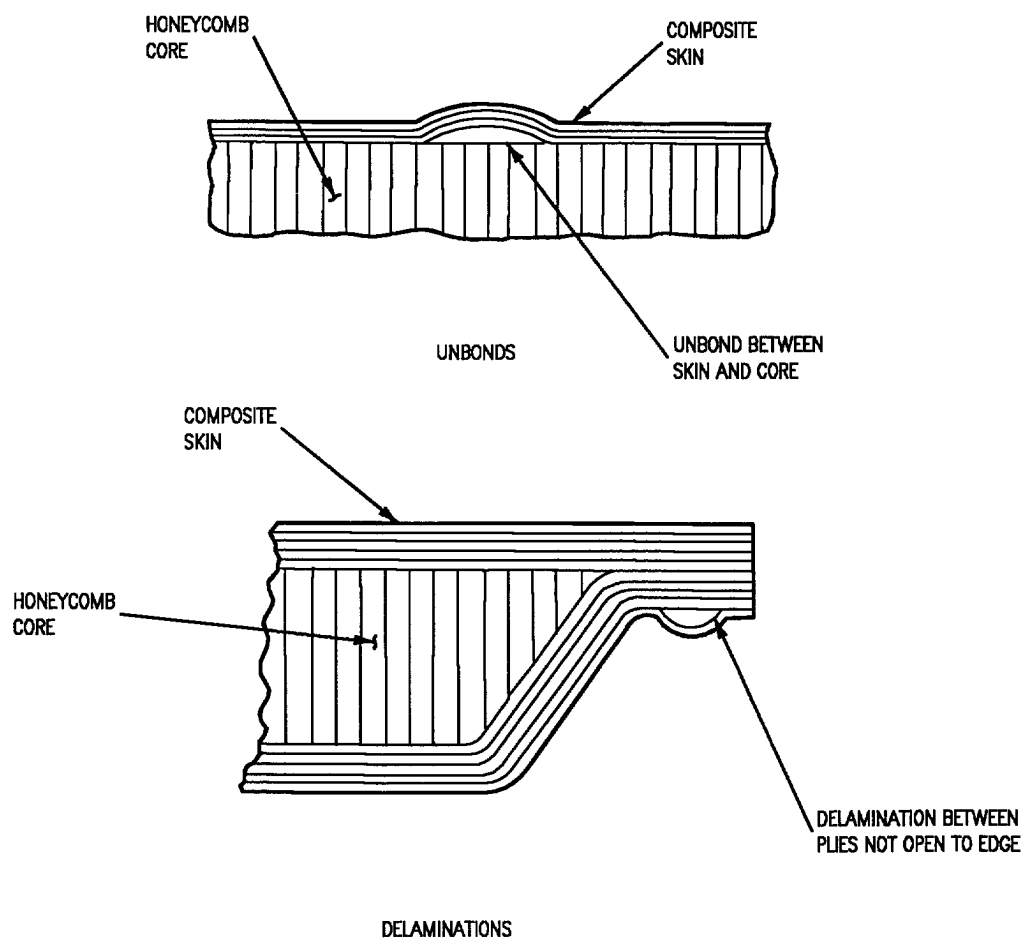
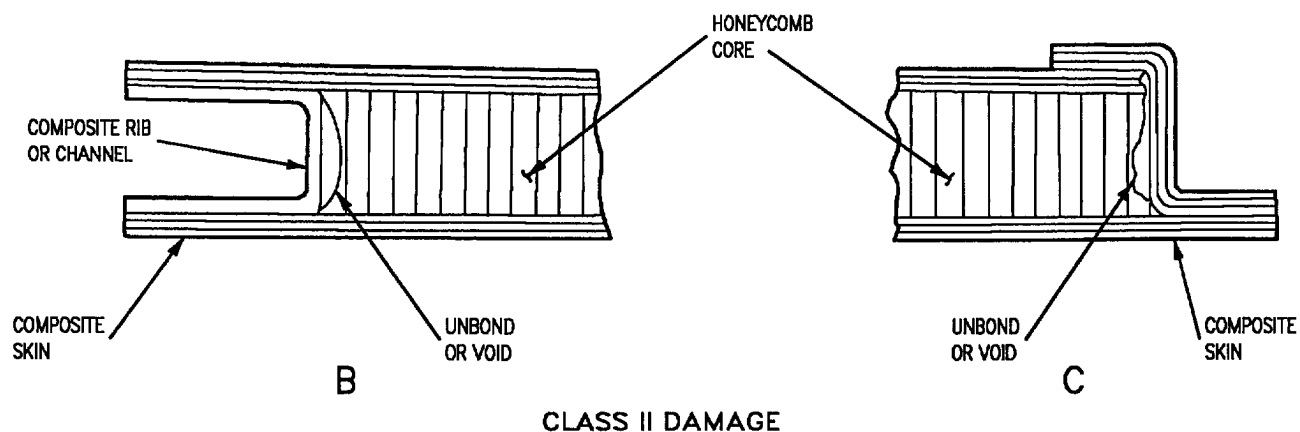


Figure 2. Negligible Damage (Sheet 2)



A
CLASS I DAMAGE

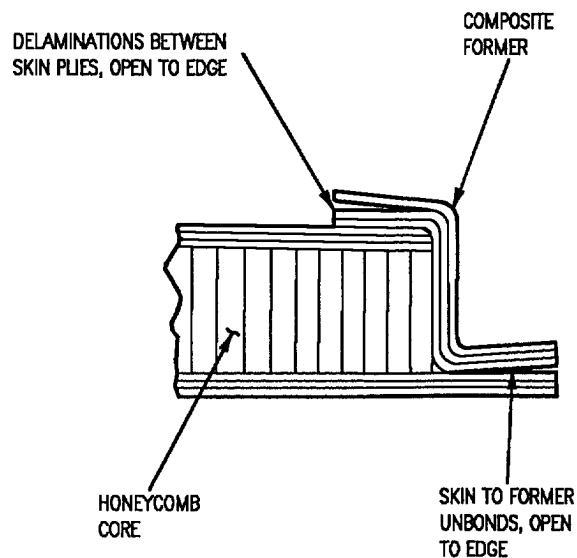
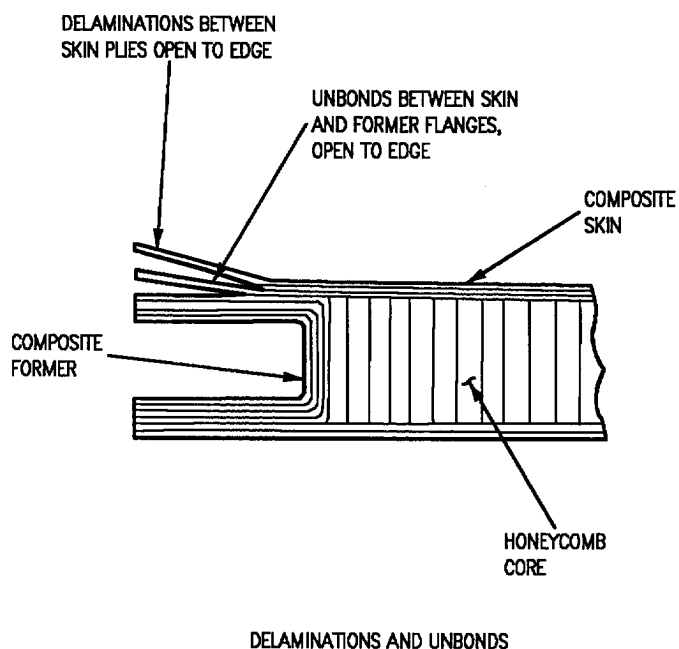
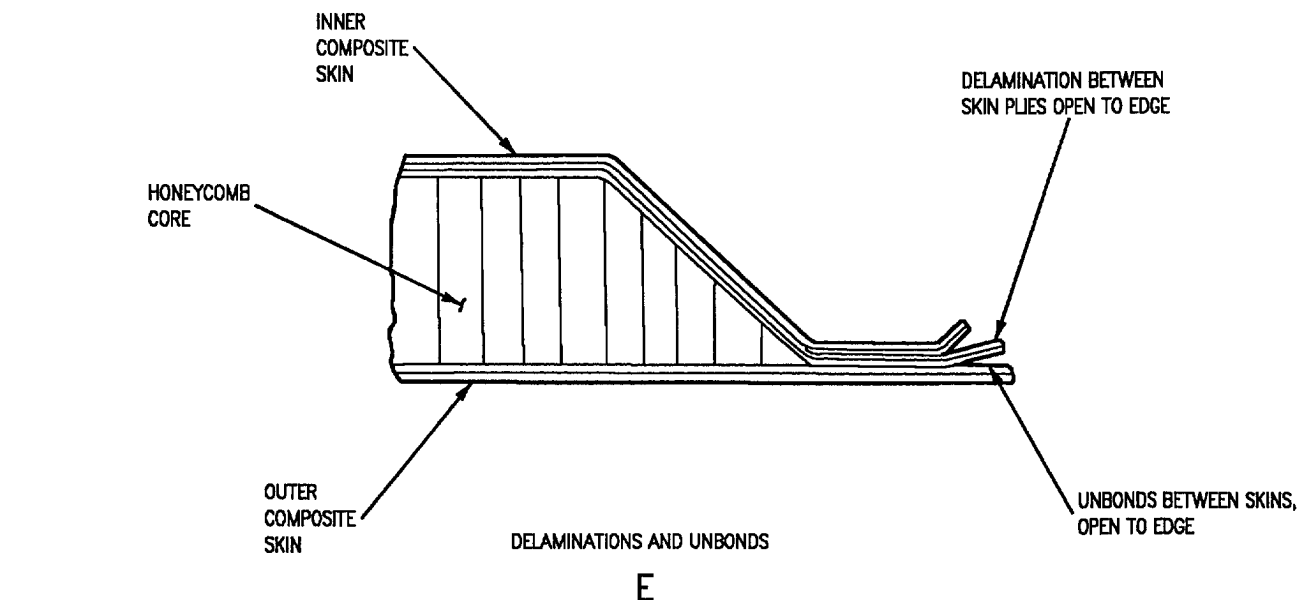
Figure 3. Repairable Damage (Sheet 1)



D

CLASS III DAMAGE

Figure 3. Repairable Damage (Sheet 2)

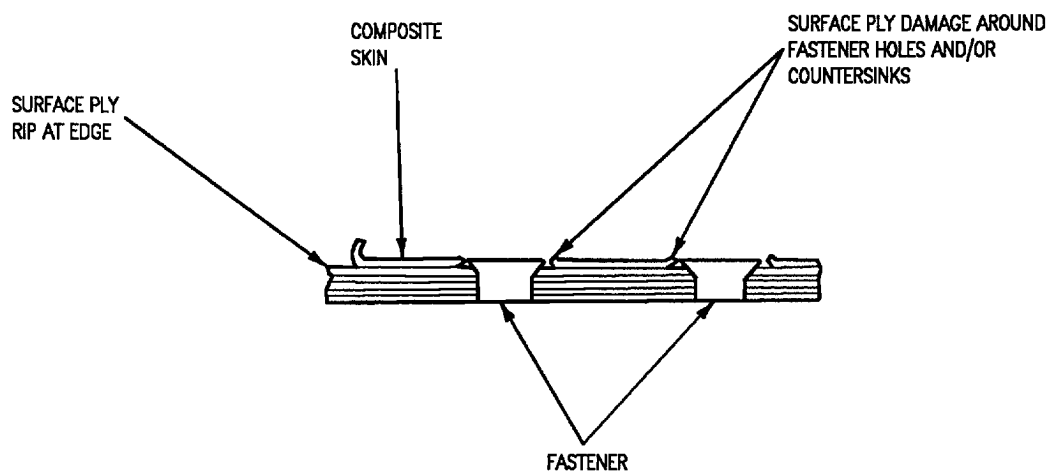


F

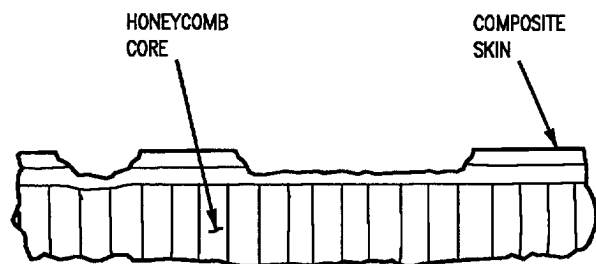
G

CLASS IV DAMAGE

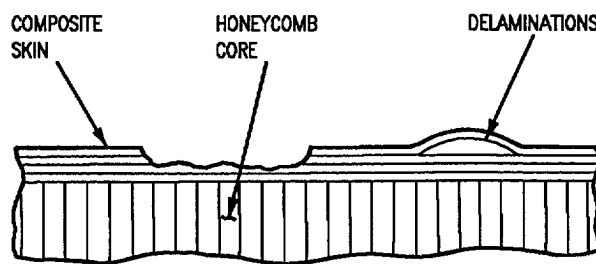
Figure 3. Repairable Damage (Sheet 3)



H
CLASS V DAMAGE



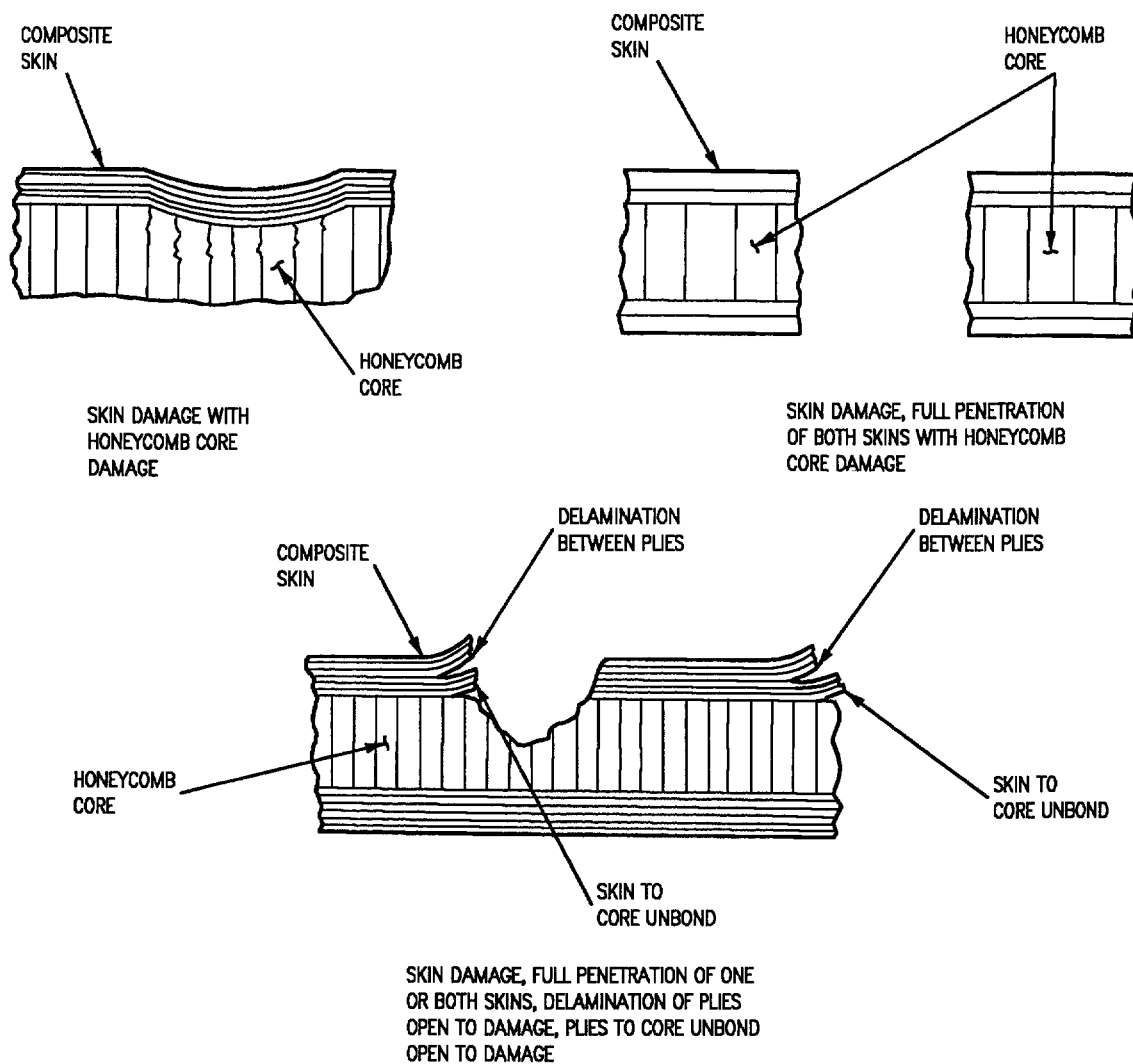
CUTS, SCRATCHES, CRACKS,
OR SKIN EROSION



CUTS, SCRATCHES, CRACKS, OR SKIN
EROSIONS AND DELAMINATIONS

J
CLASS VI DAMAGE

Figure 3. Repairable Damage (Sheet 4)



K
CLASS VII DAMAGE

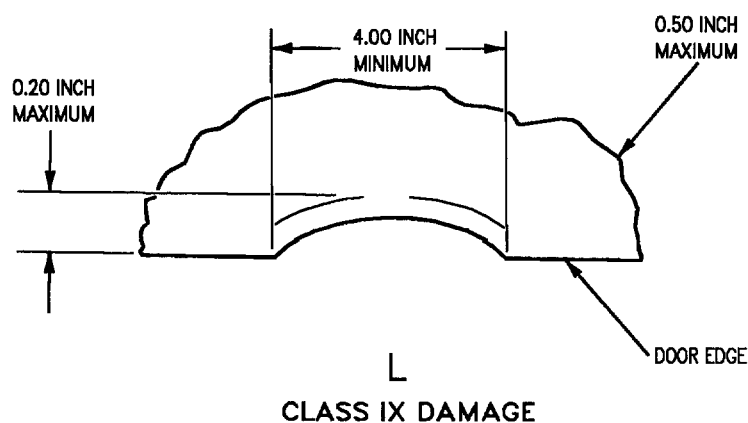
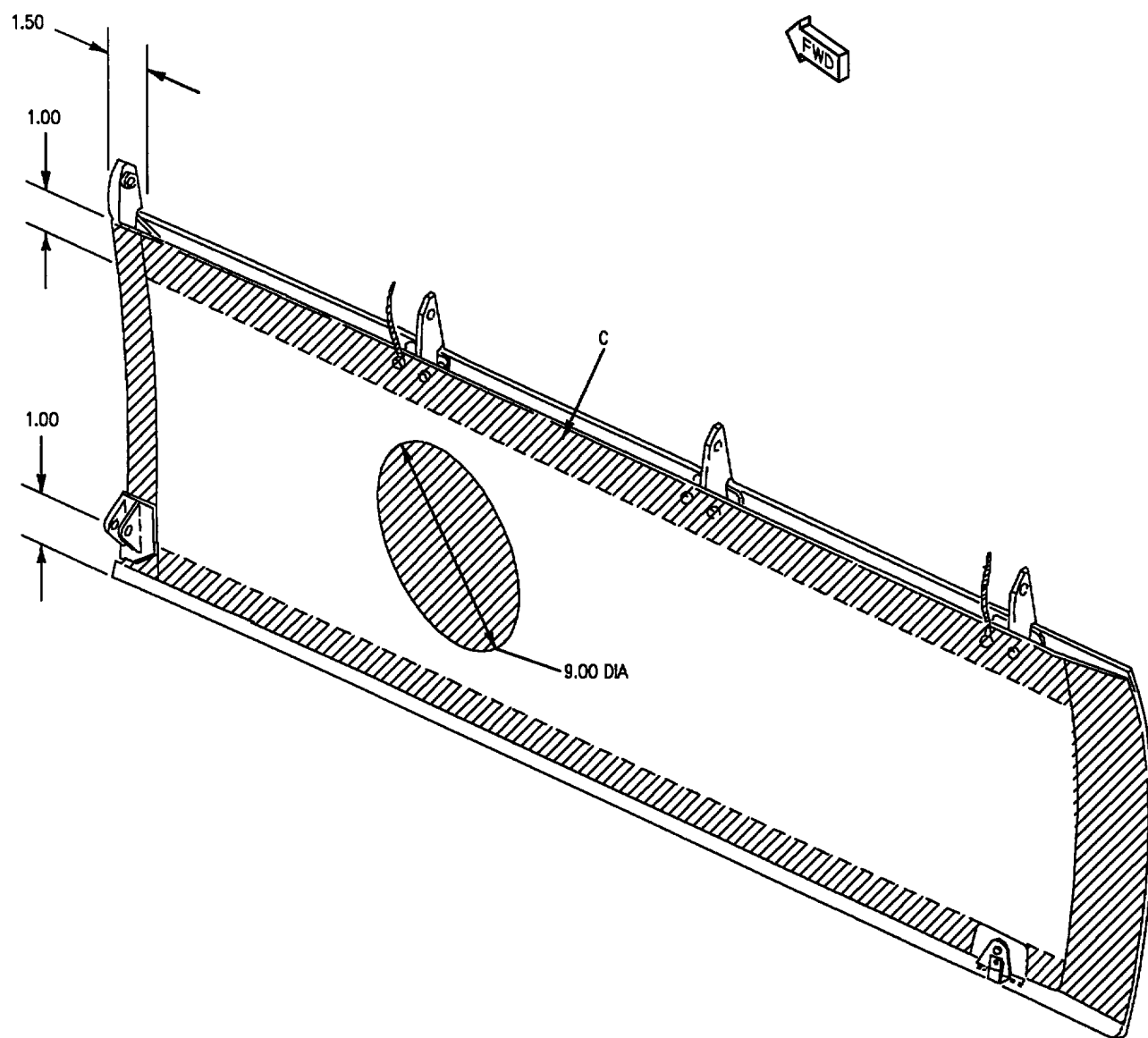


Figure 3. Repairable Damage (Sheet 5)



18AC-SRM-222-(104-1)01-SCAN

Figure 4. Repair Zones, Composite Skin and Structure

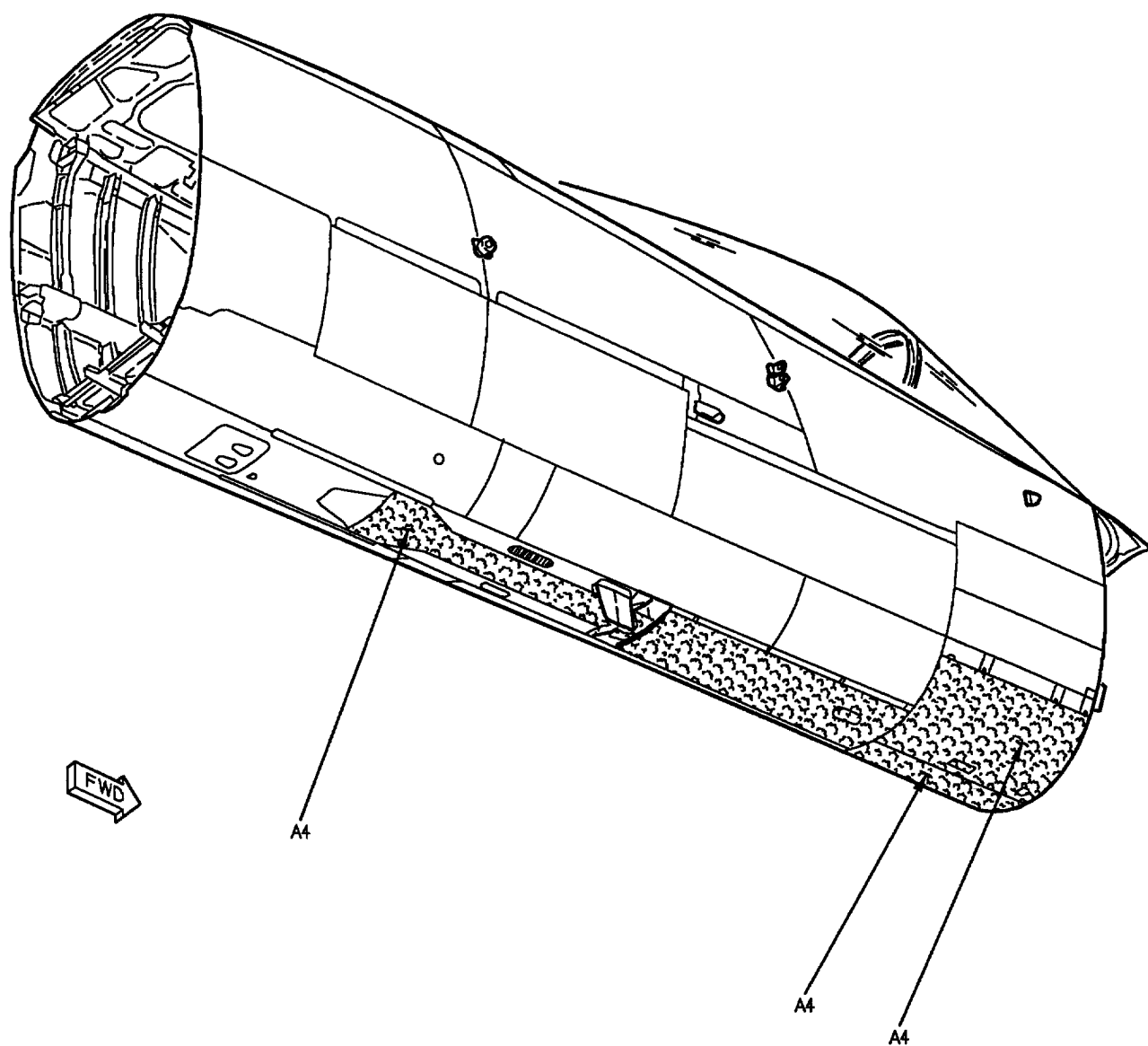


Figure 5. Repair Zones, Metal Skin and Structure

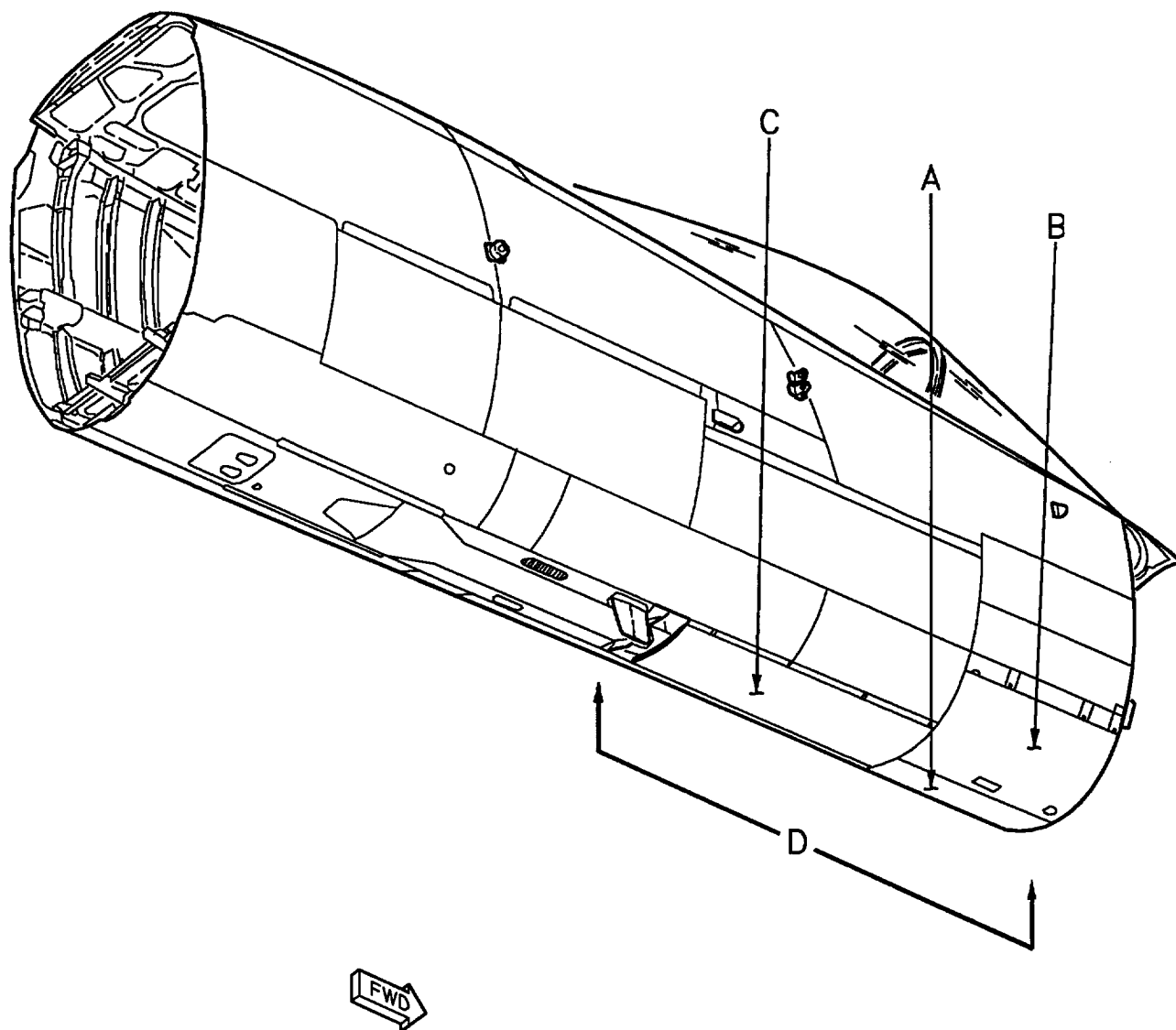
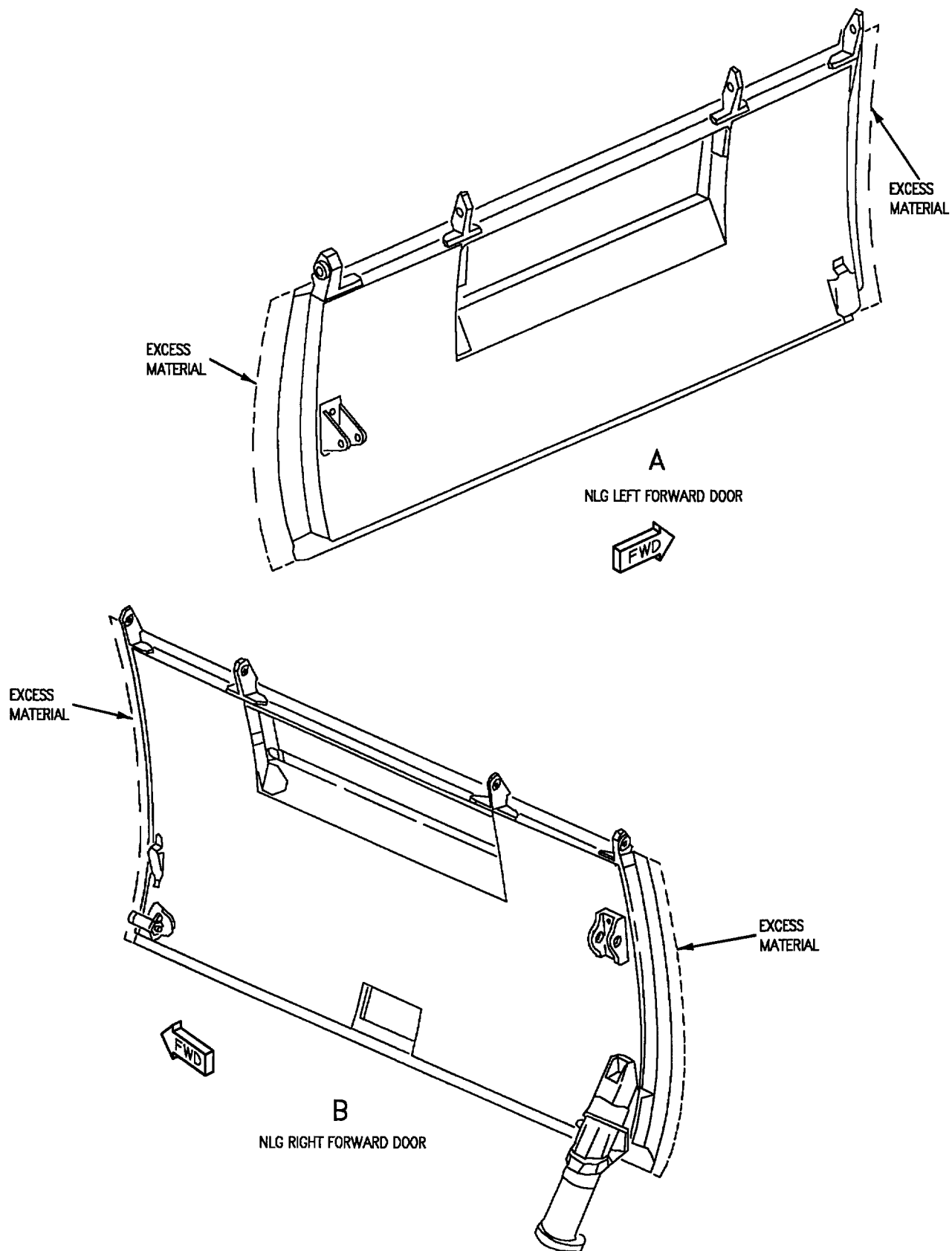


Figure 6. NLG Door Replacement (Sheet 1)



18AC-SRM-222-(106-2)01-SCAN

Figure 6. NLG Door Replacement (Sheet 2)

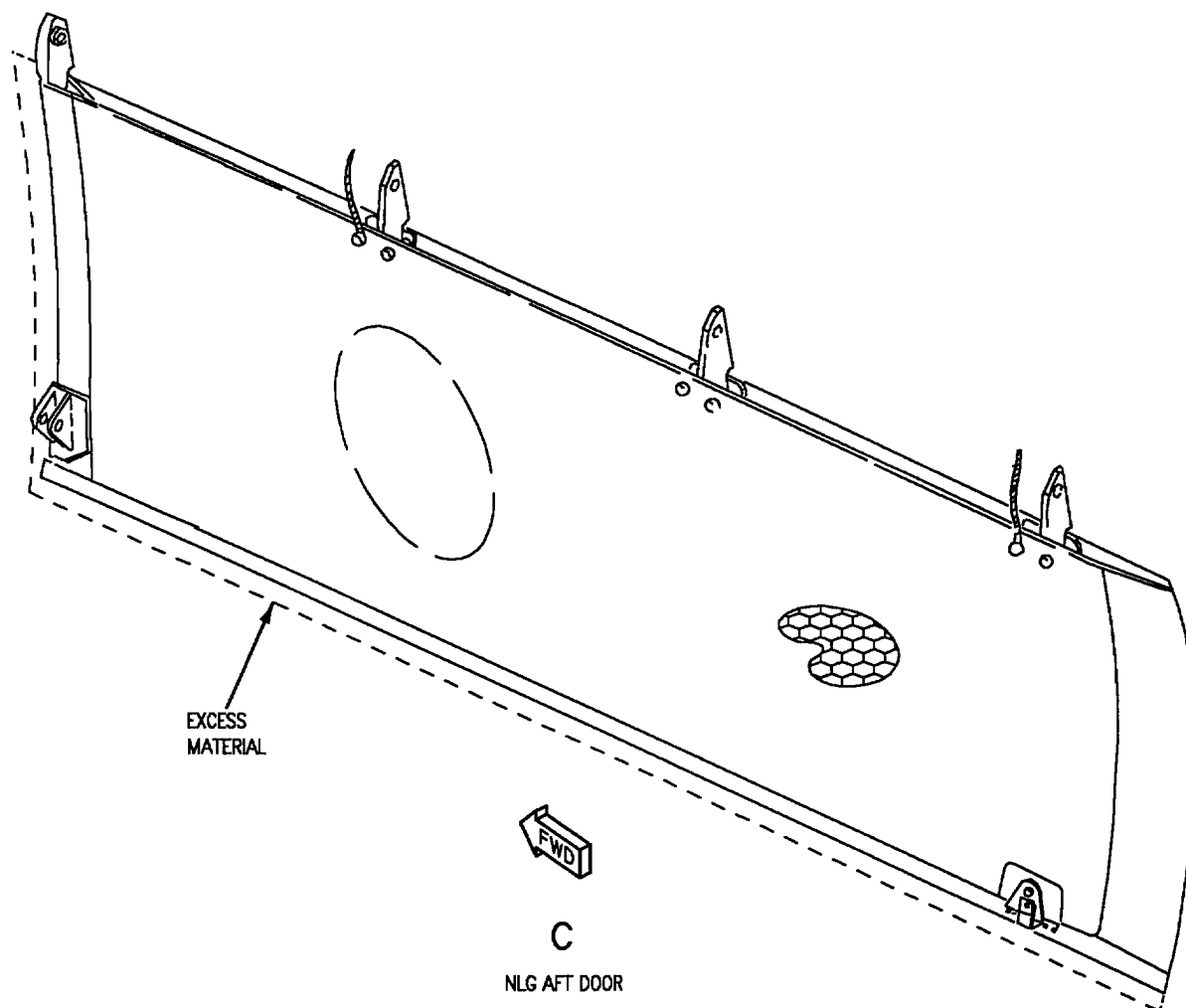


Figure 6. NLG Door Replacement (Sheet 3)

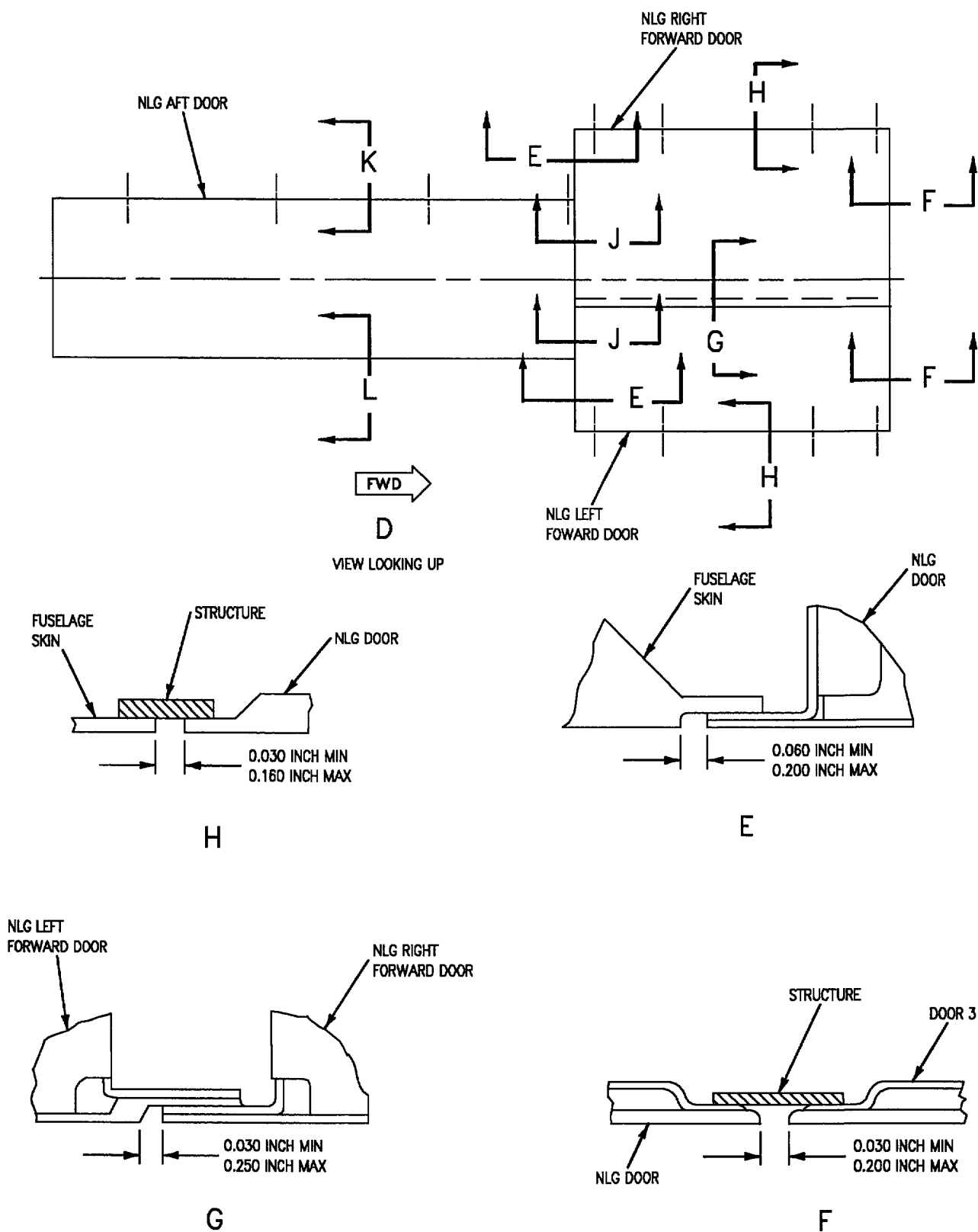


Figure 6. NLG Door Replacement (Sheet 4)

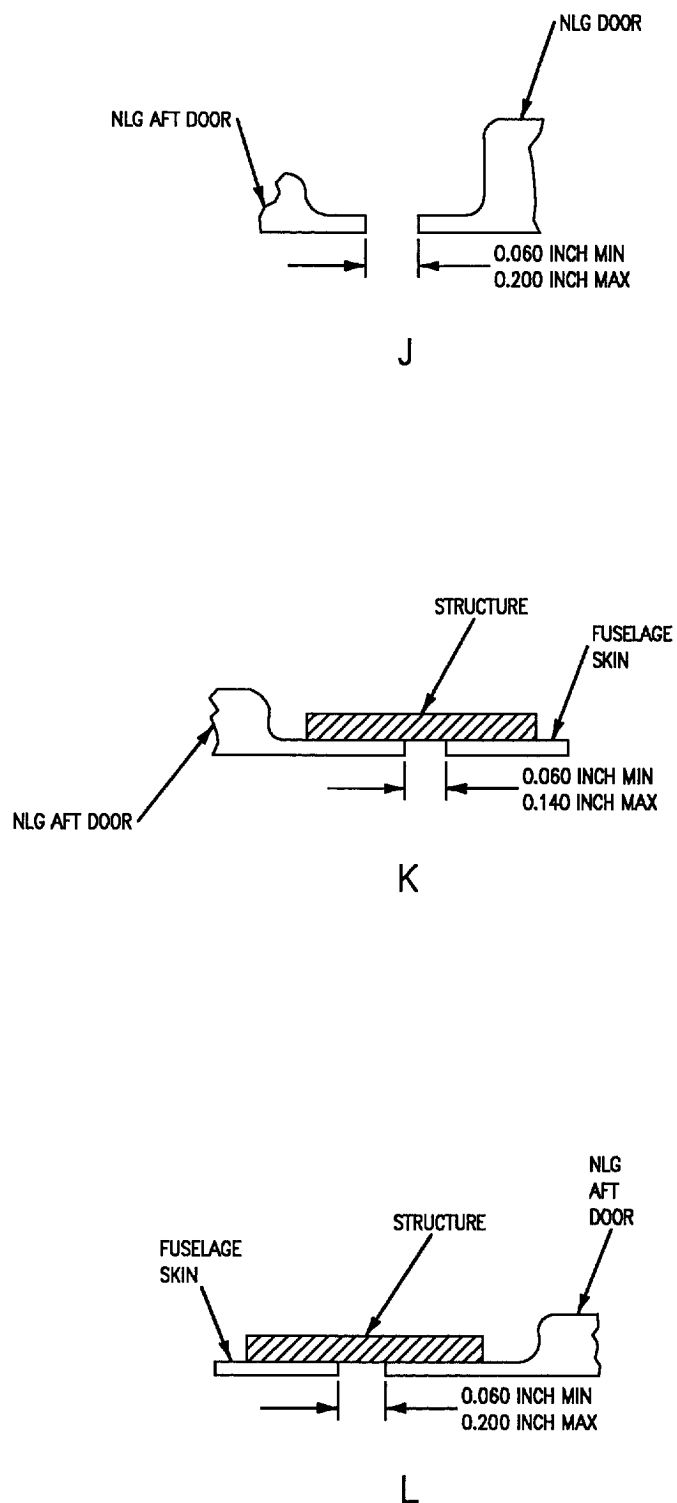


Figure 6. NLG Door Replacement (Sheet 5)

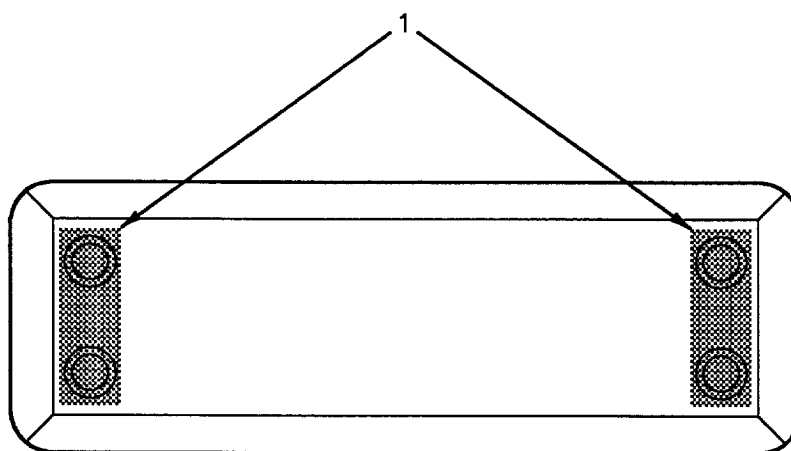


Figure 7. Plate 74A460820, Replacement (Sheet 1)





IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut 	MS21060L3
LEGEND				
 Hole diameter is 0.196 +0.0006 -0.0000.				
 Attach with RV1241-3-2 blind rivet.				

Figure 7. Plate 74A460820, Replacement (Sheet 2)

ORGANIZATIONAL MAINTENANCE**STRUCTURE REPAIR****FIBERGLASS AND ARAMID COMPONENTS**

Reference Material

Structure Repair, General Information	A1-F18AC-SRM-200
Gang Channel and Plate Nut Identification and Repair	WP004 05
Nondestructive Inspection	A1-F18AC-SRM-300
Pulse Echo, Longitudinal Wave Contact, Without Delay Line, for Composite Laminate Material	WP008 02
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Fiberglass or Aramid Assembly, Class I Damage Repair	WP039 00
Fiberglass or Aramid Assembly, Class II Damage Repair	WP040 00
Fiberglass or Aramid Assembly, Class III Damage Repair	WP041 00
Fiberglass or Aramid Assembly, Class IV Damage Repair	WP042 00
Fiberglass or Aramid Assembly, Class VI Damage Repair	WP044 00
Fiberglass or Aramid Assembly, Class VII Damage Repair	WP045 00
Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Windshield Panel, Aircraft - Instl of	FIG 007 00
Crew Station Equipment - Instl of (Cockpit) (Kickshield Panels, Glare)	
Shield Panel, Map and Data Case, Liner and Insulation	FIG 015 00
Door, Access - Fuselage Nose Section, Instl of (Gun Bay)	FIG 026 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Nose Barrel Finish System and Markings	WP018 00
Windshield, Canopy, and Cockpit Finish System	WP021 00

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Skin Damage, Full Penetration, Class VII Damage	3
Skin Damage Without Penetration, Class III Damage	2
Skin Delamination Open to Edge of Part or at Fastener Holes, Class IV Damage	3
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Record of Applicable Technical Directives

None

1. **DAMAGE EVALUATION.** See figure 1.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. Locating and determining size of damage by NDI method is intermediate maintenance. Damage not listed or exceeding limits below requires depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** See figure 2. Negligible damage may be allowed to exist as is. Type and limits are:

a. Cuts, scratches, pits, erosion or abrasions that extend into or through any protective coating but do not penetrate the outer ply of the underlying laminate skin.

4. **REPAIRABLE DAMAGE.** See figure 3. Repairable damage is damage that can be permanently repaired with no adverse effect on structural integrity, flight characteristic, or safety of the aircraft. Any repairs not listed require depot engineering disposition.5. **Skin Surface Damage, Class I Damage.** See figure 3, section A. This class of damage does not require immediate repair but shall be repaired as soon as practical. Damage shall be monitored to make sure limits are not exceeded. Class I damage is damage which does not exceed the limits below:

a. Dents, scuffs, pits, scratches, erosion, or abrasions.

(1) Do not penetrate through the first ply.

(2) Are a maximum of 20% of part surface area.

6. **Fiber Damage Around Fastener Holes And Edge Damage, Class II Damage.** See figure 3, section B. Class II damage is damage which does not exceed the limits below:

a. Broken or missing fibers at fastener hole; not more than:

(1) 0.15 inches in depth.

(2) 0.25 inches in width.

(3) 1.00 inch in length.

b. Chipped, broken, or crushed edge not extending:

(1) 0.12 inches into edge.

(2) 4.00 inches along edge.

7. **Skin Damage Without Penetration, Class III Damage.** See figure 3, section C. Determine size and location of delaminations (A1-F18AC-SRM-300, WP008 02). Class III damage is damage which does not exceed the limits below:

a. Cuts, scratches, scuffs, nicks, or gouges which:

(1) Do not penetrate through two plies.

(2) Can be enclosed in a 4 inch diameter circle.

(3) Distance between damages is at least four times diameter of largest damage.

b. Delaminations which:

(1) Are not open to edge.

(2) Are between first and second plies.

(3) Can be enclosed in a 4 inch diameter circle.

(4) Distance between damage is at least four times diameter of largest damage.

8. Skin Delaminations Open to Edge of Part or at Fastener Holes, Class IV Damage. See figure 3, section D. Determine size and location of delaminations (A1-F18AC-SRM-300, WP008 02). Class IV damage is damage which does not exceed the limits below:

a. Delaminations open to edge at any depth which:

(1) Do not extend more than 1 inch from edge.

(2) Are no longer than 4 inches.

(3) Distance between damages is at least four times length of longest damage.

b. Delamination at fastener hole at any depth which can be enclosed in a 0.75 inch diameter circle.

9. Skin Damage Below Second Ply, Not Open to Edge of Part, Class VI Damage. See figure 3, section E. Determine size and location of delaminations or unbonds (A1-F18AC-SRM-300, WP008 02). Class VI damage is damage which does not exceed the limits below:

a. Delaminations or unbonds which:

(1) Can be enclosed in a 4 inch diameter circle.

(2) Distance between damages is four times diameter of largest damage.

b. Cuts, gouges, or dents which:

(1) Can be enclosed in a 4 inch diameter circle.

(2) Distance between damages is four times diameter of largest diameter.

10. Skin Damage, Full Penetration, Class VII Damage. See figure 3, section F. Class VII damage is damage which does not exceed the limits below:

a. Can be enclosed in a 4 inch diameter circle.

b. A depot engineering disposition is required if repairs to this class damage overlap existing fasteners.

11. REPAIRS.

12. Class I, II, III, IV, VI, and VII damages are organizational maintenance. Repair class I, II, III, IV, VI, VII damages per the procedures referenced below. Refinish repaired area as required (A1-F18AC-SRM-500, WP018 00 and WP021 00).

a. Repair class I damage (A1-F18AC-SRM-250, WP039 00).

b. Repair class II damage (A1-F18AC-SRM-250, WP040 00).

c. Repair class III damage (A1-F18AC-SRM-250, WP041 00).

d. Repair class IV damage (A1-F18AC-SRM-250, WP042 00).

e. Repair class VI damage (A1-F18AC-SRM-250, WP044 00).

f. Repair class VII damage (A1-F18AC-SRM-250, WP045 00).

13. REPLACEMENT.

14. COVER, 74A313012. Cover is interchangeable. Fastener attaching hardware is shown on figure 4. For fasteners (A1-F18AC-SRM-420, FIG 026 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP018 00).

15. SHIELD (DOOR CPM). Door is interchangeable. Fastener attaching hardware is shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 015 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

16. **11M1016-1 STRIP.** Replace loose or damaged strips. See figure 6 and steps below.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
11M1016-1	Chloroprene Rubber Strip
MS20470AD3	Rivet (2)
EC1357	Adhesive
MIL-C-38736	Cleaning Compound
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
H-B-695, CLASS 1 GRADE A SIZE 1	Brush, Varnish
A-A-1047 GRIT 320 - 9X11	Paper, Abrasive
4M27-3	Washer (4)

a. Remove MS20470AD3 rivets and 4M27-3 washers, typical two places, detail A.

b. Pull strip loose from shield.



Use care when removing residual adhesive not to damage base material of shield.

c. Clean all residual adhesive where strip mated with shield by sanding with 320 grit abrasive paper.



Cleaning Compound, MIL-C-38736

4

d. Clean bonding area with clean cheesecloth moistened with cleaning compound.

e. Wipe surface dry with clean dry cheesecloth.

f. Cut replacement 11M1016-1 strip to required length.

g. Brush apply adhesive evenly over bonding area, detail B.

h. Allow to air dry until adhesive becomes tacky to the touch of the finger.

i. Install strip over shield.

j. Install MS20470AD3 rivets with 4M27-3 washers, typical two places, detail A.

k. Allow strip to cure to shield at room temperature for a minimum of 24 hours.

l. Touch up repaired area as required (A1-F18AC-SRM-500, WP021 00).

17. **74A800678-2007 STRIP.** Replace loose or damaged strips. See figure 7 and steps below.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
ZZ-R-765 CLASS IB, GRADE 50	Silicone Rubber Strip
RTV106	Adhesive
SS-4004	Primer, Silicone
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
A-A-1047 GRIT 320 - 9X11	Paper, Abrasive
TT-M-261	Methyl Ethyl Ketone

a. Pull strip loose from shield.



Use care when removing residual adhesive not to damage base material of shield.

b. Clean all residual adhesive where strip mated with shield by sanding with abrasive paper.



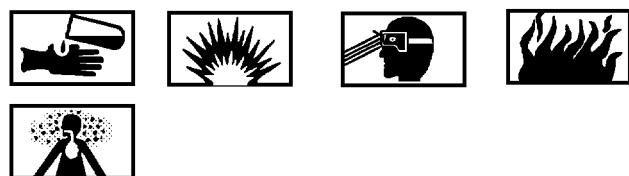
Methyl Ethyl Ketone, TT-M-261

10

c. Clean bonding area with clean cheesecloth moistened with methyl ethyl ketone.

d. Wipe surface dry with clean dry cheesecloth.

e. Cut replacement silicone rubber strip to required length.



Silicone Primer, SS-4004

17

f. Apply light coat of rubber primer to bonding area by wiping with cheesecloth dampened with rubber primer, detail A.

g. Allow rubber primer to air dry for one hour.



Adhesive, RTV106

18

h. Apply small amount of adhesive evenly over bonding area, detail A.

i. Install strip over shield.

j. Allow strip to cure at room temperature for a minimum of 24 hours.

k. Touch up repaired area as required (A1-F18AC-SRM-500, WP021 00).

18. **74A800678-2013 FLAP.** Replace loose or damaged flap. See figure 8 and steps below.

Support Equipment Required

None

Materials Required

Specification or Part Number

Nomenclature

MIL-R-6855 CLASS 2 Type EA, GRADE 40	Rubber, Chloroprene Sheet
EC1357	Adhesive
MIL-C-38736	Cleaning Compound
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
H-B-695, CLASS 1 GRADE A SIZE 1	Brush, Varnish
A-A-1047 GRIT 320 - 9X11	Paper, Abrasive
-	X-acto Knife

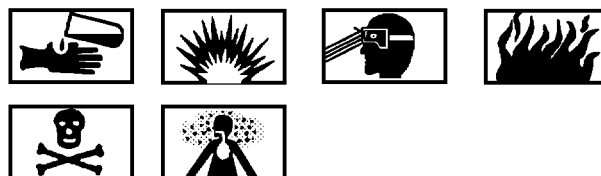
a. Remove 11M1016-1 strip, paragraph 16 this work package.

b. Pull flap loose from shield.



Use care when removing residual adhesive not to damage base material of shield.

c. Clean all residual adhesive where flap mated with shield by sanding with abrasive paper.



Cleaning Compound, MIL-C-38736

4

d. Clean bonding area with clean cheesecloth moistened with cleaning compound.

e. Wipe surface dry with clean dry cheesecloth.

f. Cut replacement flap per steps below:

(1) Position old flap on a piece of chloroprene rubber sheet.

(2) Using old flap as a template, fabricate new flap by cutting along the periphery of old flap using x-acto knife.



Adhesive, EC1357

20

g. Brush apply adhesive evenly over bonding area, detail A.

h. Allow to air dry until adhesive becomes tacky to the touch of the finger.

i. Install flap on shield.

j. Install 11M1016-1 strip, paragraph 16 this work package.

k. Allow flap to cure to shield at room temperature for a minimum of 24 hours.

l. Touch up repair area as required (A1-F18AC-SRM-500, WP021 00).

19. **NAS43DD3-14 SPACER.** Replace loose or damaged spacer. See figure 9 and steps below.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
NAS43DD3-14	Spacer
RTV106	Adhesive
SS-4004	Primer, Silicone
CCC-C-440 TYPE 1	Cheesecloth
CLASS 1	
A-A-1047 GRIT 320 - 9X11	Paper, Abrasive
TT-M-261	Methyl Ethyl Ketone
GG-D-266 TYPE 1	Depressor, Tongue

a. Remove spacer from shield.



Use care when removing residual adhesive not to damage base material of shield.

b. Clean all residual adhesive where spacer mated with shield by sanding with abrasive paper.

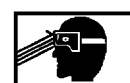


Methyl Ethyl Ketone, TT-M-261

10

c. Clean bonding area with clean cheesecloth moistened with methyl ethyl ketone.

d. Wipe surface dry with clean dry cheesecloth.



Silicone Primer, SS-4004

17

e. Apply light coat of silicone primer to bonding surfaces of shield and spacer by wiping with clean cheesecloth dampened with rubber primer, detail A.

f. Allow rubber primer to air dry for one hour.



Adhesive, RTV106

18

g. Apply small amount of adhesive evenly over bonding area using tongue depressor, detail A.

h. Install spacer on shield and flare in 0.12 radius around spacer with adhesive, detail A.

i. Allow spacer to cure at room temperature for a minimum of 24 hours.

j. Touch up repair area as required (A1-F18AC-SRM-500, WP021 00).

20. **COVER, 74A830721.** Cover is interchangeable. Fastener attaching hardware is shown on figure 10. For fasteners (A1-F18AC-SRM-420, FIG 007 00). For replacement rivets, attaching hardware not shown (A1-F18AC-SRM-200, WP004 05). Apply finish system as required (A1-F18AC-SRM-500, WP021 00).

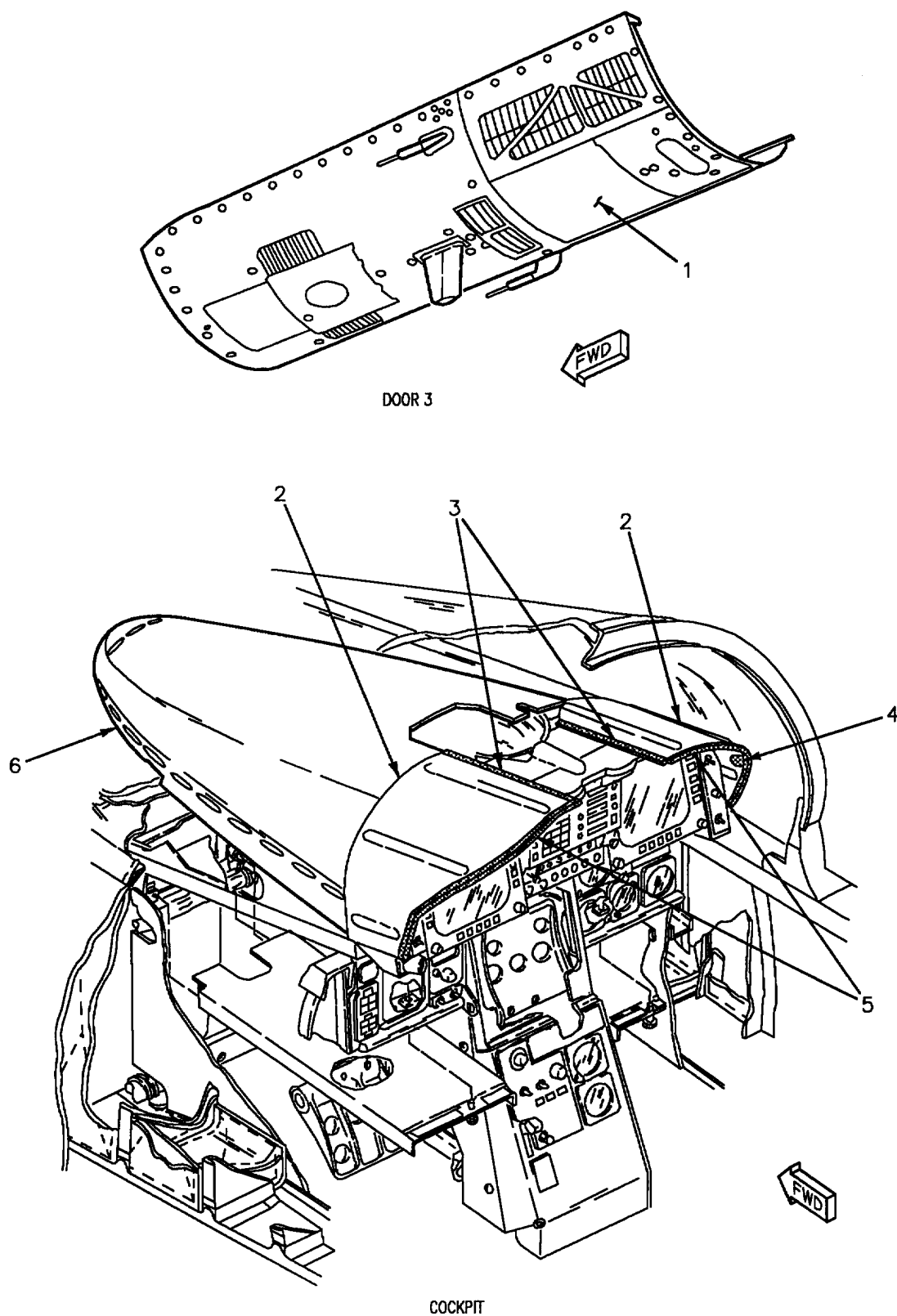
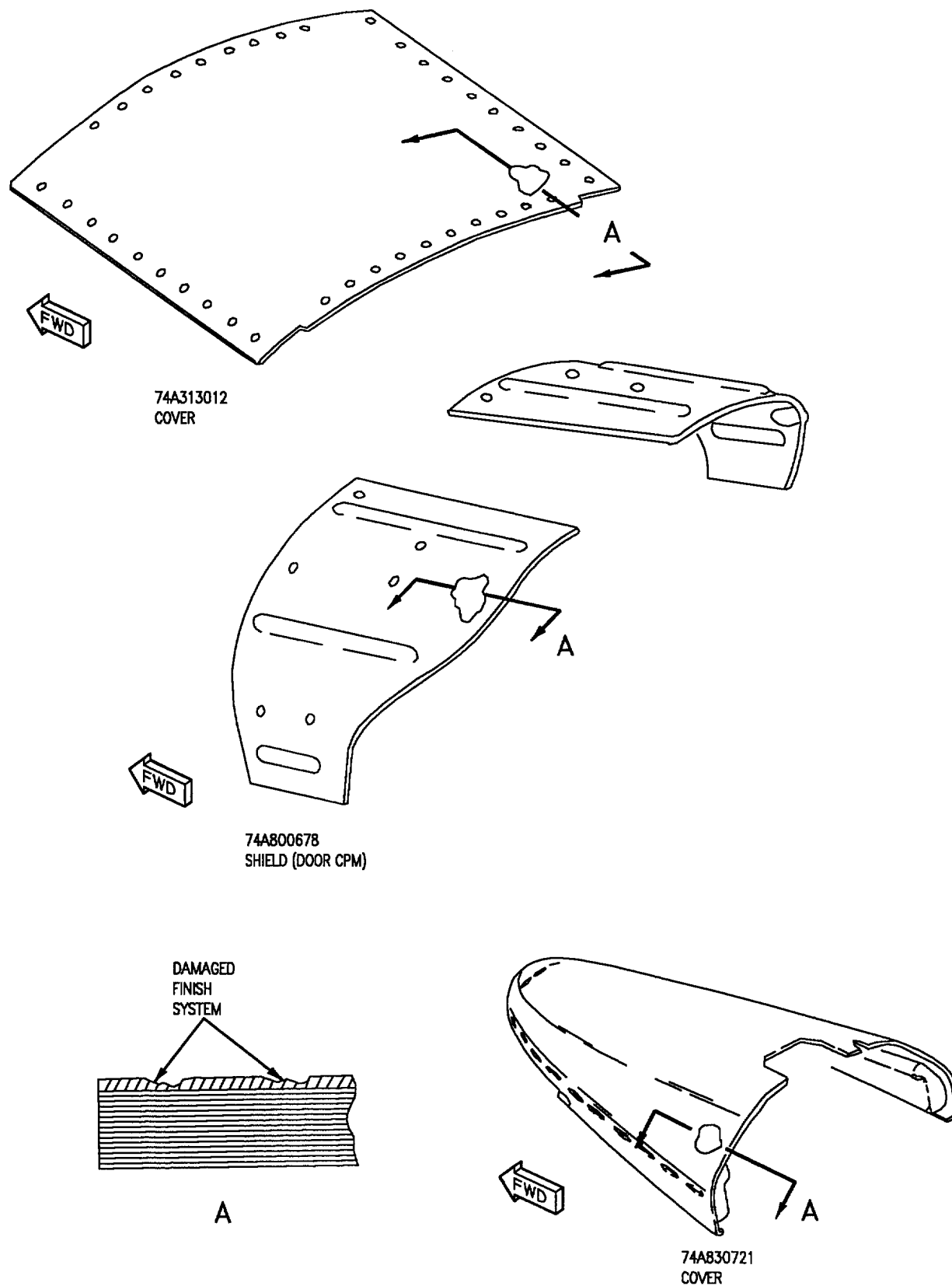


Figure 1. Material Index (Sheet 1)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Cover 74A313012-2005	0.110 Laminate, 0.010 Plies	Kevlar 49 cloth
2		Shield (Door CPM) 74A800678-2009	0.040 Laminate, 0.010 Plies	Kevlar 49 cloth
L	1	74A800678-2011		
R	2	74A800678-2015		
3		Strip 74A800678-2007	6	3
4		Flap 74A800678-2013	4	5
5		Strip 11M1016-1	-	Chloroprene rubber
6		Cover 74A830721-1015	0.010 Plies	Kevlar 49 cloth
LEGEND 1 161353 THRU 162406. 2 162407 AND UP. 3 ZZ-R-765, class IB, grade 50, flat black. 4 0.031 x 2.12 x 4.06 chloroprene rubber sheet. 5 MIL-R-6855, class 2, type EA, grade 40. 6 0.031 x 0.50 x 11.35 silicone rubber sheet.				

Figure 1. Material Index (Sheet 2)



18AC-SRM-222-(109-1)01-SCAN

Figure 2. Negligible Damage

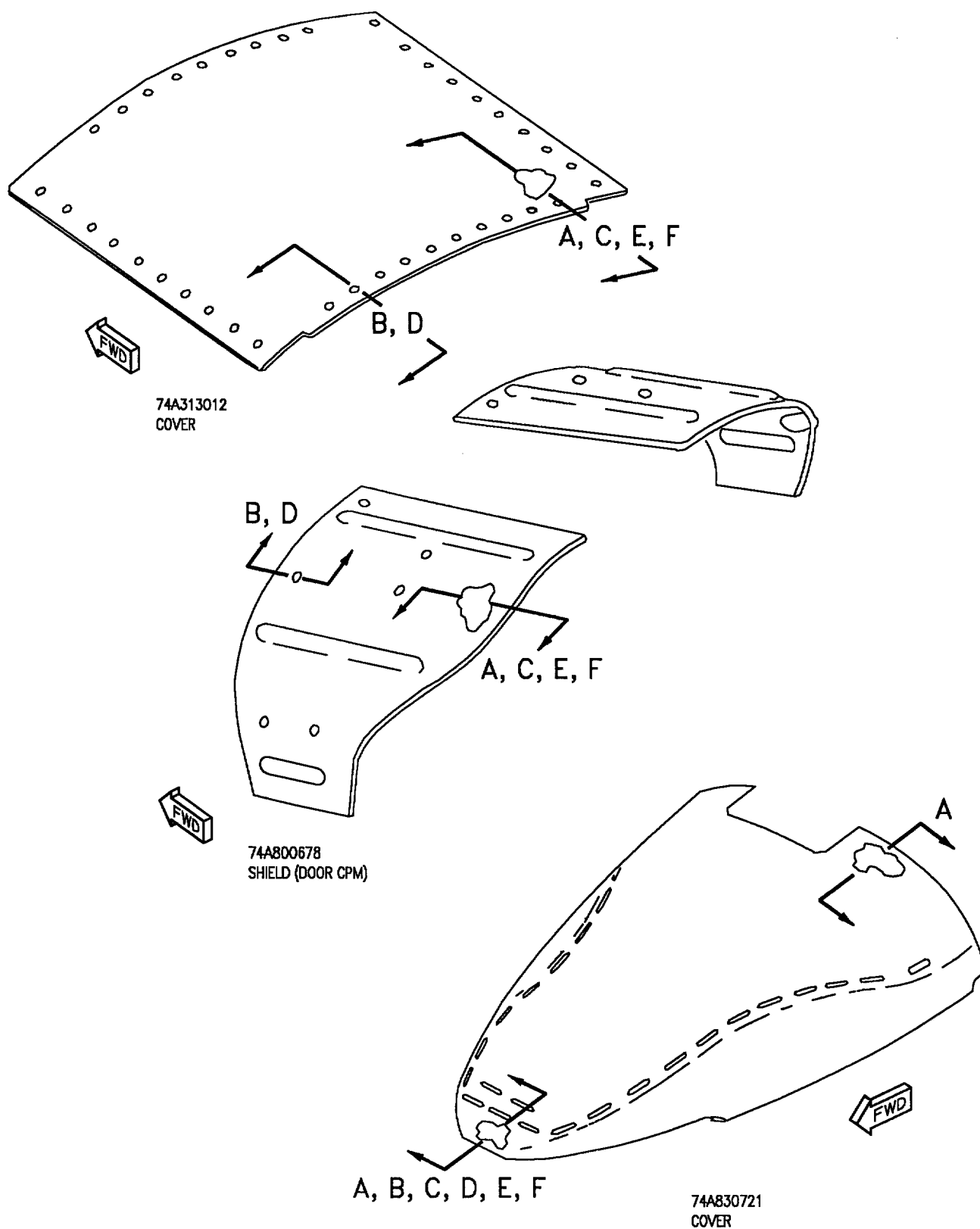


Figure 3. Repairable Damage (Sheet 1)

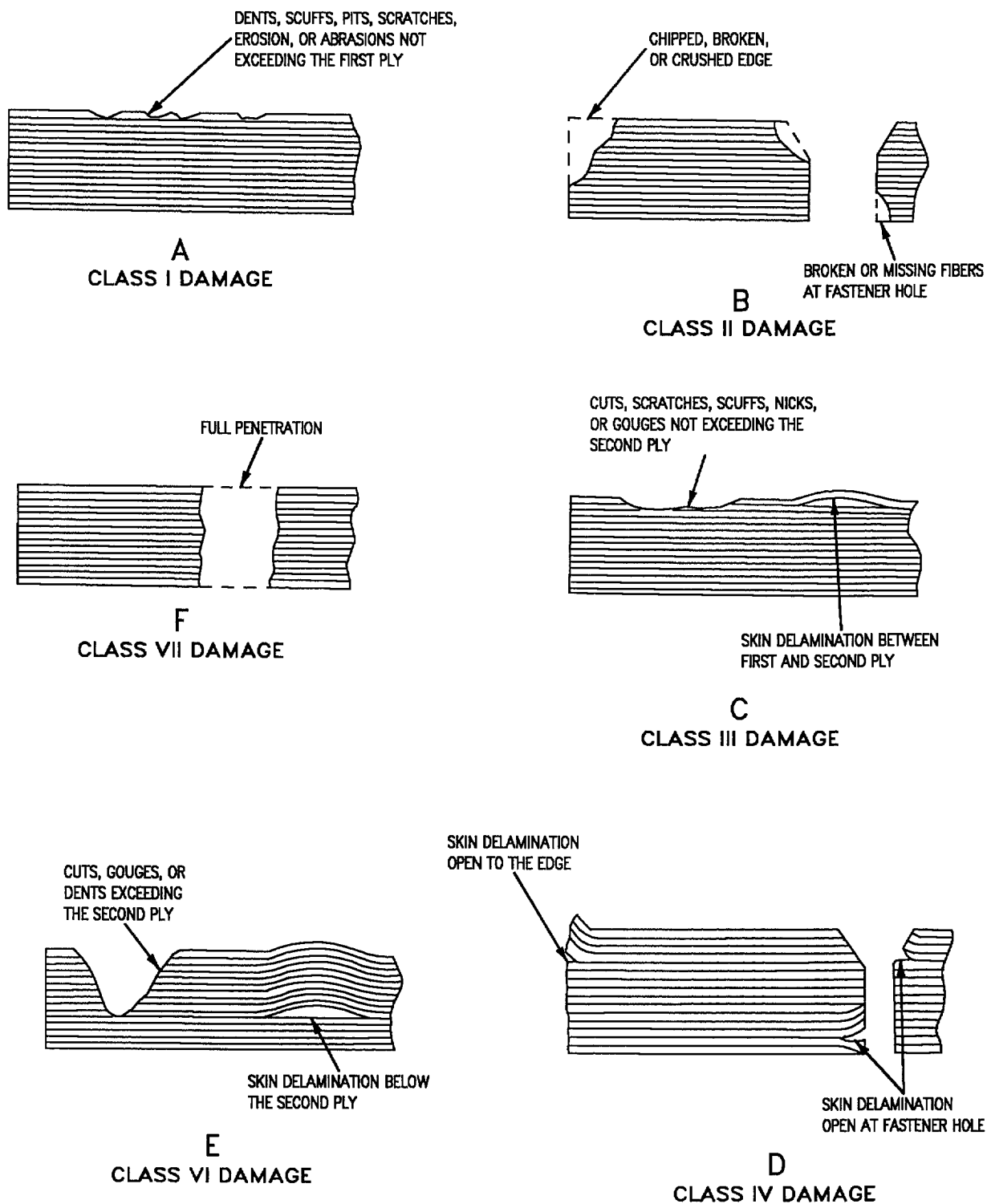
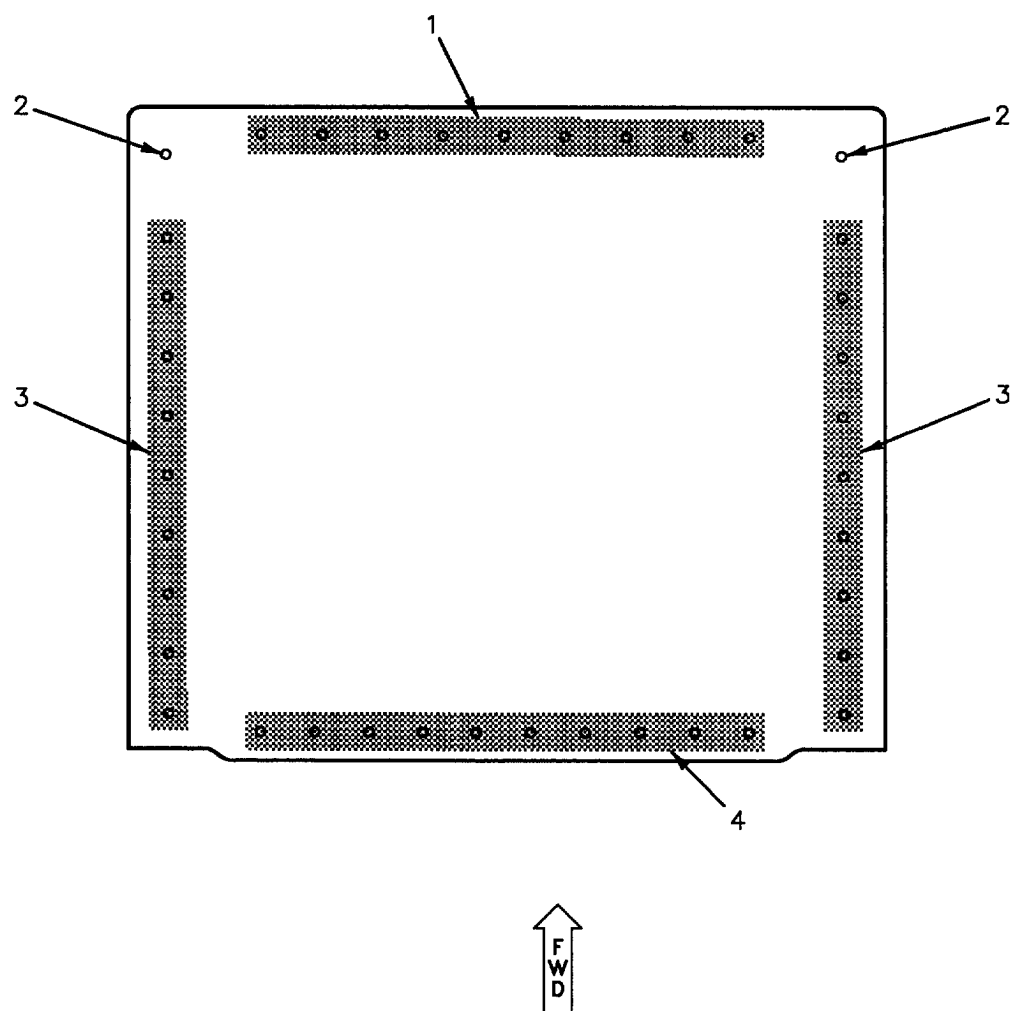


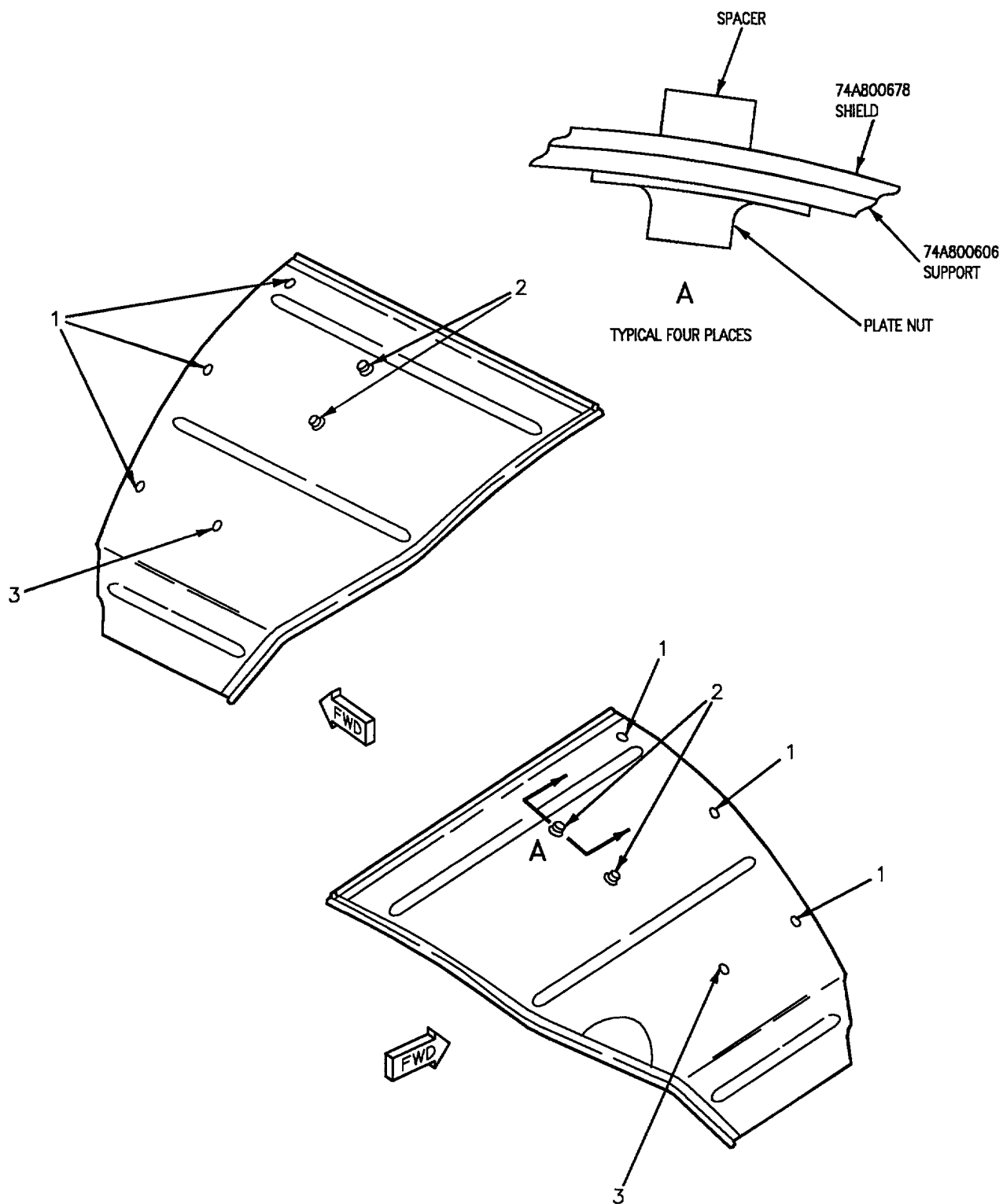
Figure 3. Repairable Damage (Sheet 2)



18AC-SRM-222-(111-1)01-CAT1

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Gang Channel	G14421-2-3-9
2			Plate Nut	MS21059L3
3			Gang Channel	G14421-2-3-10
4			Gang Channel	G14421-2-3-9
LEGEND				
			Hole diameter is 0.195 +0.007 -0.000.	
			Hole diameter is 0.196 +0.006 -0.000 in cover and 0.191 +0.006 -0.000 in structure.	
			Hole diameter is 0.195 +0.007 -0.000 in cover and 0.191 +0.006 -0.000 in structure.	

Figure 4. Cover, 74A313012, Replacement



18AC-SRM-222-(112-1)01-SCAN

Figure 5. Shield (Door CPM) Replacement (Sheet 1)






IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21061L3
2			Plate Nut Spacer	F50405-3 NAS43DD3-14
3			Plate Nut	F6001-3
LEGEND				
 0.375 x 0.250 slot in shield and 0.218 +0.006 -0.000 diameter hole in structure.				
 Hole diameter is 0.250 +0.006 -0.000				

Figure 5. Shield (Door CPM) Replacement (Sheet 2)

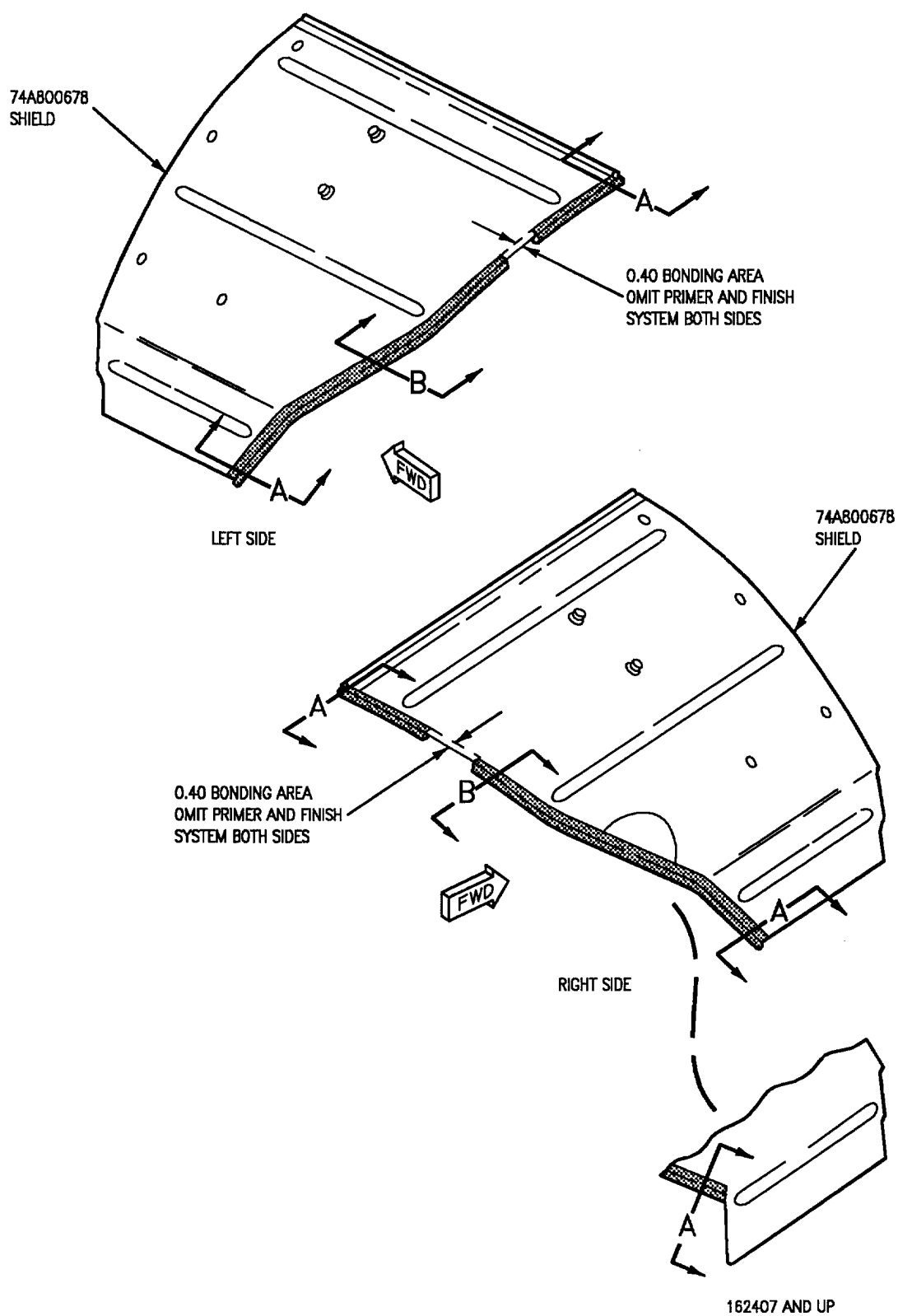


Figure 6. 11M1016-1 Strip Replacement (Sheet 1)

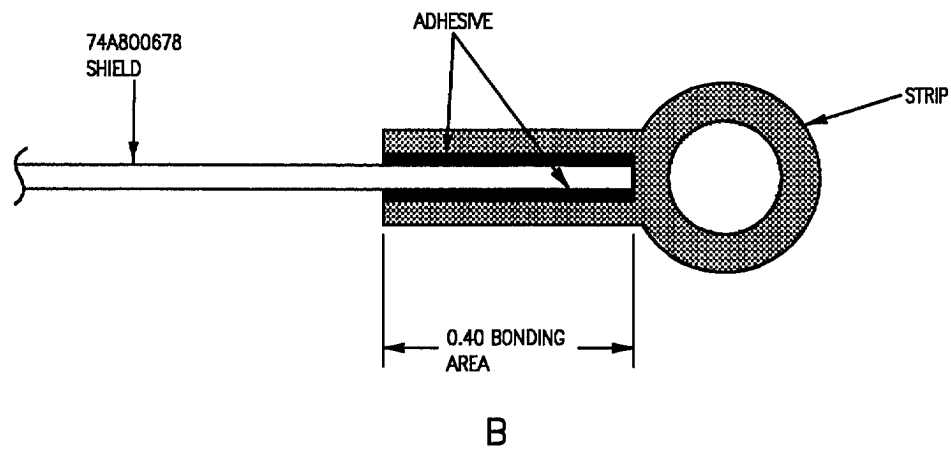
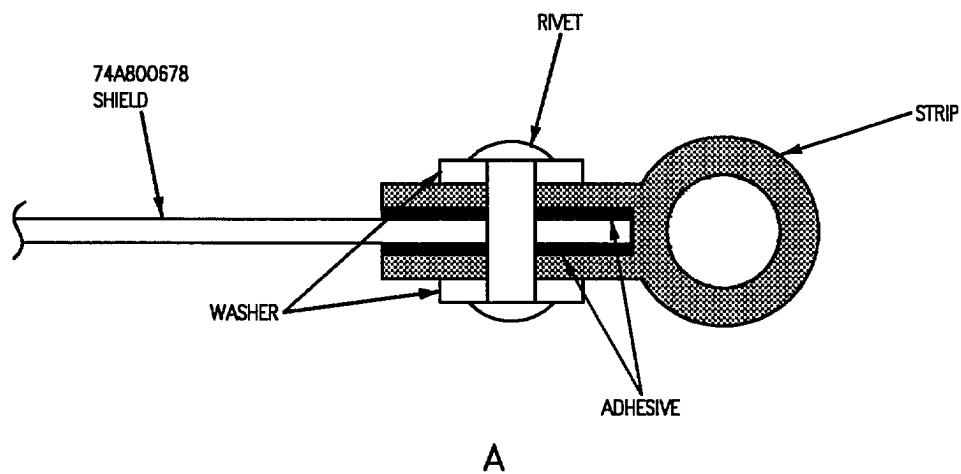


Figure 6. 11M1016-1 Strip Replacement (Sheet 2)

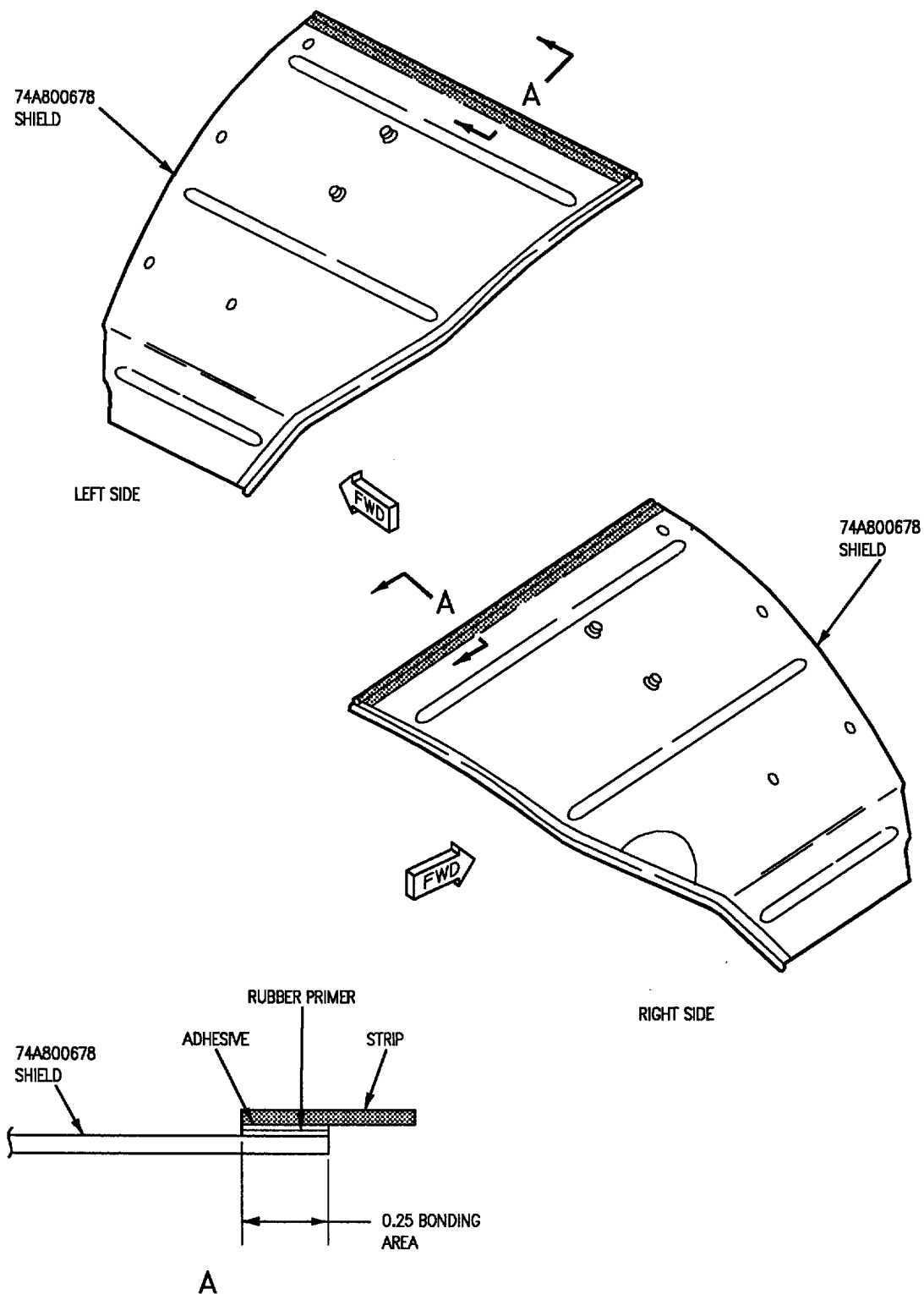


Figure 7. 74A800678-2007 Strip Replacement

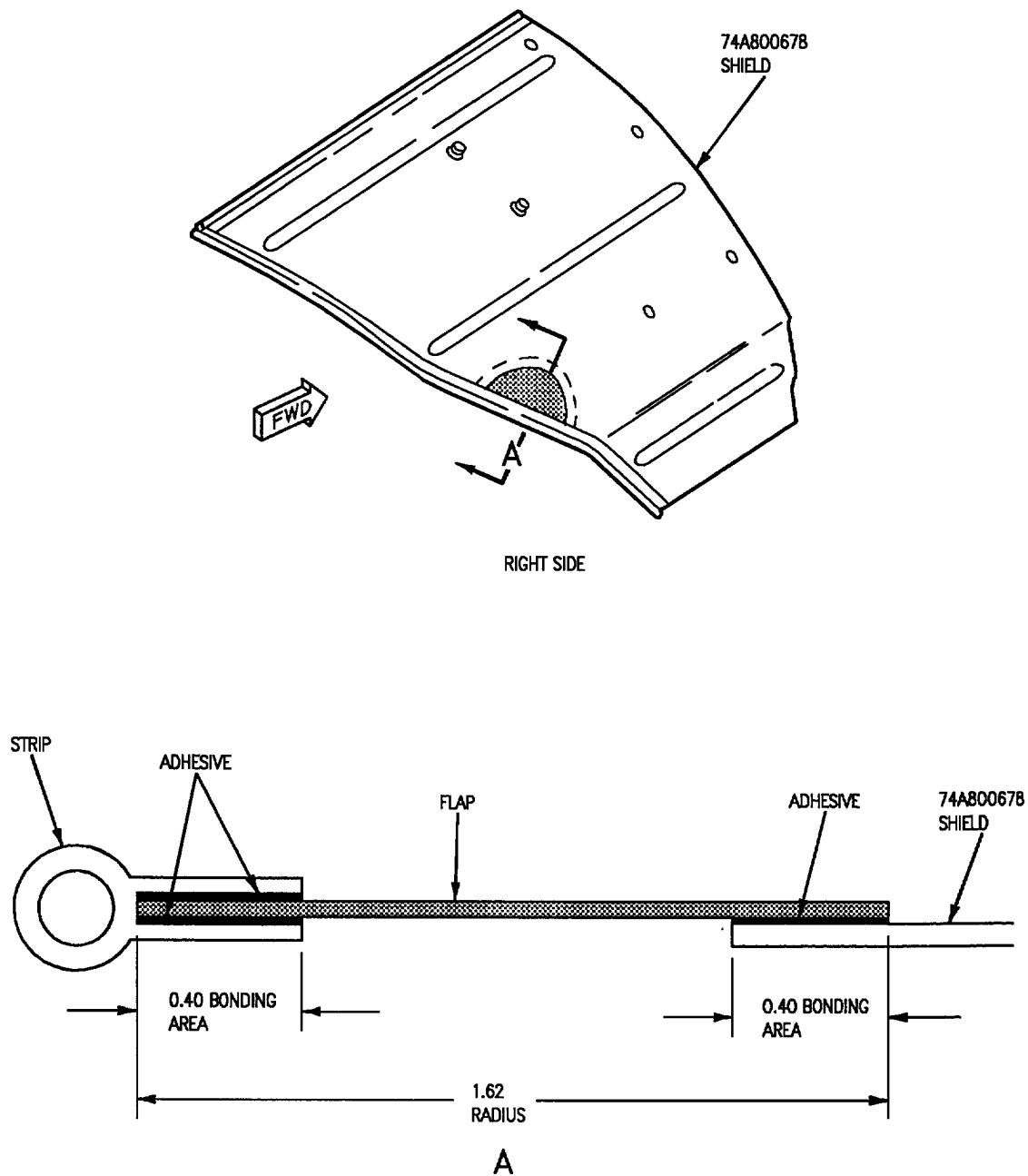


Figure 8. 74A800678-2013 Flap Replacement

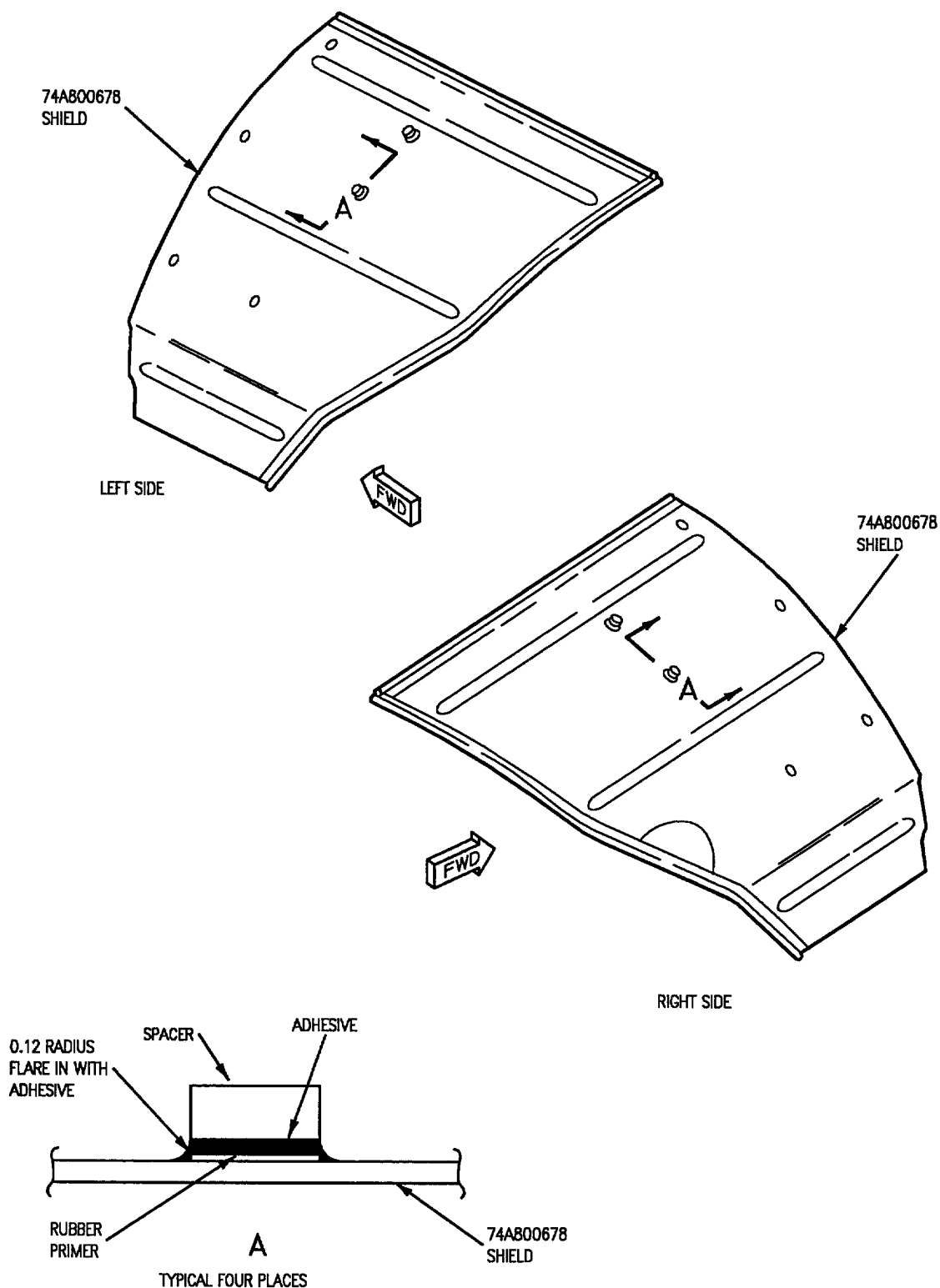
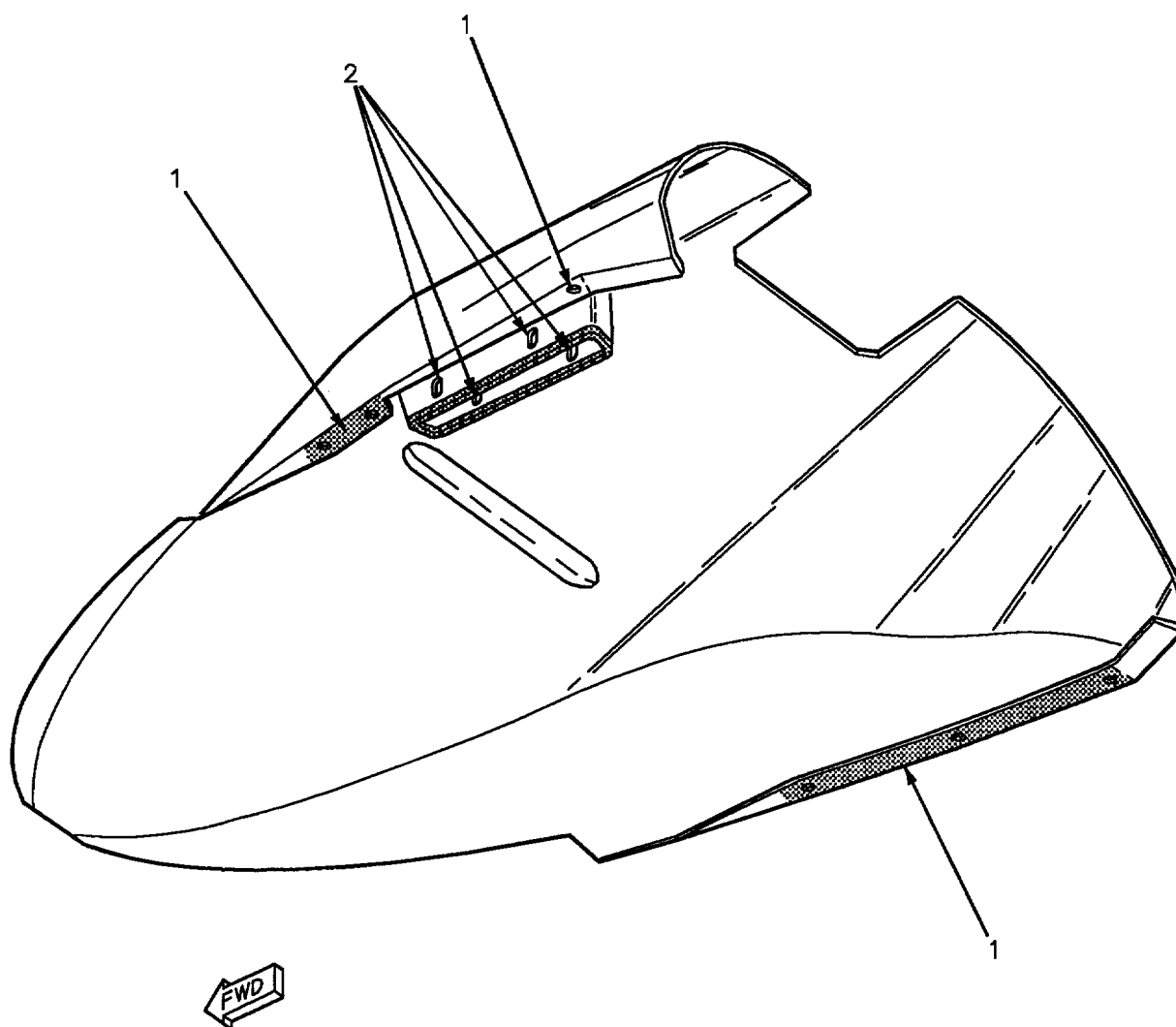


Figure 9. NAS43DD3-14 Spacer Replacement



18AC-SRM-222-(117-1)01-SCAN

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	MS21059L3
2			Plate Nut	MS21060L08
LEGEND				
Hole diameter is 0.250 +0.006 -0.000.				
0.300 X 0.166 slot in cover and 0.166 +0.006 -0.000 diameter hole in structure.				
Attach with MS20426B3 rivet, length to be determined on installation.				

Figure 10. Cover, 74A830721, Replacement

ORGANIZATIONAL AND DEPOT MAINTENANCE**STRUCTURE REPAIR****LEFT LEADING EDGE EXTENSION SKIN AND DOORS**

Reference Material

Structure Illustrated Parts Breakdown - Forward Fuselage	A1-F18AC-SRM-420
Skin, Aircraft-Aft, Closure, LE Ext, Instl of	FIG 048 00
Leading Edge Extension, Instl. of	FIG 047 00
Aircraft Corrosion Control	A1-F18AC-SRM-500
Form In Place Sealing	WP010 00
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Priming Procedures	WP011 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Structure Repair, General Information	A1-F18AC-SRM-200
Introduction	WP002 00
Gang Channel and Plate Nut Identification and Repair	WP004 05
Shop Practices-Forming Sheet Metal	WP004 01
Shop Practices-Locating Blind Holes and Trim Lines	WP004 03
Structure Repair, Typical Repair	A1-F18AC-SRM-250
Aluminum Patch Fabrication	WP006 01
Aluminum, Graphite Epoxy, or Titanium Patch Installation and Removal	WP007 00
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Aluminum Sheet Edge Repair	WP034 00
Aluminum Sheet Repairs, Across Structure and Lands Blending	WP038 00
Seat, Canopy, Survival Equipment and Boarding Ladder	A1-F18AC-120-300
Removal and Installation - Boarding Ladder or Drag Brace Assembly	WP122 00
Exterior Lighting System	A1-F18AC-440-300
Lex Position Light	WP005 00

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Permanent Repairs	3
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Leading Edge Extension Fence	5
Installation	5
Removal	5
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Skin, 74T030348-2013	6
Removable Covers	5

Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F/A-18 AFC 102	-	Leading Edge Extension Fence, Installation of (ECP MDA-F/A-18-00300)	15 Apr 88	-

Support Equipment Required

None

Material Required

None

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figure 1. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Damage not listed or exceeding the following limits require depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers

in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

4. **REPAIRABLE DAMAGE.** The types and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with figure and index numbers in the material index, figure 1.

NOTE

The limits in table 2 apply after blending the damage.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surfaces at least 20 times the depth.

c. Cracks. All cracks must be repaired.

5. REPAIRS.

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definitions are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

7. PERMANENT REPAIRS.

8. Scratches, Nicks, Gouges, or Corrosion.

Blend scratches, nicks, gouges or corrosion (A1-F18AC-SRM-250, WP038 00). If, after blending, the damage limits of table 2 are exceeded, repair aluminum as below. Refinish blended areas (A1-F18AC-SRM-500, WP024 00).

a. Scratches - make crack or edge repair.

b. Nicks, gouges or corrosion - make hole or edge repair.

9. Cracks.

a. In repair zone A3, repair cracks free of structure or land areas in aluminum (A1-F18AC-SRM-250, WP031 00).

(1) Rout out crack.

(2) Install lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair cracks free of structure or land areas in aluminum sheet, (0.050 inch thickness or less).

(1) Completely cut out crack in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3, repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3 repair cracks to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

10. Holes.

a. In repair zone A3, repair holes free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) Install a type one flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair holes free of structure or land areas in aluminum sheet, (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3, repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay,
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3, repair dents to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

11. **Edge.** In repair zone A3, repair edge damage in aluminum sheet (A1-F18AC-SRM-250, WP034 00).

a. Cut out damage.

b. Select and install repair patch.

(1) Corner damage to Lands.

(2) Corner damage to Lands and Bays.

(3) Edge damage to Lands.

(4) Edge damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

12. Dents.

a. In repair zone A3, repair dents free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) Install a type one flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair dents free of structure or land areas in aluminum sheet, (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3, repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3, repair dents to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.





(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

13. **DRAG BRACE A2641-6 REPAIR, 161353 THRU 162414.** Temporary Repair. See figure 5.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
MIL-L-7808	Lubricating Oil
a. Remove drag brace from aircraft (A1-F18AC-120-300, WP122 00).	
b. Remove end cap from drag brace on 1 inch diameter end (R/H threads).	
<div>CAUTION</div> <p>Compression of drag brace beyond this point can cause loss of balls in locking collar.</p>	
c. Compress drag brace until 0.62 diameter inner tube is flush with locking collar.	
d. Pull 0.31 diameter rod out of 0.62 diameter tube as far as possible.	
e. At end, opposite locking collar cut 0.31 diameter rod at base of 0.62 diameter tube.	
f. Remove any exposed or loose fabric liner from the inside of the 0.62 diameter tube.	
g. Apply locktie to threads, replace end cap, and restake shoulder of end cap.	
<div></div> <p>Lubricate Oil, MIL-L-7808</p> <p>21</p>	
h. Apply lubricating oil to external surface of 0.62 diameter inner tube.	
i. Install drag brace on aircraft (A1-F18AC-120-300, WP122 00).	

14. **REPLACEMENT.**

15. Fastener attaching hardware is shown for cover and position light. Form in place sealing (A1-F18AC-SRM-500, WP010 00). For replacement rivets attaching plate nuts and gang channels not shown (A1-F18AC-SRM-200, WP004 05).

16. **COVER (DOOR 22).** Cover is interchangeable. Fastener attaching parts is shown on figure 3. For fasteners (A1-F18AC-SRM-420, FIG 047 00).

17. **BOARDING LADDER.** For replacement (A1-F18AC-120-300, WP122 00).

18. **LEX POSITION LIGHT.** Fastener attaching hardware is shown on figure 4. For fasteners (A1-F18AC-440-300, WP005 00).

19. **REMOVABLE COVERS.** Fastener attaching hardware is shown on figure 7. For fasteners (A1-F18AC-SRM-420, FIG 048 00).

20. **LEADING EDGE EXTENSION (LEX) FENCE.** See figure 6.

21. Any damage to LEX fence requires a depot engineering disposition.

22. **Removal.** LEX fence is interchangeable. Fastener attaching hardware and fasteners are shown on figure 6.

NOTE

Tag all fasteners when removed to ensure that the same fasteners are installed into proper hole.

a. Remove fasteners.

b. Retain 74A201033-2009 and 74A201033-2007 spacers. If spacers are damaged on removal, replace spacers.

23. **Installation.** See figure 6.

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Torque Wrench, 0 to 300 Inch Pounds

Materials Required

Specification or Part Number	Nomenclature
MS20995NC51	Wire, Non-electrical
M20995N40	Lockwire
MIL-C-16173, GR 3	Corrosion Preventative Compound
MIL-S-83430, B-2	Sealing Compound



Sealing Compound, MIL-S-83430, Class B-2 22

a. Apply sealing compound to faying surfaces of spacer and fence prior to installation of fence. For sealant (A1-F18AC-SRM-200, WP011 00).

b. Position 74A201033-2009, 74A201033-2007 spacers and 74A201031-2001 fence in place.

c. Install fasteners as follows:



Corrosion Preventative Compound, 23
MIL-C-16173, Grade 3

(1) Apply corrosion preventative compound to shank and threads of attach fasteners.

(2) Install two NAS674V20H bolts and four AN960C416 washers (two under each bolt head) in forward attach points.

(3) Install two MB84-5H22 bolts and two NAS1587-5C washers (one under each bolt head) in aft attach points.

d. Tighten NAS674V20H bolts at forward attach points, 50-70 inch-pounds torque and safety with MS20995N40 lockwire.

e. Tighten MB84-5H22 bolts, at aft attach points, 100-140 inch-pounds torque, and safety with MS20995NC51 lockwire.

f. Apply a continuous film of sealing compound to encapsulate each fastener head (A1-F18AC-SRM-200, WP011 00).

g. Touch up bolt heads (A1-F18AC-SRM-500, WP024 00)

24. **SKIN, 74T030348-2013, REPLACEMENT.** See figure 8. Replacement of damaged or missing skin requires fabrication of new skin at intermediate maintenance. Procedures for removal, installation, drilling and application of finish systems is organizational maintenance.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440	Scraper, Formica
TYPE 1 CLASS 1	Cheesecloth
TT-I-735	Isopropyl Alcohol
H-B-643, TYPE 2,	Acid Swab Brush
CLASS 1, SIZE 1	
MIL-S-81733	Sealing Compound
CLASS 1-1/2	
7075-T6 Alclad	Skin
0.090 Thick	

a. Remove two fasteners attaching damaged skin to LEX.

b. Remove sealant from area where skin was removed using nonmetallic scraper.



Isopropyl Alcohol, TT-I-735 15

c. Remove residual sealant using clean cheesecloth moistened with isopropyl alcohol.

d. Apply finish system as required to bare aluminum surface with acid brush (A1-F18AC-SRM-500, WP024 00).

e. Fabricate new skin per steps below;

(1) Cut a 5.20 +0.010, -0.000 inch by 2.85 +0.005, -0.000 inch rectangular skin section from 0.090 inch thick 7075-T6 alclad aluminum sheet, detail A.

(2) Machine material to thickness shown on detail B (A1-F18AC-SRM-200, WP004 01).

(3) Form material to contour requirements shown on detail C (A1-F18AC-SRM-200, WP004 01).

(4) Remove all sharp edges.

f. Mate new LEX skin with structure and trim as necessary to fit with a gap tolerance of 0.005 to 0.060 inch (A1-F18AC-SRM-200, WP004 03).

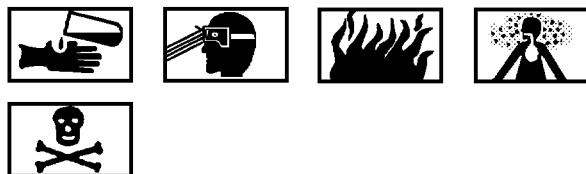
g. Locate and drill 0.195 +0.007, -0.000 holes in skin. Countersink holes to flushness requirements of fasteners, detail C (A1-F18AC-SRM-200, WP004 03).

WARNING

Primer coating is flammable and toxic to eyes, skin, and respiratory tract. Skin/eye protection required. Avoid repeated/prolonged contact. Use only in well ventilated areas. Keep away from open flames or other sources of ignition.

h. Prime skin surfaces. (A1-F18AC-SRM-500, WP011 00).

i. Apply finish system (A1-F18AC-SRM-500, WP011 00).



Sealing Compound, MIL-S-81733, Class 1-1/2

24

j. Fay seal LEX skin. For sealing compound preparation and application (A1-F18AC-SRM-200, WP011 00).

k. Install LEX skin. For fasteners see (A1-F18AC-SRM-420, WP048 00).

l. Touch up finish system as required (A1-F18AC-SRM-500, WP024 00).

Table 1. Negligible Damage Limits























Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Skin Zone A3	0.090	0.018	0.0006	100%		10%
Fig 1 (2)	Skin Zone A3	0.045	0.002	0.0006	100%	0.022	
		0.071	0.002	0.002	100%		
Fig 1 (3)	Skin Zone A3	0.071	0.014	0.0006	100%		10%
Fig 1 (4)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		
Fig 1 (5)	Skin Zone A3	0.032	0.006	0.0006	100%	0.016	
		0.050	0.010	0.0006	100%		
Fig 1 (6)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		
Fig 1 (7)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		
Fig 1 (8)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		
Fig 1 (9)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		
Fig 1 (10)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.090	0.018	0.0006	100%		
Fig 1 (11)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.090	0.018	0.0006	100%		
Fig 1 (12)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.090	0.018	0.0006	100%		

Table 1. Negligible Damage Limits (Continued)























Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (13)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
		0.090	0.018	0.0006	100%		10%
Fig 1 (14)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (15)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (16)	Skin Zone A3	0.071	0.014	0.0006	100%		10%
Fig 1 (18)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (19)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (20)	Leading Edge Zone A3	2.00	0.040	0.0006	100%		10%
Fig 1 (21)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		10%
Fig 1 (22)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		10%
Fig 1 (23)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		10%
Fig 1 (24)	Skin Zone A3	0.050	0.010	0.0006	100%	0.025	
		0.071	0.014	0.0006	100%		10%
Fig 1 (25)	Skin Zone A3	0.071	0.014	0.0006	100%		10%

Table 1. Negligible Damage Limits (Continued)
























Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (26)	Skin Zone A3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (27)	Skin Zone A3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (28)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (29)	Skin Zone A3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (30)	Skin Zone A3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (31)	Skin Zone A3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (32)	Skin Zone A3	0.071	0.014	0.0006	100%		10%
Fig 1 (33)	Skin Zone A3	0.040	0.008	0.0006	100%	0.020	
		0.071	0.014	0.0006	100%		10%
Fig 1 (34)	Skin Zone A3	0.160	0.032	0.0006	100%		10%
		0.090	0.018	0.0006	100%	0.045	
		0.070	0.014	0.0006	100%		10%
		0.042	0.008	0.0006	100%	0.020	
Fig 1 (35)	Skin Zone A3	0.042	0.008	0.0006	100%	0.020	
		0.070	0.014	0.0006	100%		10%
		0.090	0.018	0.0006	100%	0.045	
		0.160	0.032	0.0006	100%		10%

Table 2. Repairable Damage Limits After Blending

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (1)	Skin Zone A3	0.090	0.018	0.018	100%	0.018	100%
Fig 1 (2)	Skin Zone A3	0.045	0.009	0.009	50%	0.009	50%
		0.071	0.014	0.014	50%	0.014	50%
Fig 1 (3)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%
Fig 1 (4)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (5)	Skin Zone A3	0.032	0.006	0.006	100%	0.006	100%
		0.050	0.010	0.010	100%	0.010	100%
Fig 1 (6)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (7)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (8)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (9)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (10)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.090	0.018	0.018	100%	0.018	100%
Fig 1 (11)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.090	0.018	0.018	100%	0.018	100%
Fig 1 (12)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.090	0.018	0.018	100%	0.018	100%

Table 2. Repairable Damage Limits After Blending (Continued)

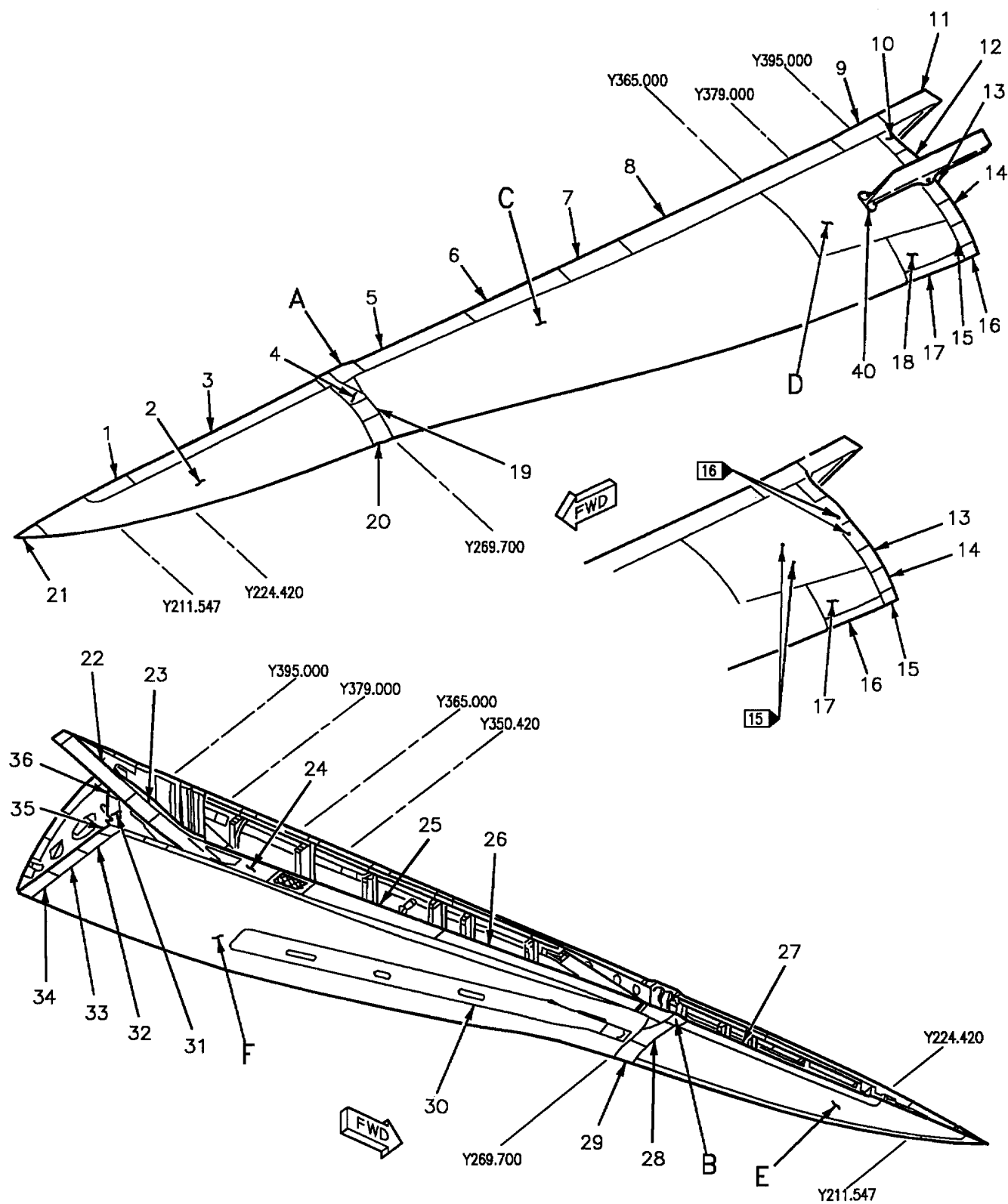
Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (13)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
		0.090	0.018	0.018	100%	0.018	100%
Fig 1 (14)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (15)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (16)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%
Fig 1 (18)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (19)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (20)	Leading Edge Zone A3	2.00	0.040	0.040	100%	0.040	100%
Fig 1 (21)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (22)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (23)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (24)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (25)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%

Table 2. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (26)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (27)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (28)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (29)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (30)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (31)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (32)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%
Fig 1 (33)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (34)	Skin Zone A3	0.042	0.008	0.008	100%	0.008	100%
		0.070	0.014	0.014	100%	0.014	100%
		0.090	0.018	0.018	100%	0.018	100%
		0.160	0.032	0.032	100%	0.032	100%
Fig 1 (35)	Skin Zone A3	0.042	0.008	0.008	100%	0.008	100%
		0.070	0.014	0.014	100%	0.014	100%
		0.090	0.018	0.018	100%	0.018	100%
		0.160	0.032	0.032	100%	0.032	100%

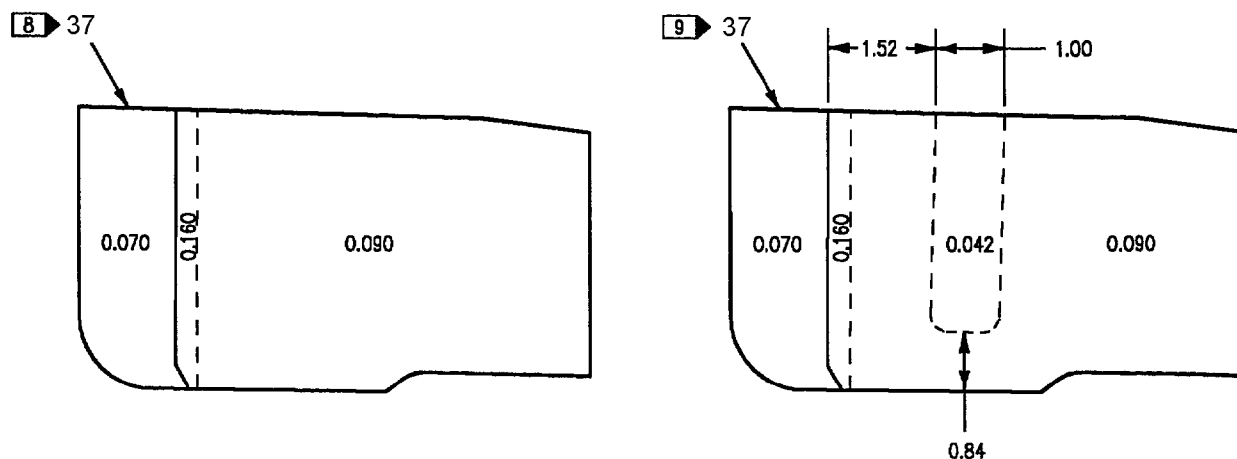
Table 2. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (36)	Skin Zone A3	0.032	0.006	0.006	50%	0.006	50%
		0.045	0.009	0.009	50%	0.009	50%
		0.060	0.012	0.012	50%	0.012	50%
		0.071	0.014	0.014	50%	0.014	50%
	Zone B3	0.032	0.006	0.006	50%	0.006	50%
		0.045	0.009	0.009	50%	0.009	50%
		0.060	0.012	0.012	50%	0.012	50%
		0.071	0.014	0.014	50%	0.014	50%
Fig 1 (37)	Door 22 Zone A3	0.045	0.009	0.009	100%	0.009	100%
		0.055	0.011	0.011	100%	0.011	100%
		0.090	0.018	0.018	100%	0.018	100%
Fig 1 (38)	Skin Zone A3	0.032	0.006	0.006	50%	0.006	50%
		0.045	0.009	0.009	50%	0.009	50%
		0.050	0.010	0.010	50%	0.010	50%
		0.071	0.014	0.014	50%	0.014	50%
	Zone B3	0.032	0.006	0.006	5%	0.006	5%
		0.045	0.009	0.009	5%	0.009	5%
		0.050	0.010	0.010	5%	0.010	5%
		0.060	0.012	0.012	100%	0.012	100%
Fig 1 (39)	Skin Zone A3	0.032	0.006	0.006	100%	0.006	100%
		0.040	0.008	0.008	50%	0.008	50%
		0.045	0.009	0.009	50%	0.009	50%
		0.050	0.010	0.010	50%	0.010	50%
		0.060	0.012	0.012	20%	0.012	20%
		0.071	0.014	0.014	50%	0.014	50%
	Zone B3	0.045	0.009	0.009	50%	0.009	50%

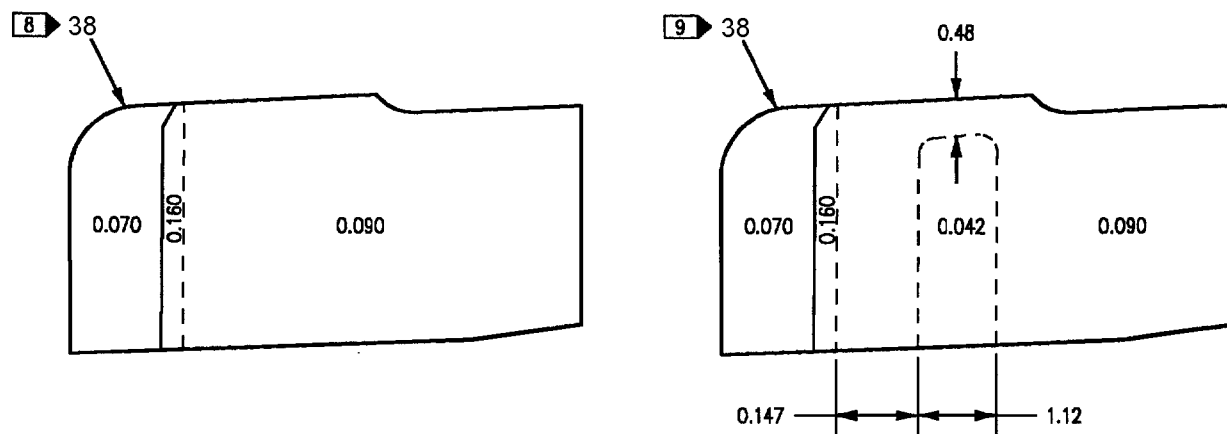


18AC-SRM-222-(118-1)01-SCAN

Figure 1. Material Index (Sheet 1)



A



B

Figure 1. Material Index (Sheet 2)

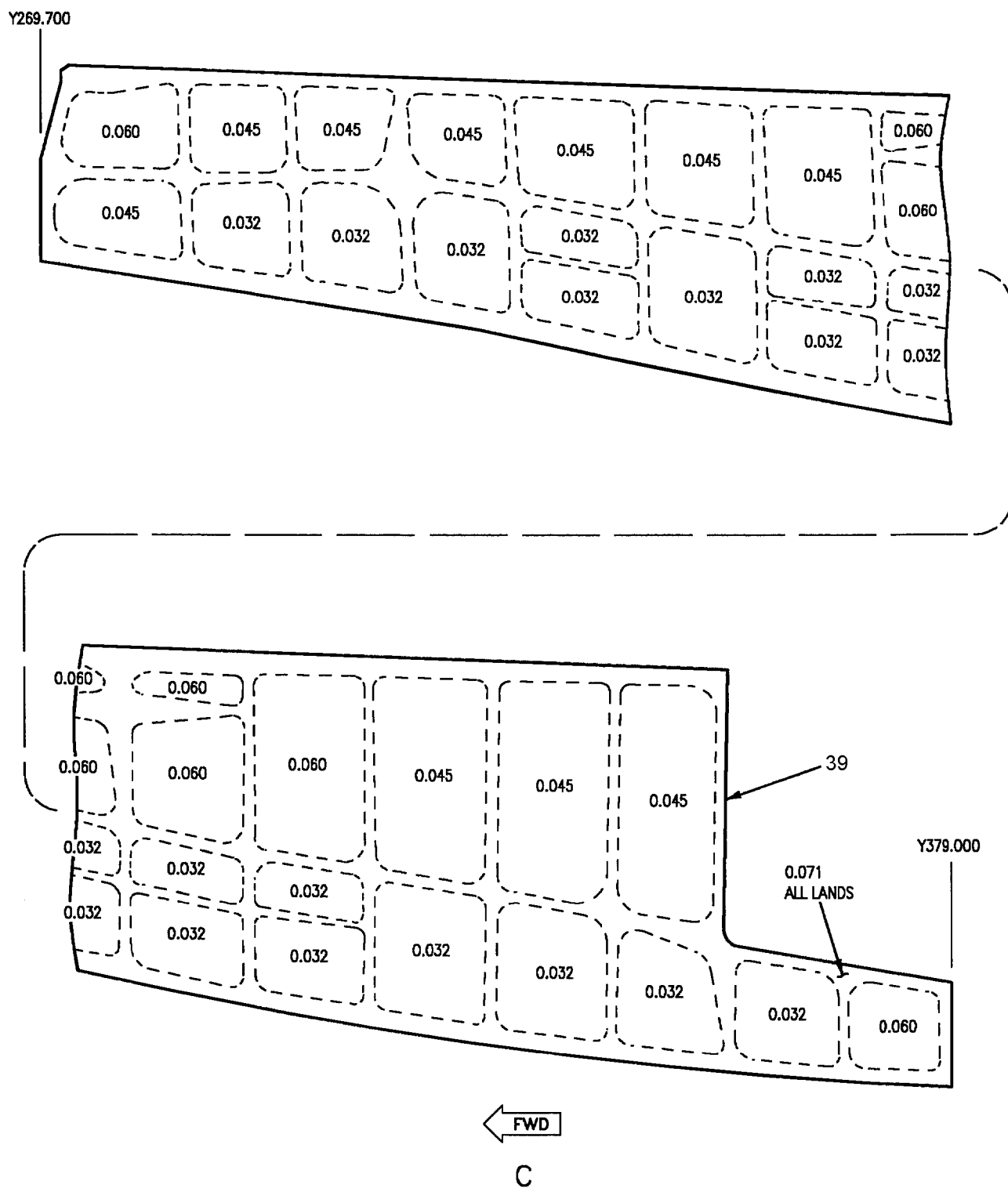


Figure 1. Material Index (Sheet 3)

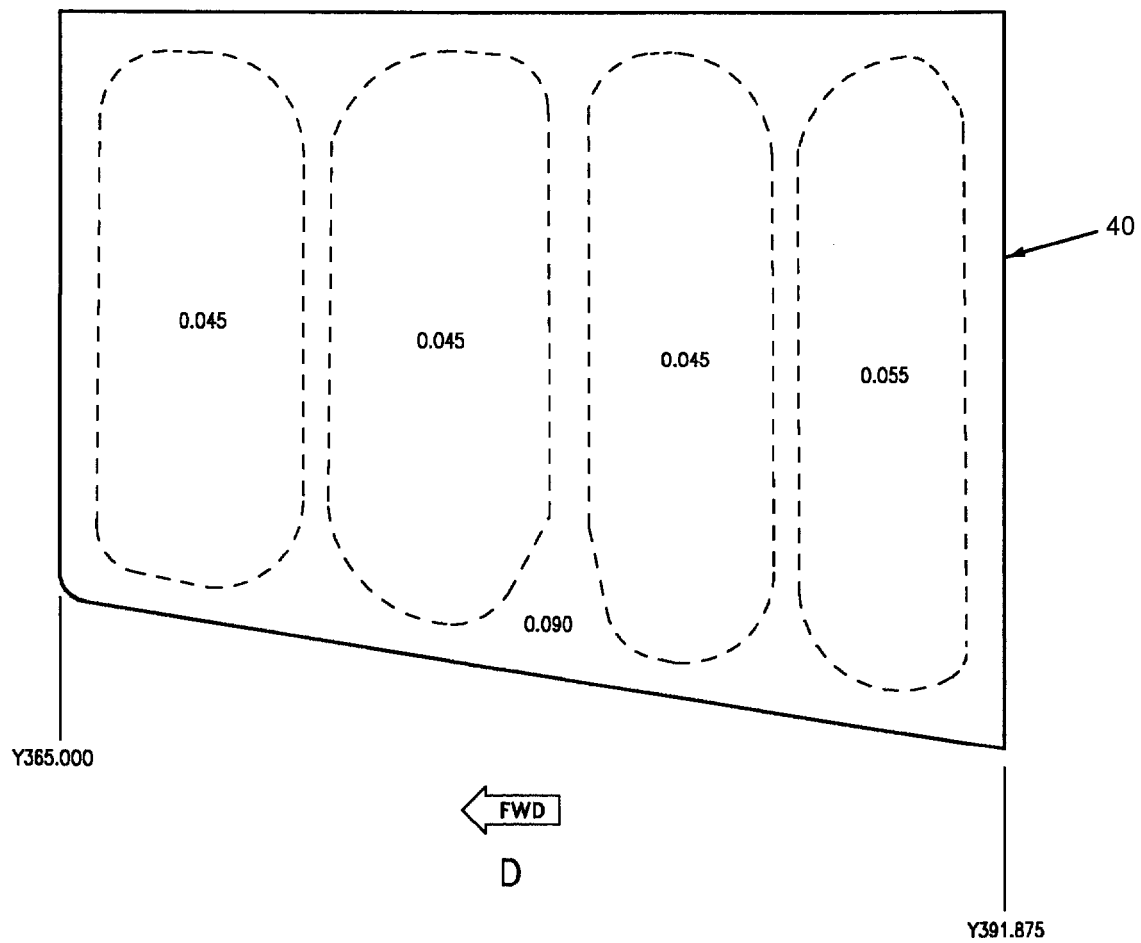


Figure 1. Material Index (Sheet 4)

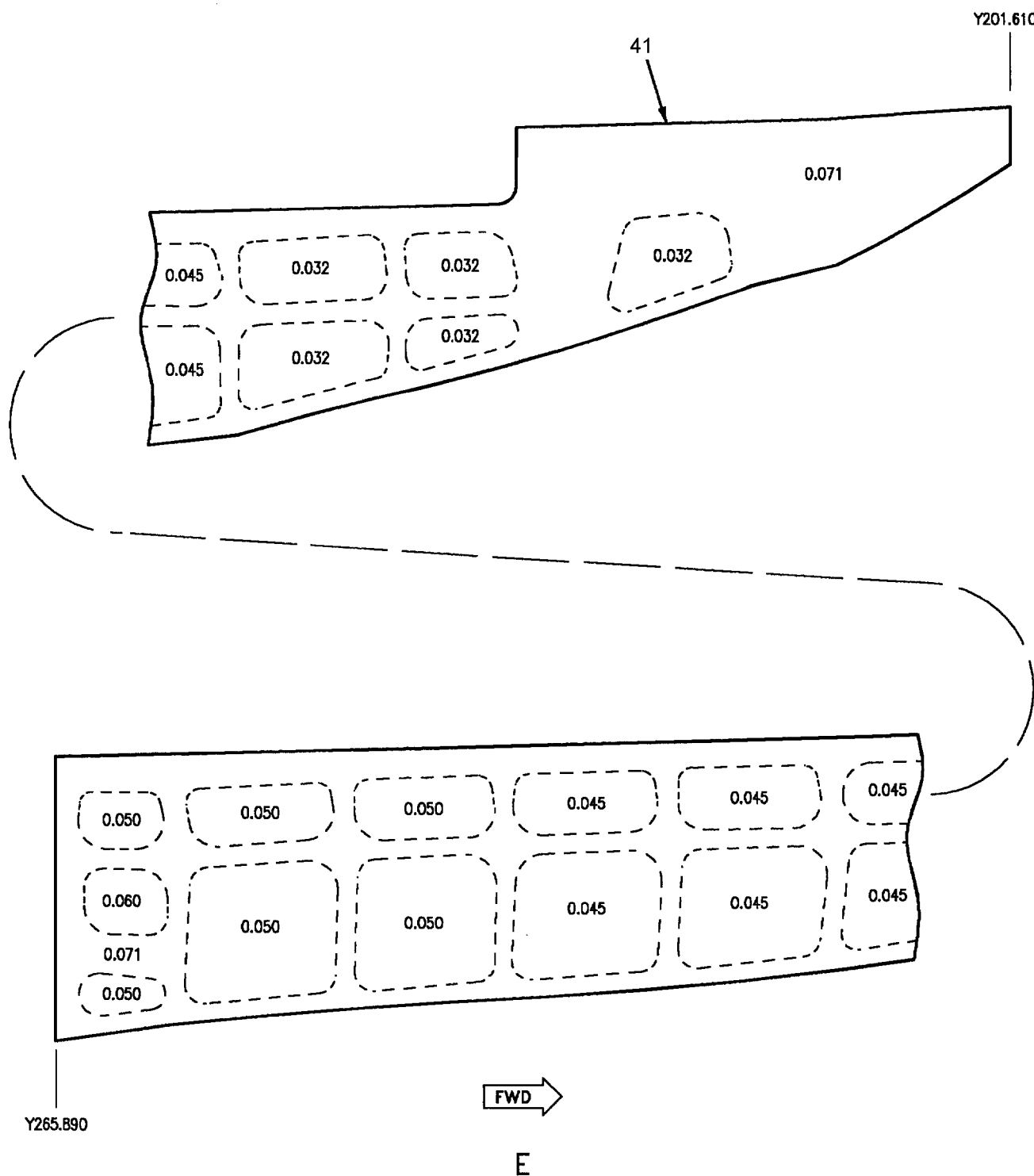


Figure 1. Material Index (Sheet 5)

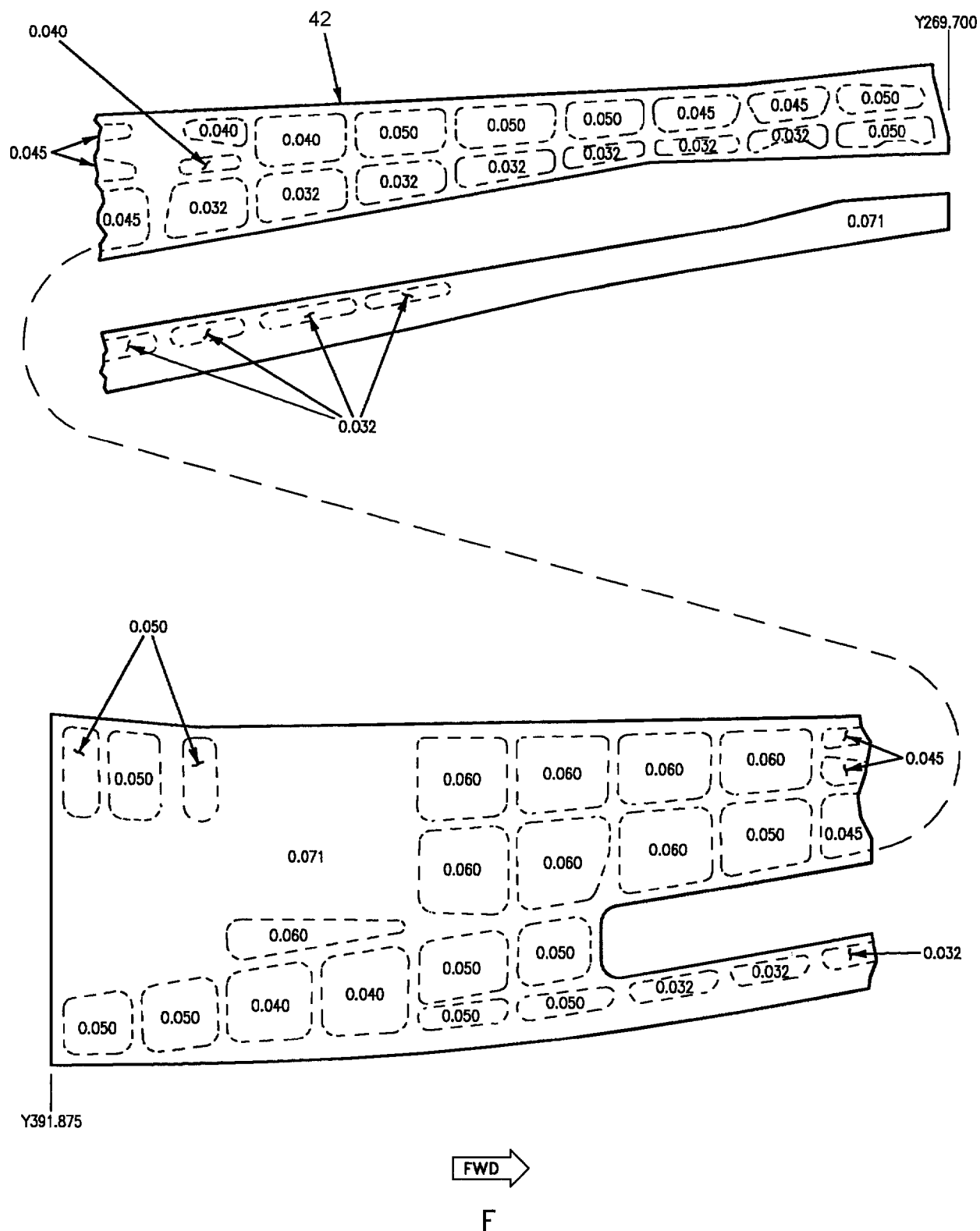


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















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3		Skin 74A200695-2007	0.071 Sheet	7075-T6 Alclad
4		Skin 74T030312-2001	 Sheet	7075-T6 Alclad
5		Skin 74T030361-2073	 Sheet	7075-T6 Alclad
6		Skin 74A200694-2007	 Sheet	7075-T6 Alclad
7		Skin 74A200694-2005	 Sheet	7075-T6 Alclad
8		Skin 74A200694-2003	 Sheet	7075-T6 Alclad
9		Skin 74A200694-2001	 Sheet	7075-T6 Alclad
10		Skin 74T030348-2019	 Sheet	7075-T76 Alclad
11		Skin 74A200723-2005	0.071 Sheet	7075-T76 Alclad
12		Skin 74T030348-2017	 Sheet	7075-T76 Alclad
13		Skin 74T030348-2015	 Sheet	7075-T76 Alclad
14		Skin 74T030348-2013	 Sheet	7075-T76 Alclad
15		Skin 74T030348-2011	 Sheet	7075-T6 Alclad
16	 	Skin 74T030348-2009 74T030348-2061	 Sheet  Sheet	7075-T6 Alclad 7075-T6 Alclad
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Figure 1. Material Index (Sheet 7)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Skin 74T030312-2003	 Sheet	7075-T6 Alclad
20		Skin 74T030312-2005	 Sheet	7075-T6 Alclad
21		Plate 74T030312-2005	2.00 Plate	7075-T7351 Al Aly
22		Skin 74A200723-2007	0.071 Sheet	7075-T6 Alclad
23		Skin 74A200694-2013	 Sheet	7075-T6 Alclad
24		Skin 74A200694-2027	 Sheet	7075-T6 Alclad
25		Skin 74A200694-2011	 Sheet	7075-T6 Alclad
26		Skin 74A200694-2009	 Sheet	7075-T6 Alclad
27		Skin 74A200695-2009	0.071 Sheet	7075-T6 Alclad
28		Skin 74T030312-2007	 Sheet	7075-T6 Alclad
29		Skin 74T030312-2009	 Sheet	7075-T6 Alclad
30		Beam 74A670489-2001	2.50 Plate	7075-T7351 Al Aly
31	 	Skin 74T030348-2023 74T030348-2057	 Sheet	7075-T6 Alclad
32		Skin 74T030348-2003	 Sheet	7075-T6 Alclad
33		Skin 74T030348-2005	 Sheet	7075-T6 Alclad
34	 	Skin 74T030348-2007 74T030348-2063	 Sheet	7075-T6 Alclad
35	 	Skin 74T030348-2001 74T030348-2053	0.071 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 8)





























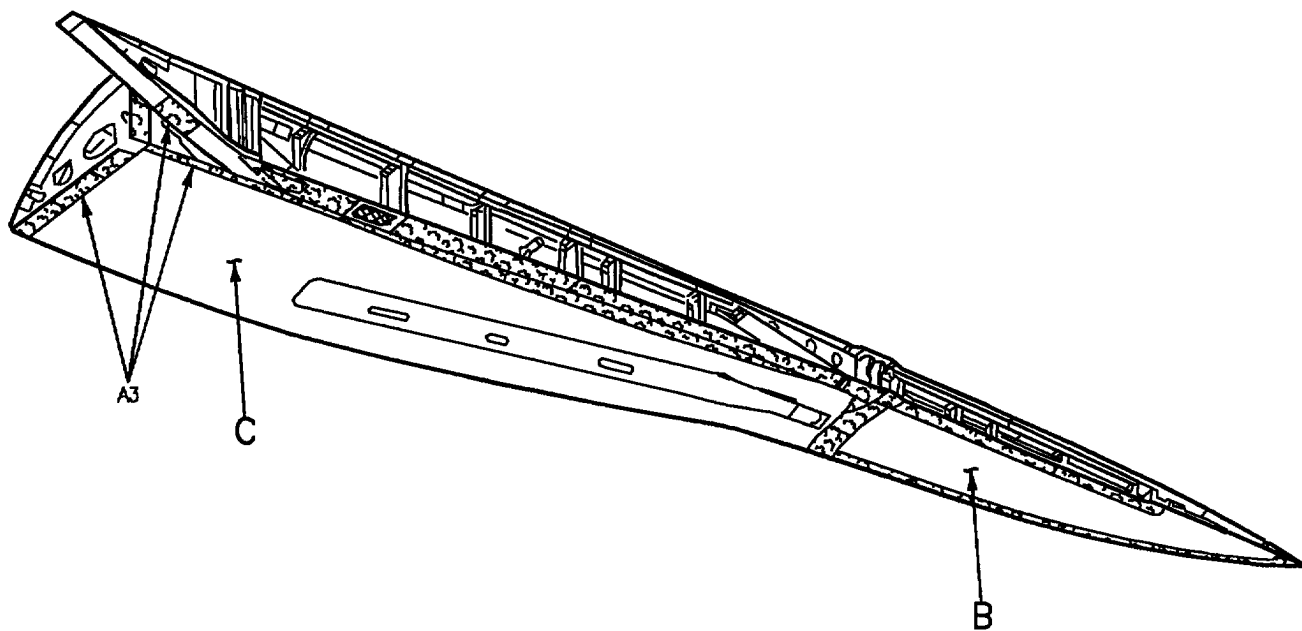
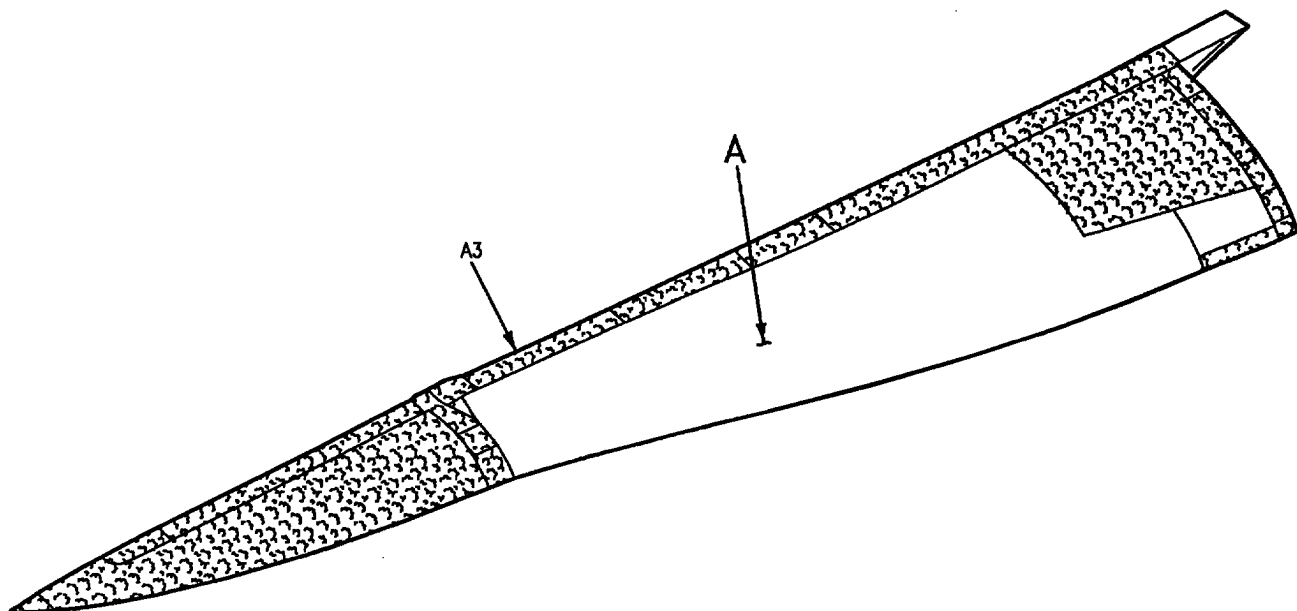
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
36	 8	Skin 74T030348-2021	 2 Sheet	7075-T6 Alclad
37	 10  11	Skin 74A200695-2001 74A200695-2025	0.160 Sheet	7075-T76 Alclad
38	 10  11	Skin 74A200695-2013 74A200695-2027	0.160 Sheet	7075-T76 Alclad
39	 13  14	Skin 74T030334-2001 74T030334-2005	0.071 Sheet	7075-T6 Alclad
40		Cover (Door 22) 74T030333-2013	0.090 Sheet	7075-T6 Alclad
41		Skin 74T030311-2001	0.071 Sheet	7075-T6 Alclad
42	 13  14	Skin 74T030335-2001 74T030335-2005	0.071 Sheet	7075-T6 Alclad
43	 17	Fence 74A201031-2001	1MA10641D05 Extr	7075-T73511 Al Aly
LEGEND				
 1 Lands are 0.071, and bays are 0.045.				
 2 Fastener lands are 0.071, and remaining area is 0.040.				
 3 Lands are 0.071, and bays are 0.032.				
 4 Lands are 0.050, and bays are 0.032.				
 5 Lands are 0.071, and bays are 0.050.				
 6 Fastener lands are 0.090, and remaining areas are 0.040.				
 7 Fastener lands are 0.071, and remaining areas are 0.030.				
 8 161353 THRU 161715.				
 9 161716 AND UP.				
 10 161353 THRU 161519.				
 11 161520 AND UP.				
 12 Fastener lands are 0.071, and remaining area is 0.035.				
 13 161353 THRU 162443.				
 14 162444 AND UP.				
 15 Temporary bolts, NAS674V15 and washers, AN960JD416 installed AFTER F/A-18 AFC 102 to plug attach holes for LEX fence.				
 16 Temporary bolts, NAS675V13 and washers, AN960JD516 installed AFTER F/A-18 AFC 102 to plug attach holes for LEX fence.				
 17 161353 AND UP AFTER F/A-18 AFC 102.				

Figure 1. Material Index (Sheet 9)



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Figure 2. Repair Zones (Sheet 1)

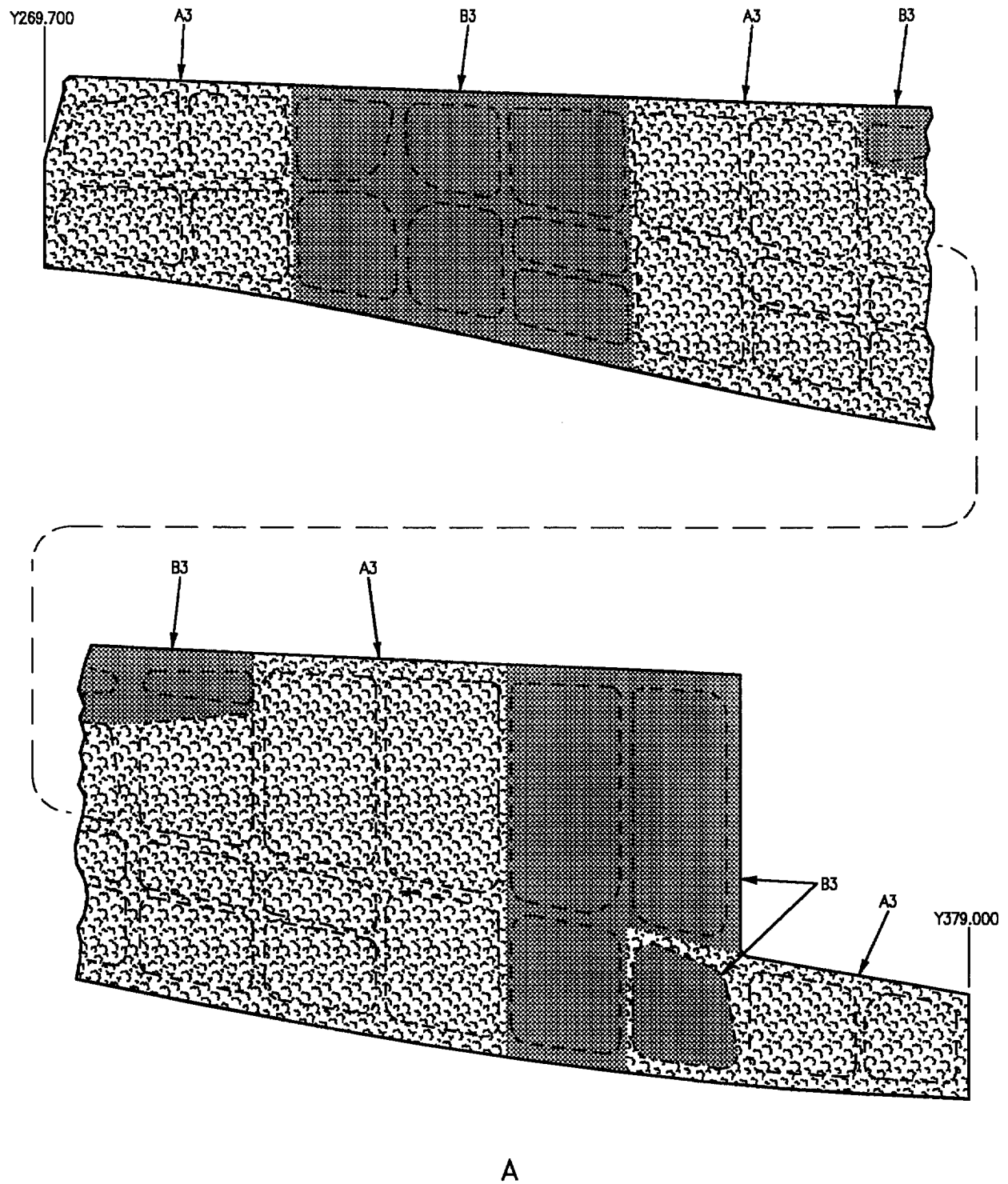


Figure 2. Repair Zones (Sheet 2)

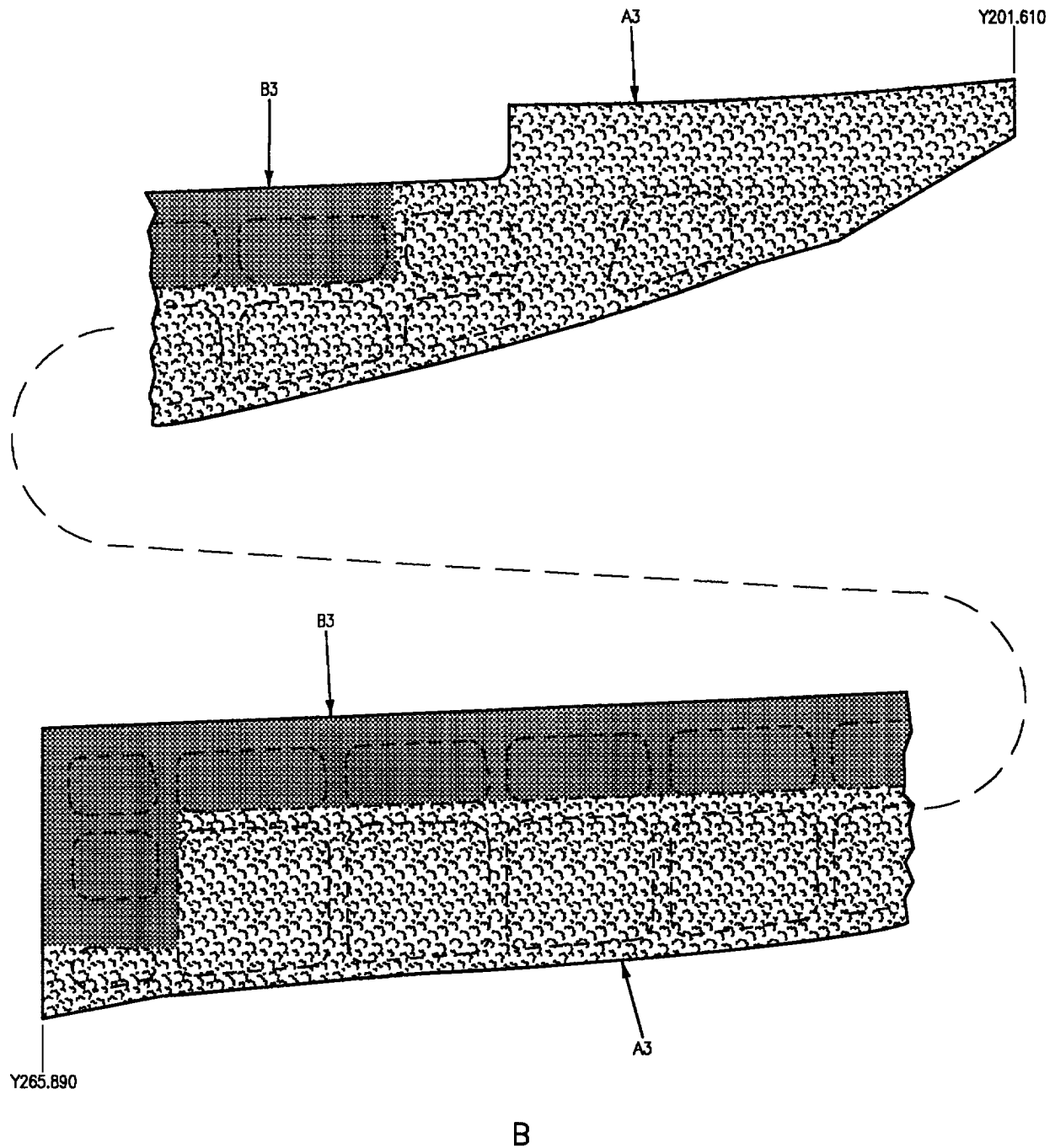


Figure 2. Repair Zones (Sheet 3)

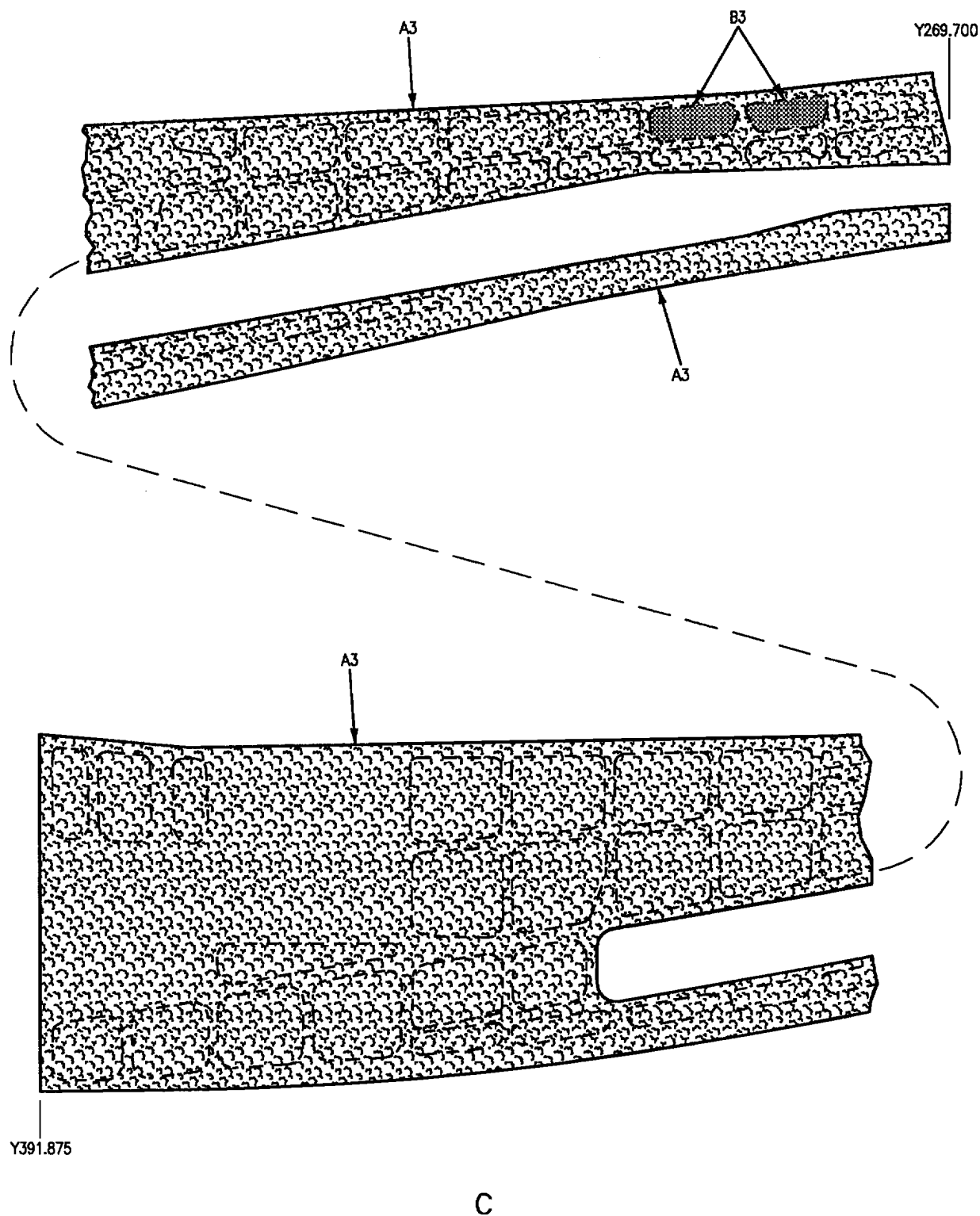


Figure 2. Repair Zones (Sheet 4)

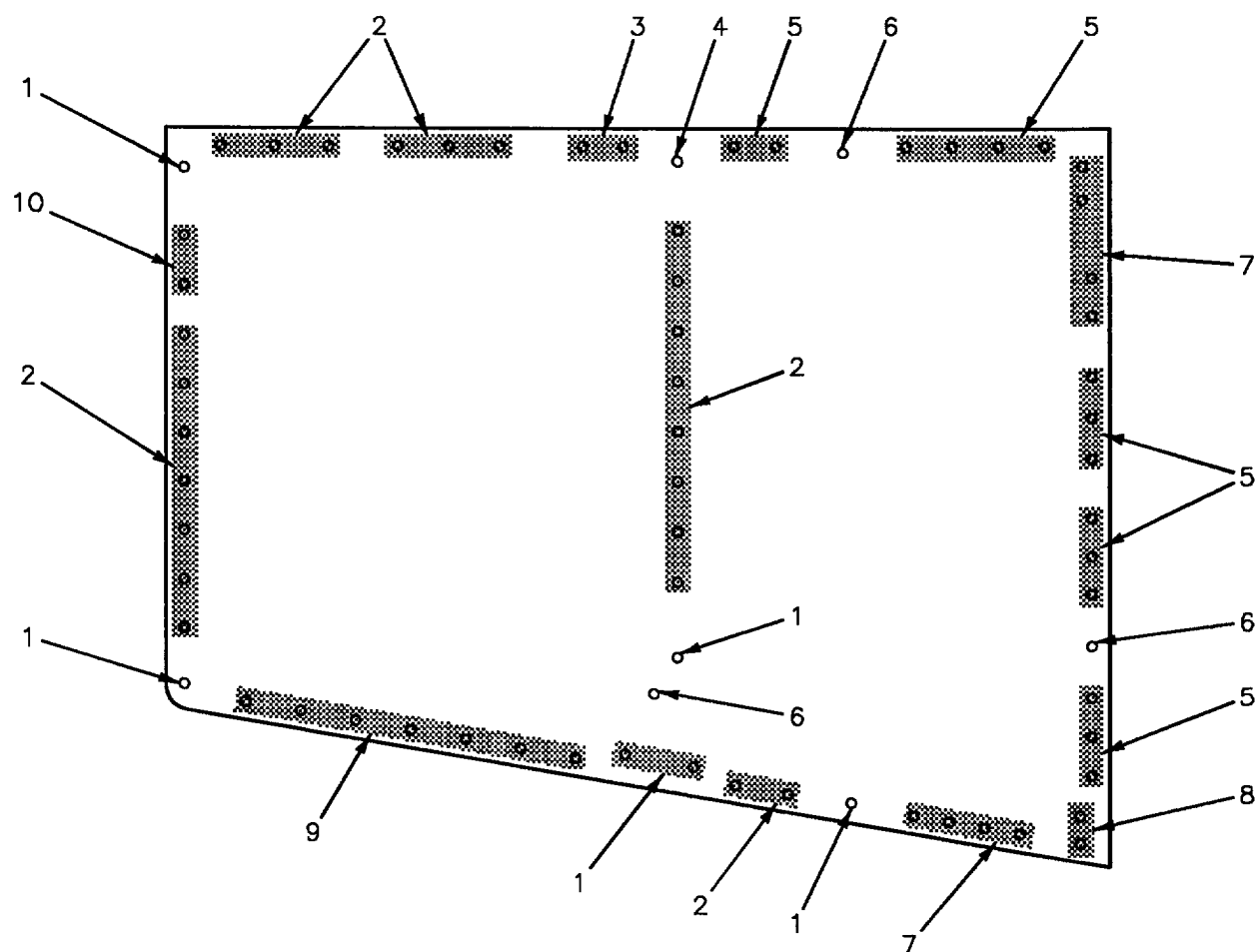


Figure 3. Cover (Door 22) Replacement (Sheet 1)












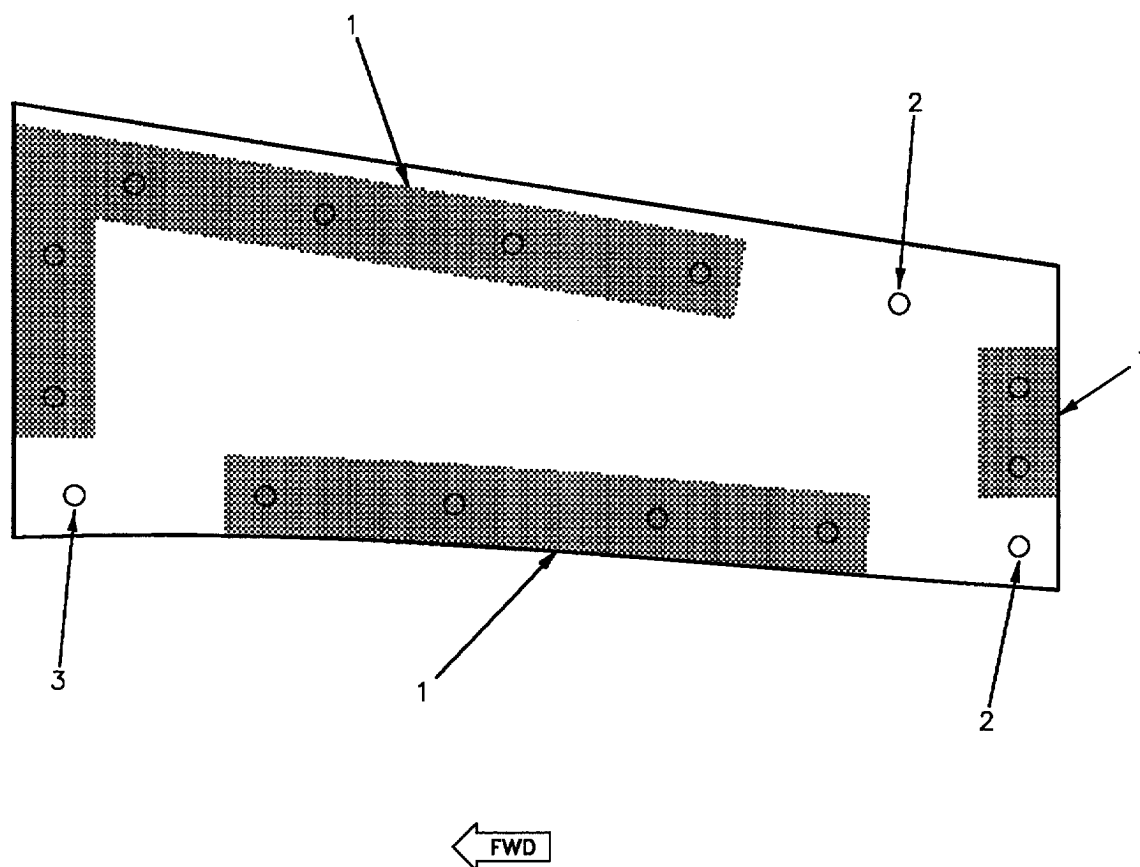
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49249E4-4
2			Gang Channel	G18421JL6-4-12
3			Gang Channel	G18421JL6-4-9
4			Plate Nut	F49249E4-1
5			Gang Channel	G18421JL6-4-10
6			Plate Nut	F49249E4-6
7			Gang Channel	G18421JL4-4-8
8			Gang Channel	G18421JL2-4-8
9			Gang Channel	G18421JL6-4-13
10			Gang Channel	G18421JL6-4-11
LEGEND				
 Hole diameter is 0.255 +0.007 -0.000.				

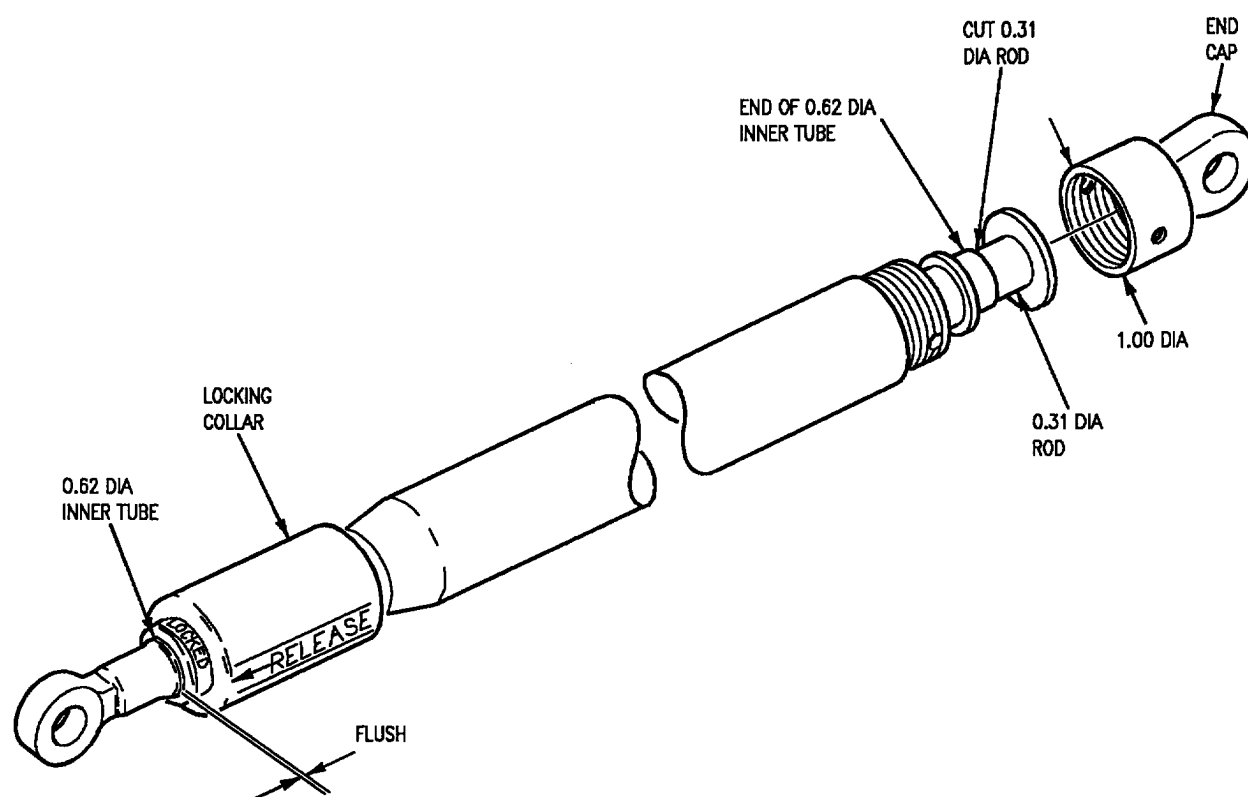
Figure 3. Cover (Door 22) Replacement (Sheet 2)



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IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut	F49249E3-4
2			Plate Nut	F49249E3-1
3			Plate Nut	F49249E3-2
LEGEND				
Hole diameter is 0.195 +0.007 -0.000.				

Figure 4. LEX Position Light Replacement



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Figure 5. Drag Brace, A2641-6 Repair, 161353 THRU 162414

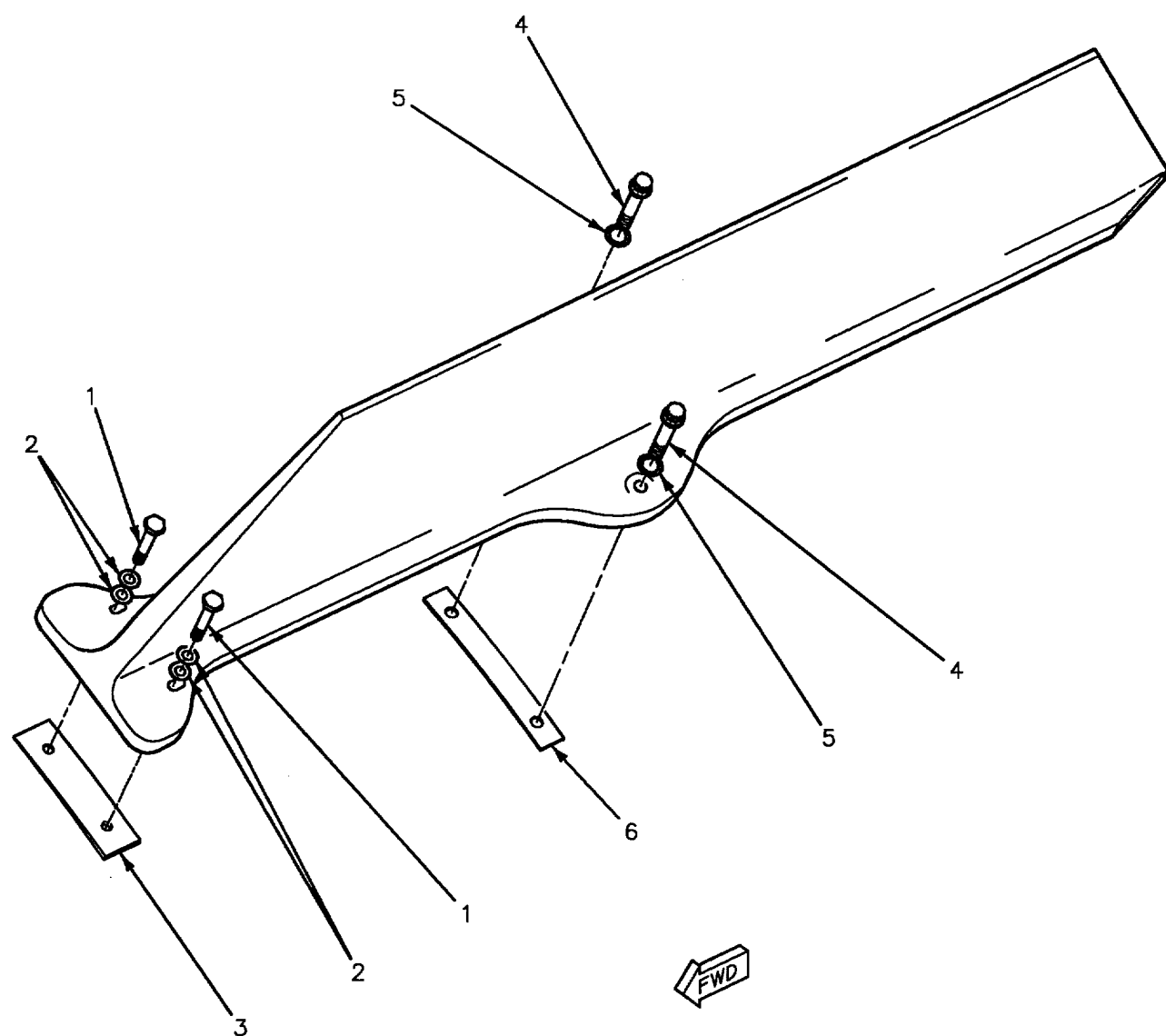


Figure 6. 74A201031 (LEX) Fence Replacement (Sheet 1)







IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Bolt Platenut	NAS674V20H F50339-4-1
2			Washer	AN960C416
3			Spacer	74A201033-2007
4		 	Bolt Barrel Nut Retainer	MB84-5H22 NAS577B5A NAS578-5A
5			Washer	NAS1587-5C
6			Spacer	74A201033-2009
<p style="text-align: center;">LEGEND</p> <p> Four required, two under each head.</p> <p> Fastener attaching hardware.</p>				

Figure 6. 74A201031 (LEX) Fence Replacement (Sheet 2)

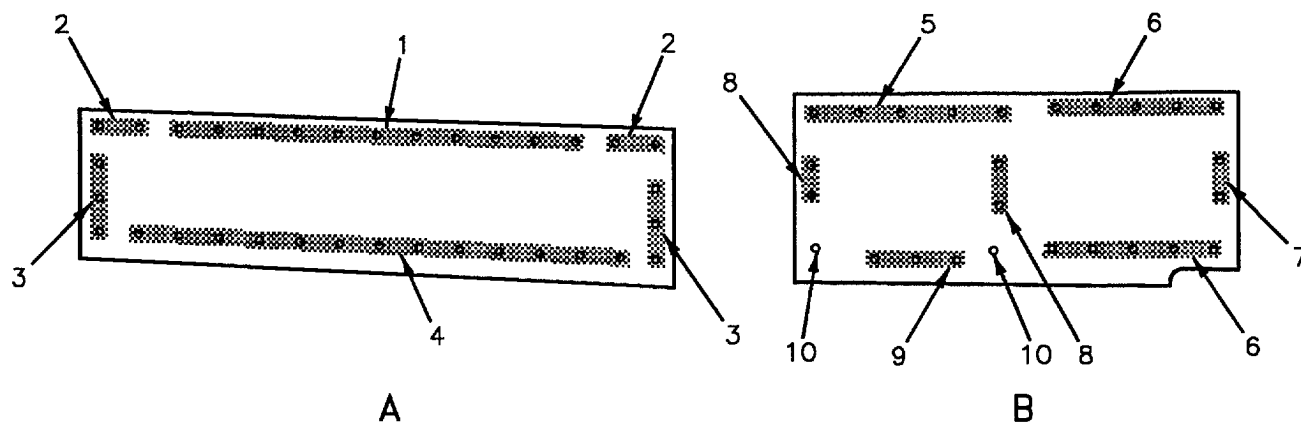
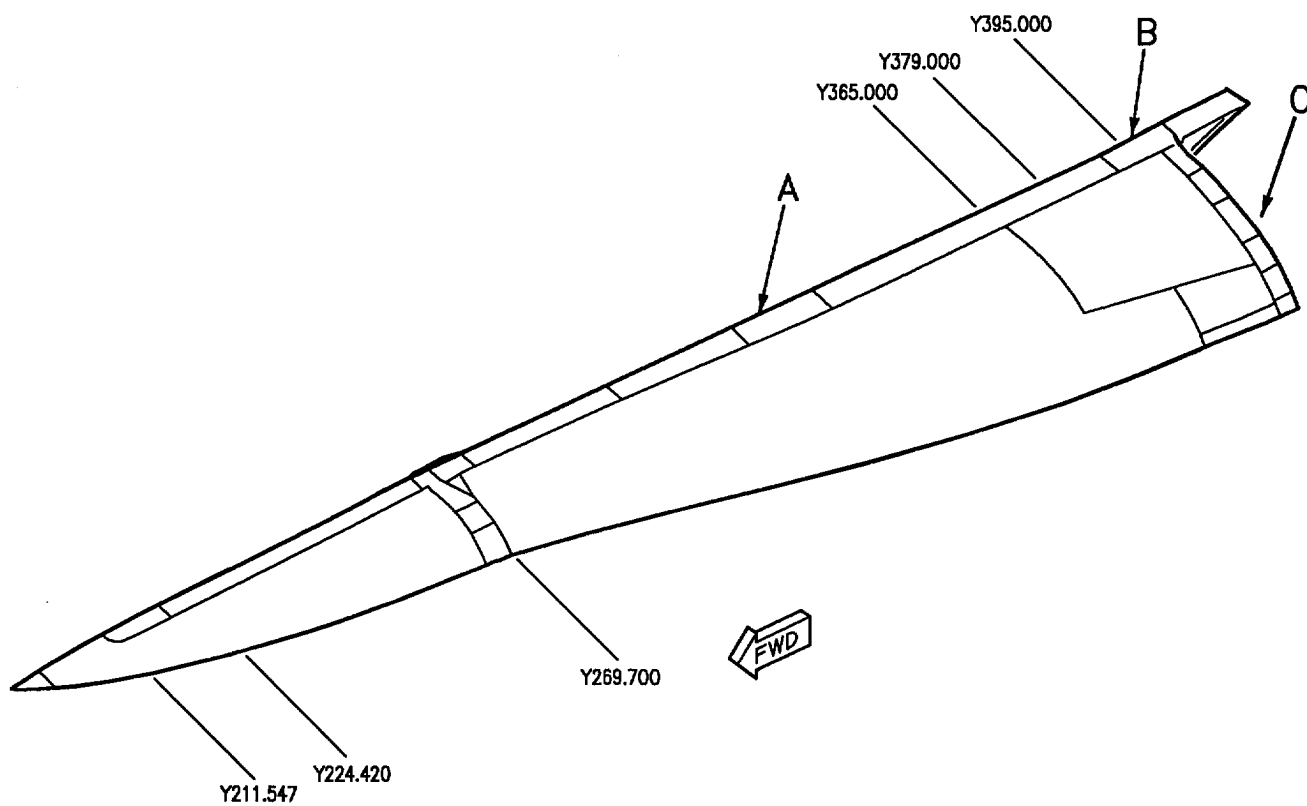
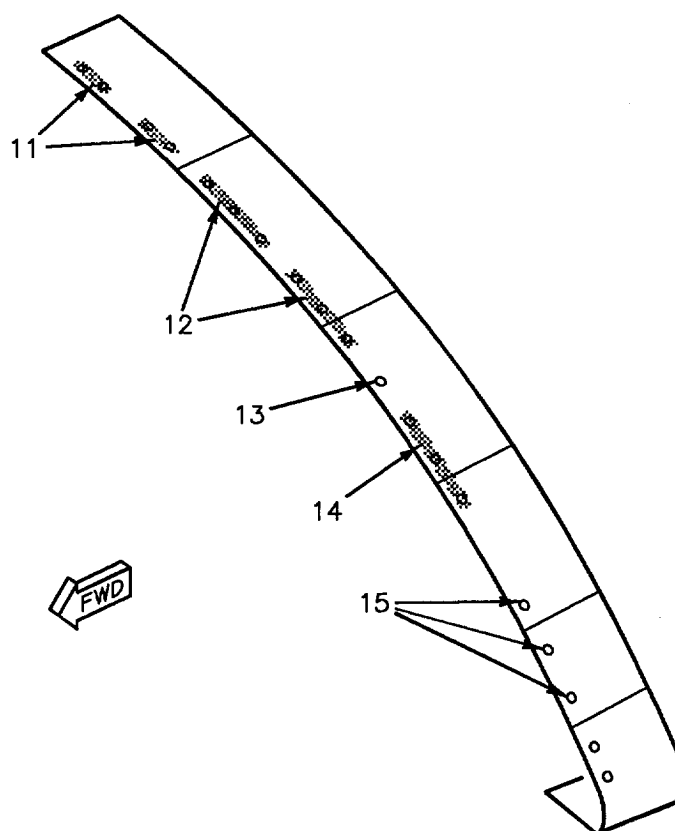


Figure 7. Removable Covers, Replacement (Sheet 1)



C

161716 AND UP

Figure 7. Removable Covers, Replacement (Sheet 2)





















IDX NO.	EFT		NOMENCLATURE	PART NUMBER
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3			Gang Channel	3M463N7A3-3
4			Gang Channel	3M463N8A13-4
5			Gang Channel	3M463N9A5-2
6			Gang Channel	3M463N8A5-2
7			Gang Channel	3M463N7A2-2
8			Gang Channel	3M463N8A2F3
9			Gang Channel	3M463N8A3-3
10			Plate Nut	F49249E3-3
11			Gang Channel	3M463C8A2-3P
12		 	Gang Channel	74T030348-2089
13			Plate Nut	F50339-3-3
14		 	Gang Channel	74T030348-2091
15			Plate Nut	F49249E3-1
LEGEND				
 Make from 3M463C10A3-3P Gang Channel.				
 Hole diameter is 0.191 +0.006 -0.000.				
 Hole diameter is 0.195 +0.007 -0.000.				

Figure 7. Removable Covers, Replacement (Sheet 3)

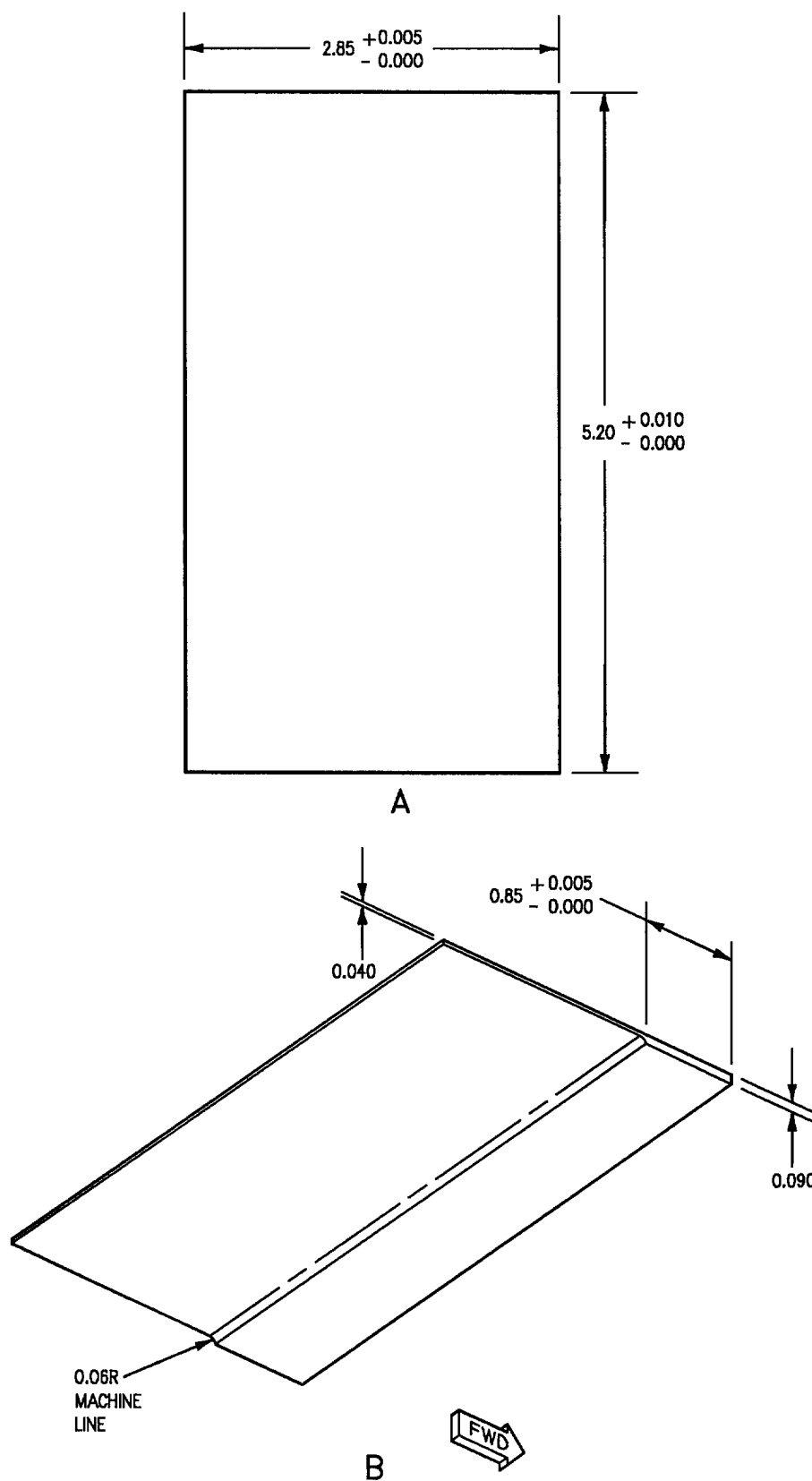


Figure 8. Replacement, Skin, 74T030348 (Sheet 1)

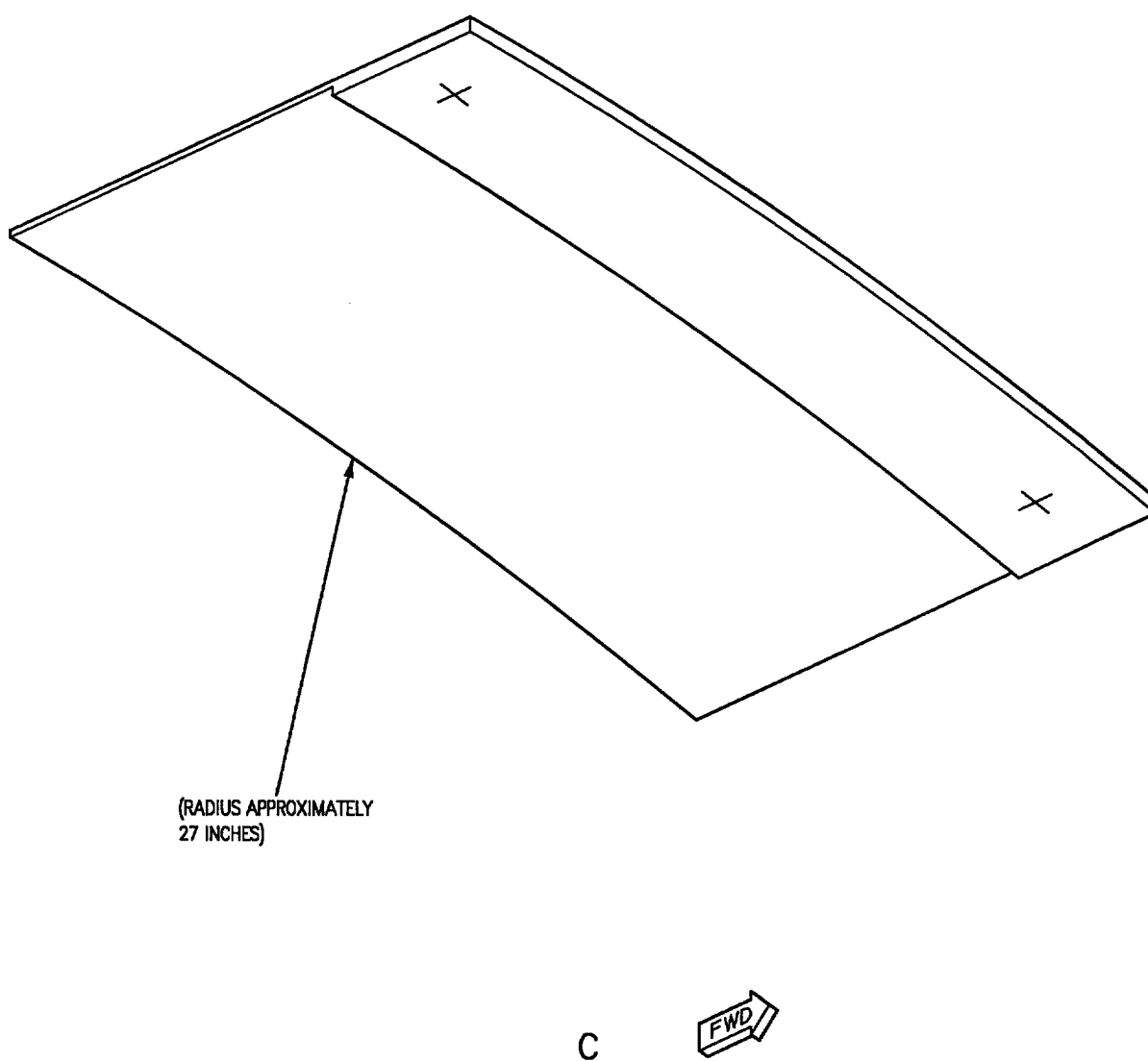


Figure 8. Replacement, Skin, 74T030348 (Sheet 2)

ORGANIZATIONAL MAINTENANCE
STRUCTURE REPAIR**RIGHT LEADING EDGE EXTENSION SKINS AND DOORS**

Reference Material

Aircraft Corrosion Control	A1-F18AC-SRM-500
Form In Place Sealing	WP010 00
Forward Fuselage Main Structure Assembly Finish System and Markings	WP024 00
Priming Procedures	WP011 00
Aircraft Weapons Systems Cleaning and Corrosion Control	NAVAIR 01-1A-509
Structure Illustrated Parts Breakdown, Forward Fuselage	A1-F18AC-SRM-420
Skin, Aircraft-Aft, Closure, LE Ext, Instl of	FIG 048 00
Structure Assembly - Aft, Leading Edge Extension, RH	FIG 051 00
Structure Repair, General Information	A1-F18AC-SRM-200
Introduction	WP002 00
Gang Channel and Plate Nut Identification and Repair	WP004 05
Shop Practices - Forming Sheet Metal	WP004 01
Shop Practices - Locating Blind Holes and Trim Lines	WP004 03
Structure Repair, Typical Repair	WP004 05
Aluminum Patch Fabrication	WP006 01
Aluminum, Graphite Epoxy, or Titanium Patch Installation and Removal	WP007 00
Aluminum Sheet, Free of Structure and Land Areas	WP031 00
Aluminum Sheet Edge Repair	WP031 00
Aluminum Sheet Repairs, Across Structure and Lands	WP036 00
Blending	WP038 00
Aluminum and Titanium Sheet, Formed Structure	WP033 00
Exterior Lighting System	A1-F18AC-440-300
LEX Position Light	WP005 00

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Repairable Damage	2
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Permanent Repairs	3
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Dents	4
Edge	4
Holes	3
Scratches, Nicks, Gouges, or Corrosion	3

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LEX Position Light (7DSM008)	5
Removable Covers	5
Skin, 74T030348-2013	6

Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F/A-18 AFC 102	-	Leading Edge Extension Fence, Installation of (ECP MDA-F/A-18-00300)	15 Apr 88	-

Support Equipment Required

None

Materials Required

None

1. **DAMAGE EVALUATION.** See figures 1 and 2.

2. Damage is classified as negligible and repairable. Locating and determining size of damage by visual method is organizational maintenance. The types of materials used are shown on figure 1. Repair zones are shown on figure 2. Allowable damage limits within repair zones are listed in tables 1 and 2. Damage not listed or exceeding the following limits require depot engineering disposition.

3. **NEGLIGIBLE DAMAGE.** Negligible damage is damage that may be allowed to exist as is. However, preventive maintenance, for temporary corrosion arrestment, should be done to scratches (NAVAIR 01-1A-509). The types and limits of damage are listed below and in table 1. The figure and index numbers in table 1 coincide with the figure and index numbers in the material index.

a. Scratches are not allowed within one diameter from the edge of any hole.

b. Smooth dents only, effective diameter at least 20 times the depth.

4. **REPAIRABLE DAMAGE.** The types and limits of damage are listed below and in table 2. The figure and index numbers in table 2 coincide with figure and index numbers in the material index, figure 1.

NOTE

The limits in table 2 apply after blending the damage.

a. Scratches.

(1) Any scratches within one diameter of any hole must be blended out. Minimum blend out is one diameter from edge of any hole.

(2) Scratches to be blended out with diameter, or width, at surface at least 20 times the depth.

b. Nicks, gouges, and corrosion to be blended out with diameter, or width, at surface at least 20 times the depth.

c. Cracks. All cracks must be repaired.

d. Holes.

(1) Damage in areas free of structure and lands must have edge of cleanup hole at last eight repair fastener diameters from any land, internal structure, or existing row of fasteners.

(2) Damage to lands, over structure, only one repair per land.

e. Dents exceeding the limits in table 1 must be repaired.

5. REPAIRS.

6. Types of repairs are temporary, one-time flight, permanent, critical area, alternate, and typical. Repair type definitions are in structure repair terms (A1-F18AC-SRM-200, WP002 00).

7. PERMANENT REPAIRS.

8. Scratches, Nicks, Gouges, or Corrosion.

Blend scratches, nicks, gouges or corrosion (A1-F18AC-SRM-250, WP038 00). If, after blending, the damage limits of table 2 are exceeded, repair aluminum as below. Refinish blended areas (A1-F18AC-SRM-500, WP024 00).

a. Scratches - make crack or edge repair.

b. Nicks, gouges or corrosion - make hole or edge repair.

9. Cracks.

a. In repair zone A3 repair cracks free of structure or land areas in aluminum (A1-F18AC-SRM-250, WP031 00).

(1) Rout out crack.

(2) Install a lap patch for cracks.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair cracks free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out crack in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3 repair cracks across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay,
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3 repair cracks to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

10. Holes.

a. In repair zone A3 repair holes free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) Install a type one flush or lap patch.

(3) Refinish repaired areas (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair holes free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3 repair holes across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Lands; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge of Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3, repair holes to aluminum formed structure (A1-F18AC-SRM-250, WP033 00).

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

11. Edge. In repair zone A3 repair edge damage in aluminum sheet (A1-F18AC-SRM-250, WP034 00).

a. Cut out damage.

b. Select and install repair patch as below:

(1) Corner Damage to Lands.

(2) Corner Damage to Lands and Bays.

(3) Edge Damage to Lands.

(4) Edge Damage to Lands and Bays.

(5) Full Width Damage to End.

c. Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

12. Dents.

a. In repair zone A3 repair dents free of structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP031 00).

(1) Cut out damage.

(2) Install a type one flush or lap patch.

(3) Refinish repaired areas (A1-F18AC-SRM-500, WP024 00).

b. In repair zone B3, repair dents free of structure or land areas in aluminum sheet (0.050 inch thickness or less).

(1) Completely cut out damage in the smallest diameter circle possible.

(2) Fabricate patch (A1-F18AC-SRM-250, WP006 01).

(3) Install patch using FM300 Adhesive (A1-F18AC-SRM-250, WP007 00).

(4) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

c. In repair zone A3, repair dents across structure or land areas in aluminum sheet (A1-F18AC-SRM-250, WP036 00).

(1) Cut out damage.

(2) Make repairs.

(a) Damage to Bay Requiring Repair
A cross Land; install flush or lap patch.

(b) Damage to Bay Requiring Repair
A cross Land and Edge or Part; install flush or lap patch.

(c) Damage to Land or Land and Bay;
install flush or lap patch.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

d. In repair zone A3, repair dents to aluminum formed structure (A1-F18AC-SRM-250, WP033 00) as below:

(1) Cut out damage.

(2) Install repair one through six. Select the repair that can be adapted to the damaged part.

(3) Refinish repaired area (A1-F18AC-SRM-500, WP024 00).

13. REPLACEMENT.

14. Fastener attaching hardware is shown for covers and position light. For form in place sealing (A1-F18AC-SRM-500, WP010 00). For replacement rivets attaching platenuts, gang channels and receptacles not shown in figures 3 through 5 and 7 (A1-F18AC-200, WP004 05).

15. COVER (DOOR 23). Cover is interchangeable. Fastener attaching hardware is shown on figure 3. For fasteners (A1-F18AC-SRM-420, FIG 051 00).

16. COVER (DOOR 123). Cover is interchangeable. Fastener attaching hardware is shown on figure 4. For fasteners (A1-F18AC-SRM-420, FIG 051 00).

17. COVER (DOOR 127). Cover is interchangeable. Fastener attaching hardware is shown on figure 5. For fasteners (A1-F18AC-SRM-420, FIG 051 00).

18. LEX POSITION LIGHT (7DSM008). Fastener attaching hardware is shown on figure 7. For fasteners and part information (A1-F18AC-440-300, WP005 00).

19. REMOVABLE COVERS. Fastener attaching hardware is shown on figure 8, for fasteners (A1-F18AC-SRM-420, FIG 048 00).

20. LEADING EDGE EXTENSION (LEX) FENCE. See figure 6.

21. Any damage to the LEX fence requires a depot engineering disposition.

22. Removal. Lex fence is interchangeable. Fastener attaching hardware and fasteners are shown on figure 6.

NOTE

Tag all fasteners when removed to ensure that the same fasteners are installed into proper hole.

a. Retain as applicable, 74R200006-2007, 74A201033-2009, and 74A201033-2035 spacers. If spacers are damaged on removal, replace spacers.

23. Installation. See figure 6.

Support Equipment Required

Part Number or Type Designation	Nomenclature
-	Torque Wrench, 0 to 300 Inch Pounds

Materials Required

Specification or Part Number	Nomenclature
M20995N40	Lockwire
MS20995NC51	Wire, Nonelectrical
MIL-C-16173, GRADE 3	Corrosion Preventative Compound
MIL-S-83430, B-2	Sealing Compound



Sealing Compound, MIL-S-83430, Class B-2 22

a. Apply sealing compound to faying surfaces of spacer and fence prior to installation of fence. For sealant (A1-F18AC-SRM-200, WP 011 00).

b. Position 74A201033-2035, 74A201033-2009 or 74R200006-2007 spacers and 74A201031-2005 fence in place.

c. Install fasteners as follows:



Corrosion Preventative Compound, 23
MIL-C-16173, Grade 3

(1) Apply corrosion preventative compound to shank and threads of attach fasteners.

(2) Install two NAS674V20H bolts and four AN960C416 washers (two under each bolt head) in forward attach points.

(3) Install two ST3M571-5H22 bolts and two NAS1587-5C washers (one under each bolt head) in aft attach points.

d. Tighten NAS674V20H bolts at forward attach points, 50-70 inch-pounds torque and safety with MS20995N40 lockwire.

e. Tighten ST3M571-5H22 bolts, at aft attach points, 100-140 inch-pounds torque, and safety with MS20995NC51 lockwire.

f. Apply a continuous film of sealing compound to encapsulate each fastener head (A1-F18AC-SRM-200, WP011 00).

g. Touch up bolt heads (A1-F18AC-SRM-500, WP024 00)

24. **SKIN, 74T030348-2035, REPLACEMENT.** See figure 9. Replacement of damaged or missing skin requires fabrication of new skin at intermediate maintenance.

Procedures for removal, installation, drilling and application of finish systems is organizational maintenance.

Support Equipment Required

None

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Scraper, Formica Cheesecloth
■ TT-I-735 H-B-643, TYPE 2, CLASS 1, SIZE 1	Isopropyl Alcohol Acid Swab Brush
MIL-S-81733 CLASS 1-1/2	Sealing Compound
7075-T6 Alclad 0.071 Thick	Skin

a. Remove two fasteners attaching damaged skin to LEX.

b. Remove sealant from area where skin was removed using nonmetallic scraper.



Isopropyl Alcohol, TT-I-735

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c. Remove residual sealant using clean cheesecloth moistened with isopropyl alcohol.

d. Apply finish system as required to bare aluminum surface with acid brush (A1-F18AC-SRM-500, WP024 00).

e. Fabricate new skin per substeps below:

(1) Cut a 5.20 +0.010 -0.000 by 2.85 +0.005 -0.000 inch rectangular skin section from 0.71 inch thick 7075-T6 alclad aluminum sheet, see detail A.

(2) Machine material to thickness shown on detail B (A1-F18AC-SRM-200, WP004 01).

(3) Form material to contour requirements shown in detail C (A1-F18AC-SRM-200, WP004 01).

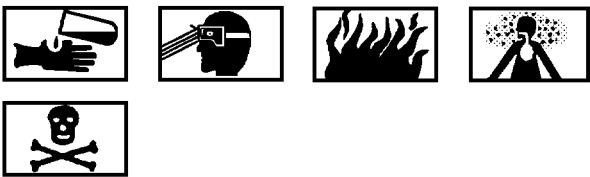
(4) Remove all sharp edges.

f. Mate new LEX skin with structure and trim as necessary to fit with a gap tolerance of 0.005 to 0.060 inch, (A1-F18AC-SRM-200, WP004 03).

g. Locate and drill 0.195 +0.007 -0.000 holes in skin. Countersink holes to flushness requirements of fasteners, see detail C (A1-F18AC-SRM-200, WP004 03).

h. Prime skin surfaces. (A1-F18AC-SRM-500, WP011 00).

i. Apply finish system (A1-F18AC-SRM-500, WP024 00).



Sealing Compound, MIL-S-81733, Class 1-1/2

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j. Fay seal LEX skin. For sealing compound preparation and application (A1-F18AC-SRM-200, WP011 00).

k. Install LEX skin. For fasteners see (A1-F18AC-SRM-420, WP048 00).

l. Touch up finish system as required (A1-F18AC-SRM-500, WP024 00).

Table 1. Negligible Damage Limits























Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (1)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (2)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (3)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (4)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (5)	Skin Zone A3	0.032	0.002	0.002	100%	0.016	
		0.050	0.002	0.002	100%		10%
Fig 1 (6)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (7)	Skin Zone A3	0.071	0.002	0.002	100%		10%
Fig 1 (8)	Skin Zone A3	0.090	0.002	0.002	100%		10%
Fig 1 (9)	Leading Edge Zone A3	2.00	0.002	0.002	100%		10%
Fig 1 (10)	Skin Zone A3	0.045	0.002	0.002	100%	0.022	
		0.071	0.002	0.002	100%		10%
Fig 1 (11)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (12)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (15)	Skin Zone A3	0.071	0.002	0.002	100%		10%

Table 1. Negligible Damage Limits (Continued)
























Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (16)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (17)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (18)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (19)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (20)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (21)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (22)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (23)	Skin Zone A3	0.040	0.002	0.002	100%	0.020	
		0.071	0.002	0.002	100%		10%
Fig 1 (24)	Skin Zone A3	0.030	0.002	0.002	100%	0.015	
		0.071	0.002	0.002	100%		10%
Fig 1 (25)	Skin Zone A3	0.030	0.002	0.002	100%	0.015	
		0.071	0.002	0.002	100%		10%
Fig 1 (26)	Skin Zone A3	0.030	0.002	0.002	100%	0.015	
		0.071	0.002	0.002	100%		10%
Fig 1 (27)	Skin Zone A3	0.071	0.002	0.002	100%		10%

Table 1. Negligible Damage Limits (Continued)































Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (28)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (29)	Skin Zone A3	0.050	0.002	0.002	100%	0.025	
		0.071	0.002	0.002	100%		10%
Fig 1 (30)	Skin Zone B3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (31)	Skin Zone B3	0.030	0.006	0.0006	100%	0.015	
		0.071	0.014	0.0006	100%		10%
Fig 1 (32)	Skin Zone A3	0.071	0.002	0.002	100%		10%
Fig 1 (33)	Skin Zone A3	0.042	0.002	0.002	100%	0.020	
		0.070	0.002	0.002	100%		10%
		0.090	0.002	0.002	100%	0.045	
		0.160	0.002	0.002	100%		10%
Fig 1 (34)	Skin Zone A3	0.032	0.002	0.002	100%	0.016	
		0.045	0.002	0.002	100%	0.022	
		0.055	0.002	0.002	100%	0.027	
		0.071	0.002	0.002	100%		10%
	Zone B3	0.060	0.0006	0.0006	100%	0.030	
		0.071	0.0006	0.0006	100%		10%
Fig 1 (35)	Skin Zone A3	0.032	0.002	0.002	100%	0.016	
		0.040	0.002	0.002	100%	0.020	
		0.045	0.002	0.002	100%	0.022	
		0.050	0.002	0.002	100%	0.025	
		0.060	0.002	0.002	100%	0.030	
		0.071	0.002	0.002	100%		10%
	Zone B3	0.040	0.0006	0.0006	100%	0.020	
		0.045	0.0006	0.0006	100%	0.022	
		0.050	0.0006	0.0006	100%	0.025	
		0.060	0.0006	0.0006	100%	0.030	
		0.071	0.0006	0.0006	100%		10%

Table 1. Negligible Damage Limits (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Dents Depth	Rivet Tilt
				Depth	Area		
Fig 1 (36)	Skin Zone A3	0.042	0.002	0.002	100%	0.020	10%
		0.070	0.002	0.002	100%	<div><div>1</div></div>	10%
		0.090	0.002	0.002	100%	0.045	10%
		0.160	0.002	0.002	100%	<div><div>1</div></div>	10%
Fig 1 (37)	Skin Zone A3	0.032	0.002	0.0006	100%	0.016	<div><div>1</div></div>
		0.045	0.002	0.0006	100%	0.022	<div><div>1</div></div>
		0.050	0.002	0.0006	100%	0.025	<div><div>1</div></div>
		0.071	0.002	0.0006	100%	<div><div>1</div></div>	10%
	Zone B3	0.032	0.0006	0.0006	100%	0.016	<div><div>1</div></div>
		0.045	0.0006	0.0006	100%	0.022	<div><div>1</div></div>
		0.050	0.0006	0.0006	100%	0.025	<div><div>1</div></div>
		0.060	0.0006	0.0006	100%	0.030	<div><div>1</div></div>
		0.071	0.0006	0.0006	100%	<div><div>1</div></div>	10%

1

None allowed.

Table 2. Repairable Damage Limits After Blending

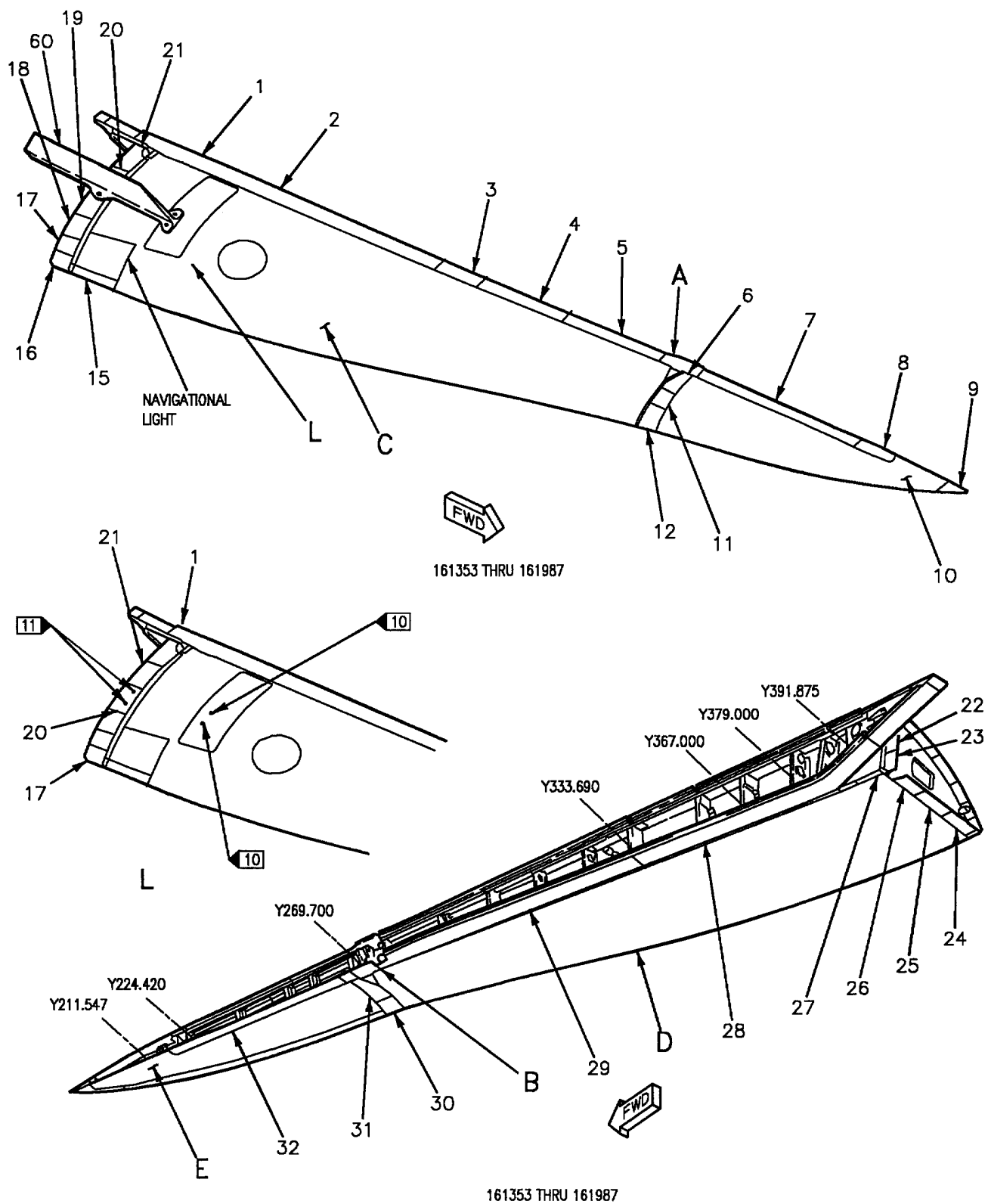
Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (1)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (2)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (3)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (4)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (5)	Skin Zone A3	0.032	0.006	0.006	100%	0.006	100%
		0.050	0.010	0.010	100%	0.010	100%
Fig 1 (6)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (7)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%
Fig 1 (8)	Skin Zone A3	0.090	0.018	0.018	100%	0.018	100%
Fig 1 (9)	Leading Edge Zone A3	2.00	0.040	0.040	100%	0.040	100%
Fig 1 (10)	Skin Zone A3	0.045	0.009	0.009	50%	0.009	50%
		0.071	0.014	0.014	50%	0.014	50%
Fig 1 (11)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (12)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (15)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%

Table 2. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (16)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (17)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (18)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (19)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (20)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (21)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.008	100%
Fig 1 (22)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (23)	Skin Zone A3	0.040	0.008	0.008	100%	0.008	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (24)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (25)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (26)	Skin Zone A3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (27)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%

Table 2. Repairable Damage Limits After Blending (Continued)

Fig No Idx No	Nomen/ Repair Zone	Thickness	Scratch Depth	Nicks Gouges		Corrosion	
				Depth	Area	Depth	Area
Fig 1 (28)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (29)	Skin Zone A3	0.050	0.010	0.010	100%	0.010	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (30)	Skin Zone B3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (31)	Skin Zone B3	0.030	0.006	0.006	100%	0.006	100%
		0.071	0.014	0.014	100%	0.014	100%
Fig 1 (32)	Skin Zone A3	0.071	0.014	0.014	100%	0.014	100%
Fig 1 (33)	Skin Zone A3	0.042	0.009	0.009	100%	0.009	100%
		0.070	0.014	0.014	100%	0.014	100%
		0.090	0.018	0.018	100%	0.018	100%
		0.160	0.032	0.032	100%	0.032	100%
Fig 1 (34)	Skin Zone A3	0.032	0.006	0.006	50%	0.006	50%
		0.045	0.009	0.009	50%	0.009	50%
		0.055	0.011	0.011	50%	0.011	50%
		0.071	0.014	0.014	50%	0.014	50%
	Zone B3	0.060	0.012	0.012	50%	0.012	50%
		0.071	0.014	0.014	50%	0.014	50%



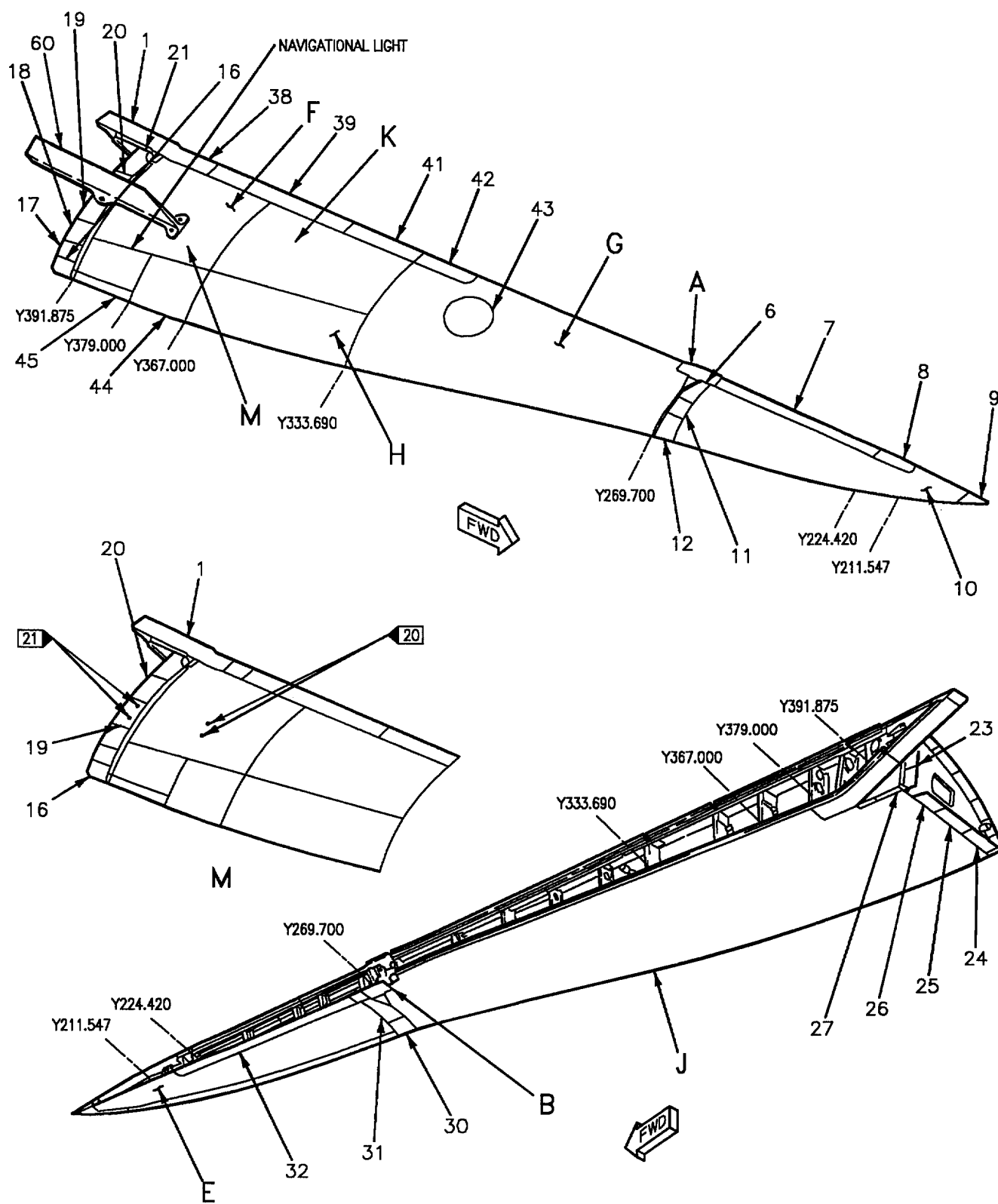
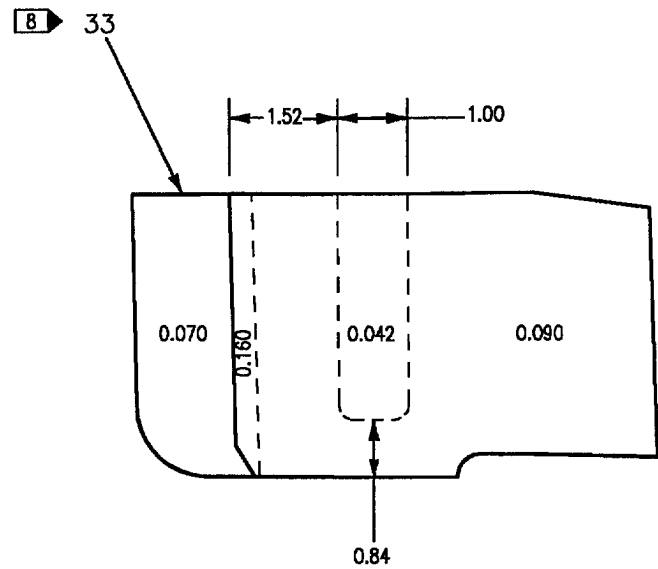
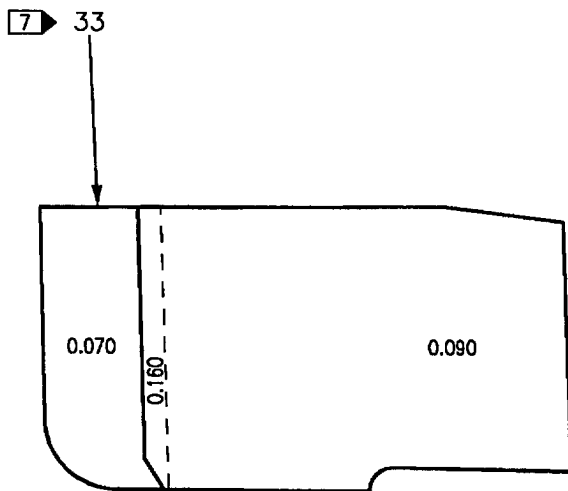
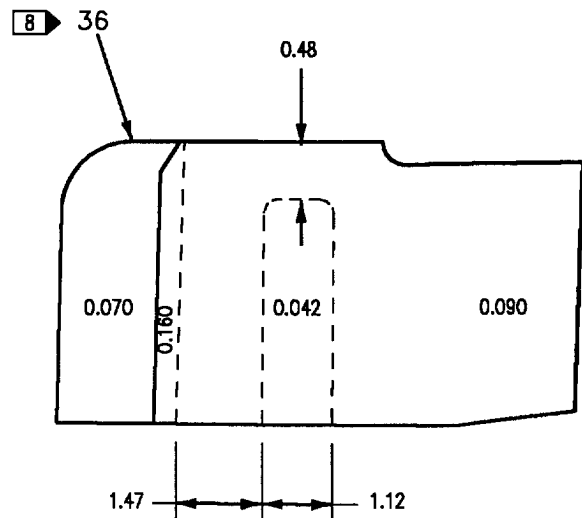
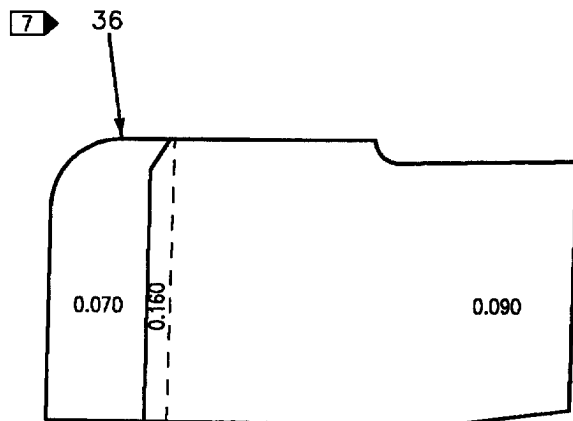


Figure 1. Material Index (Sheet 2)



A



B

Figure 1. Material Index (Sheet 3)

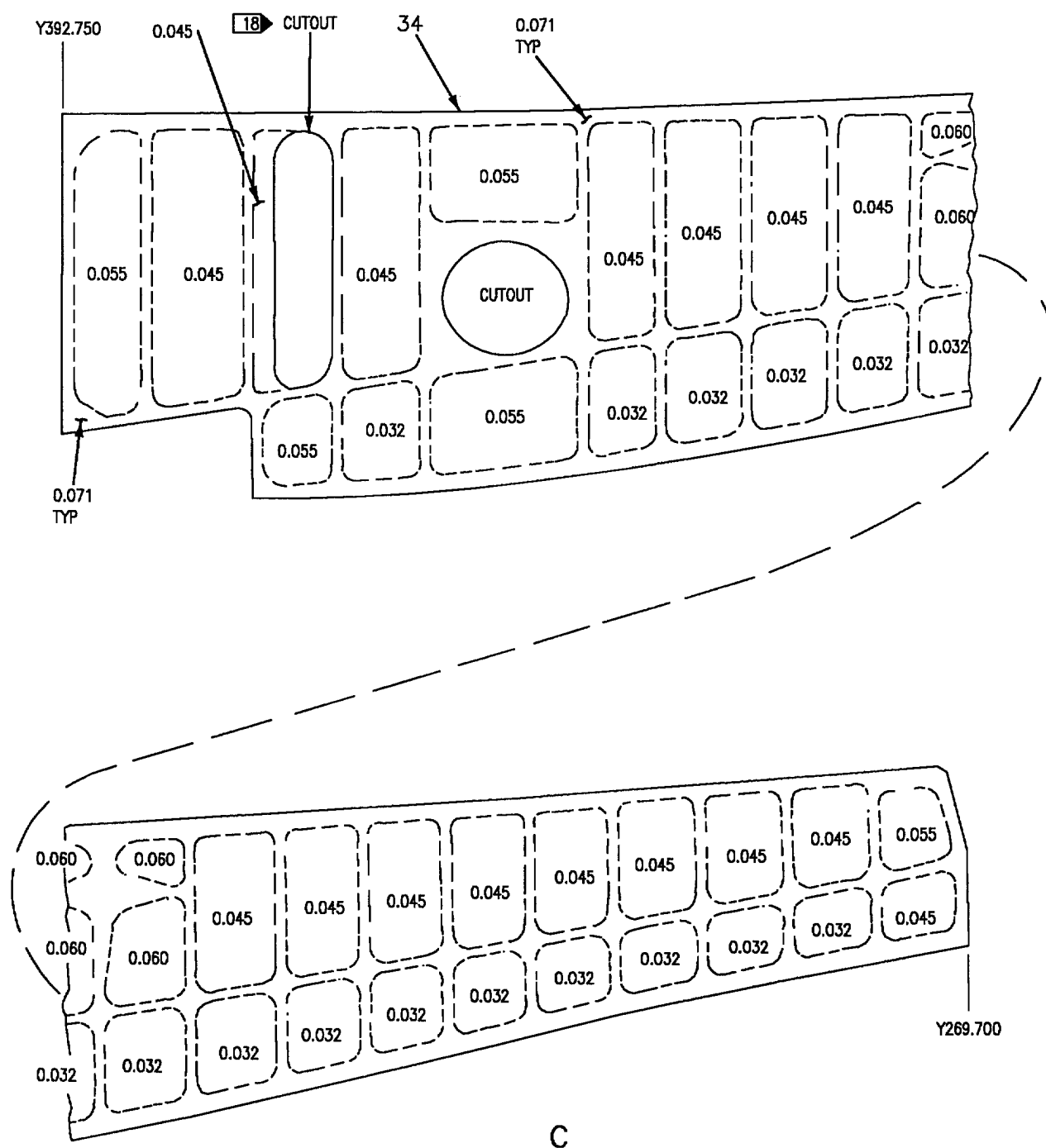


Figure 1. Material Index (Sheet 4)

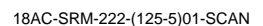


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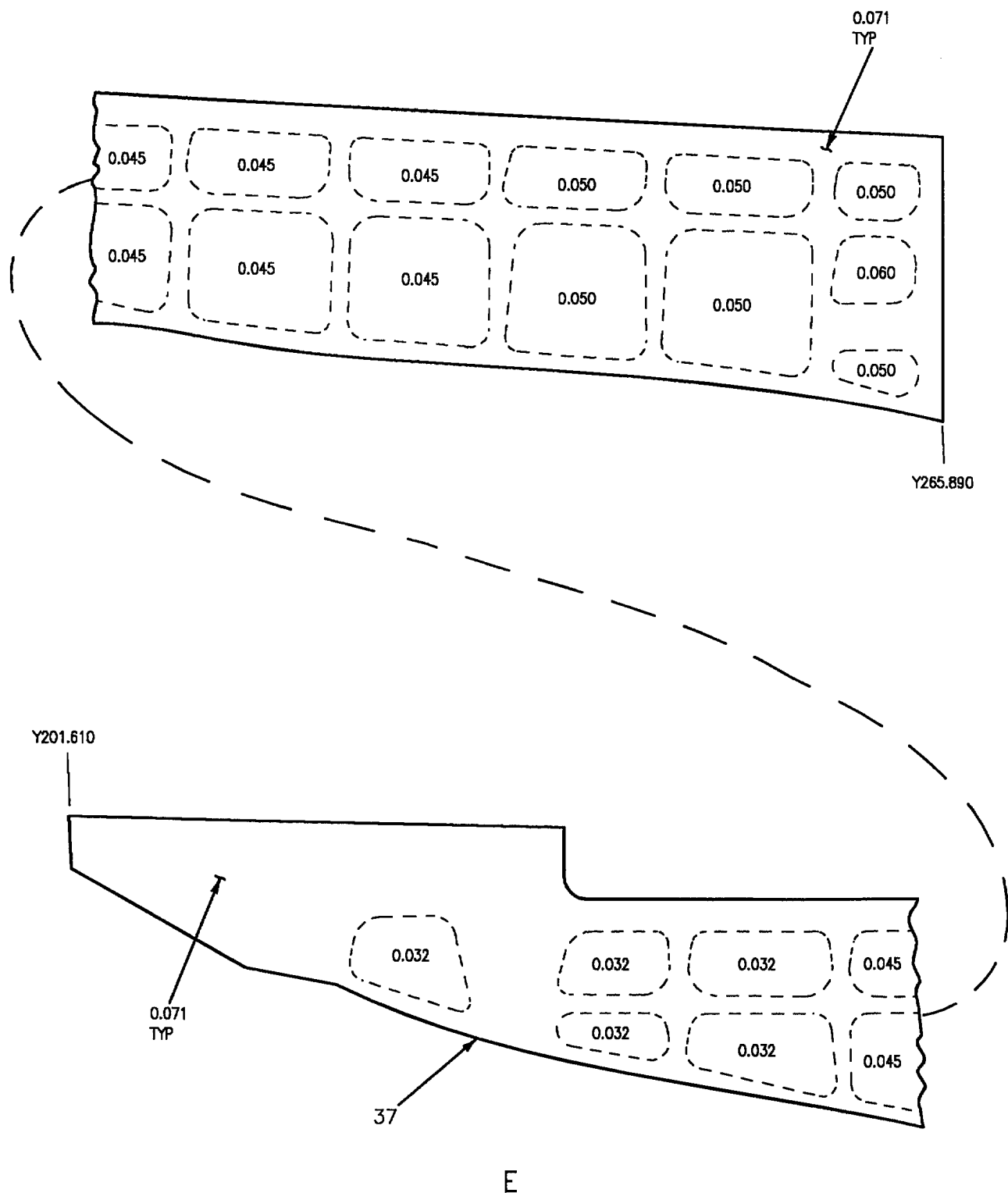


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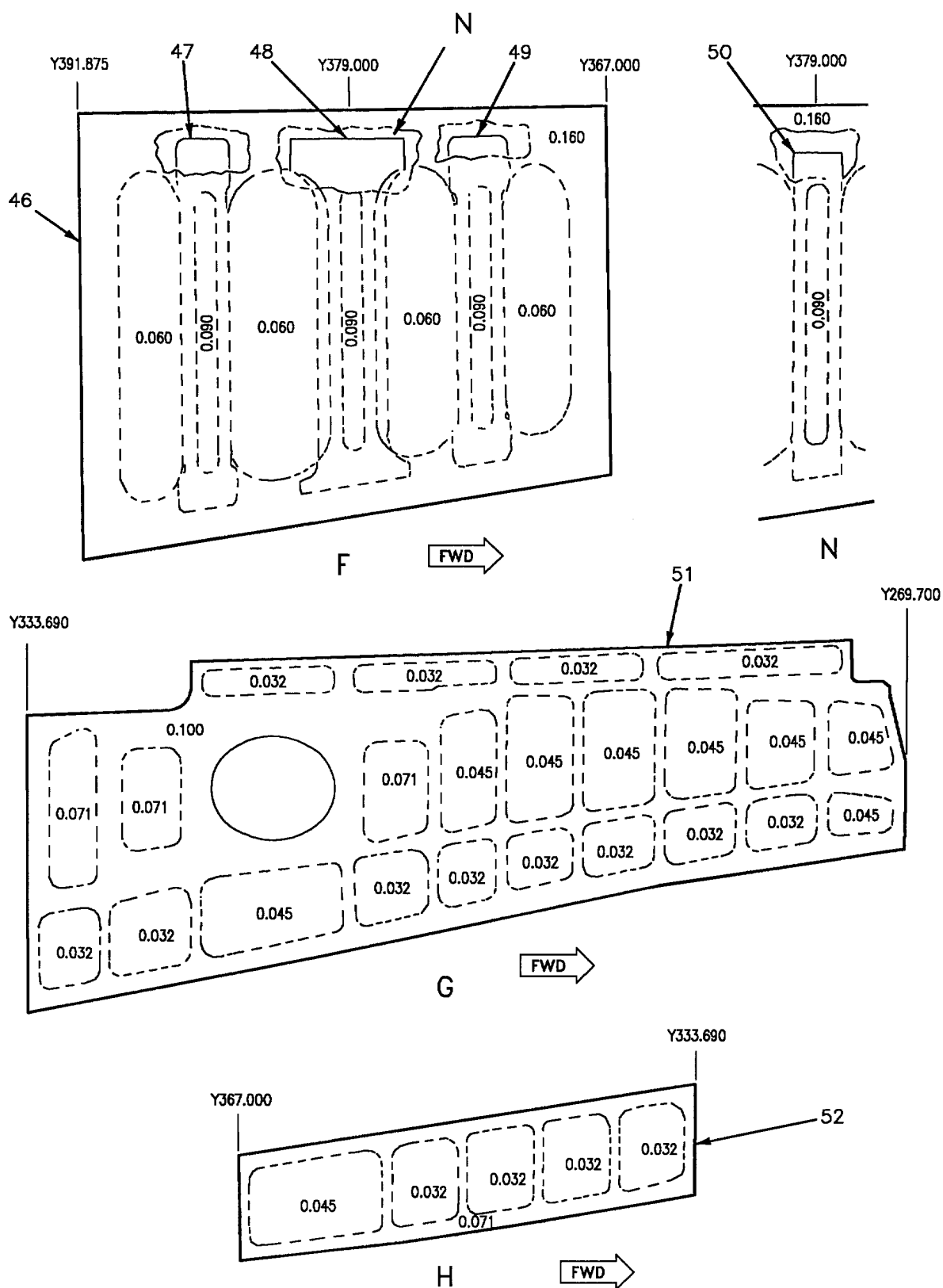


Figure 1. Material Index (Sheet 7)

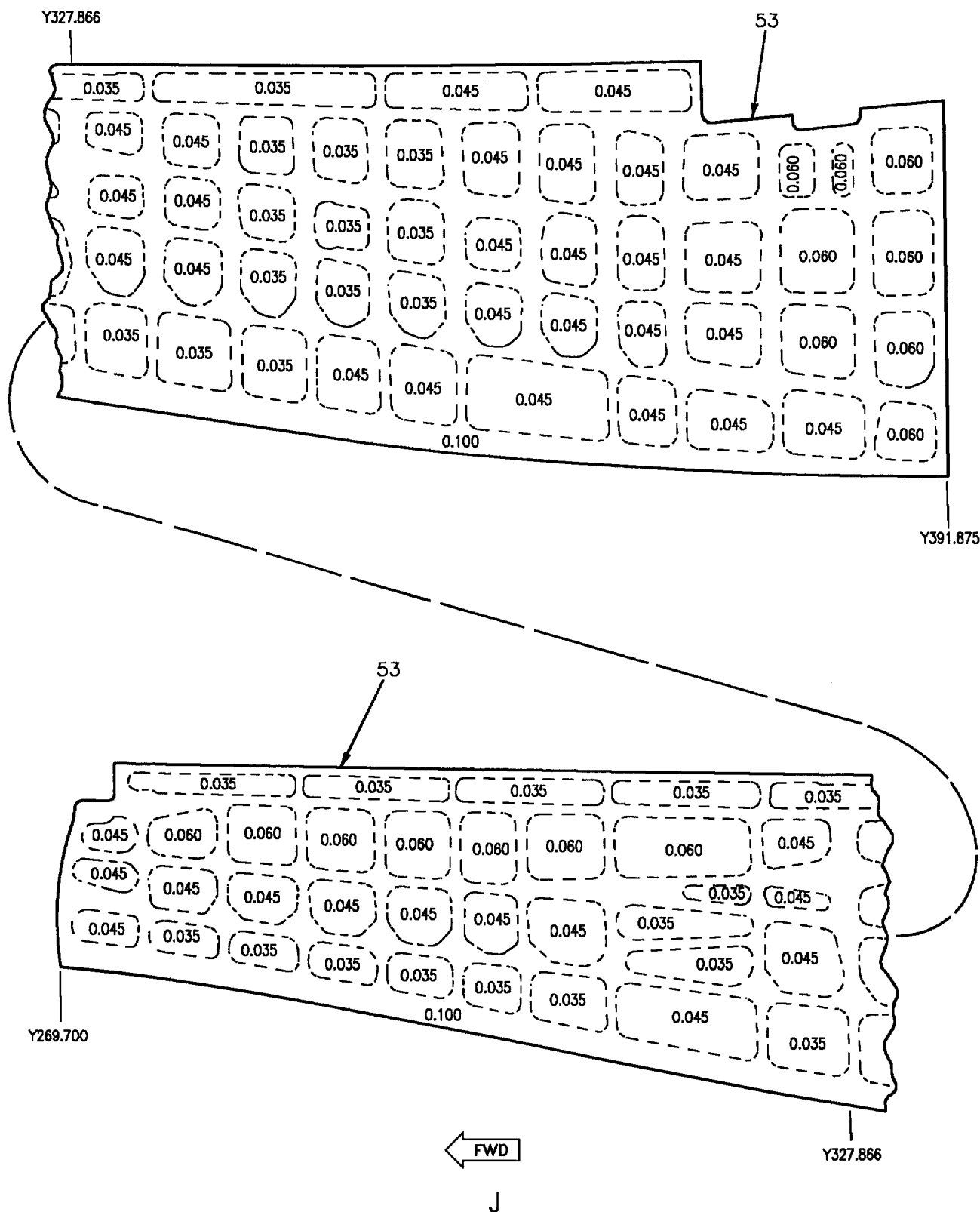


Figure 1. Material Index (Sheet 8)

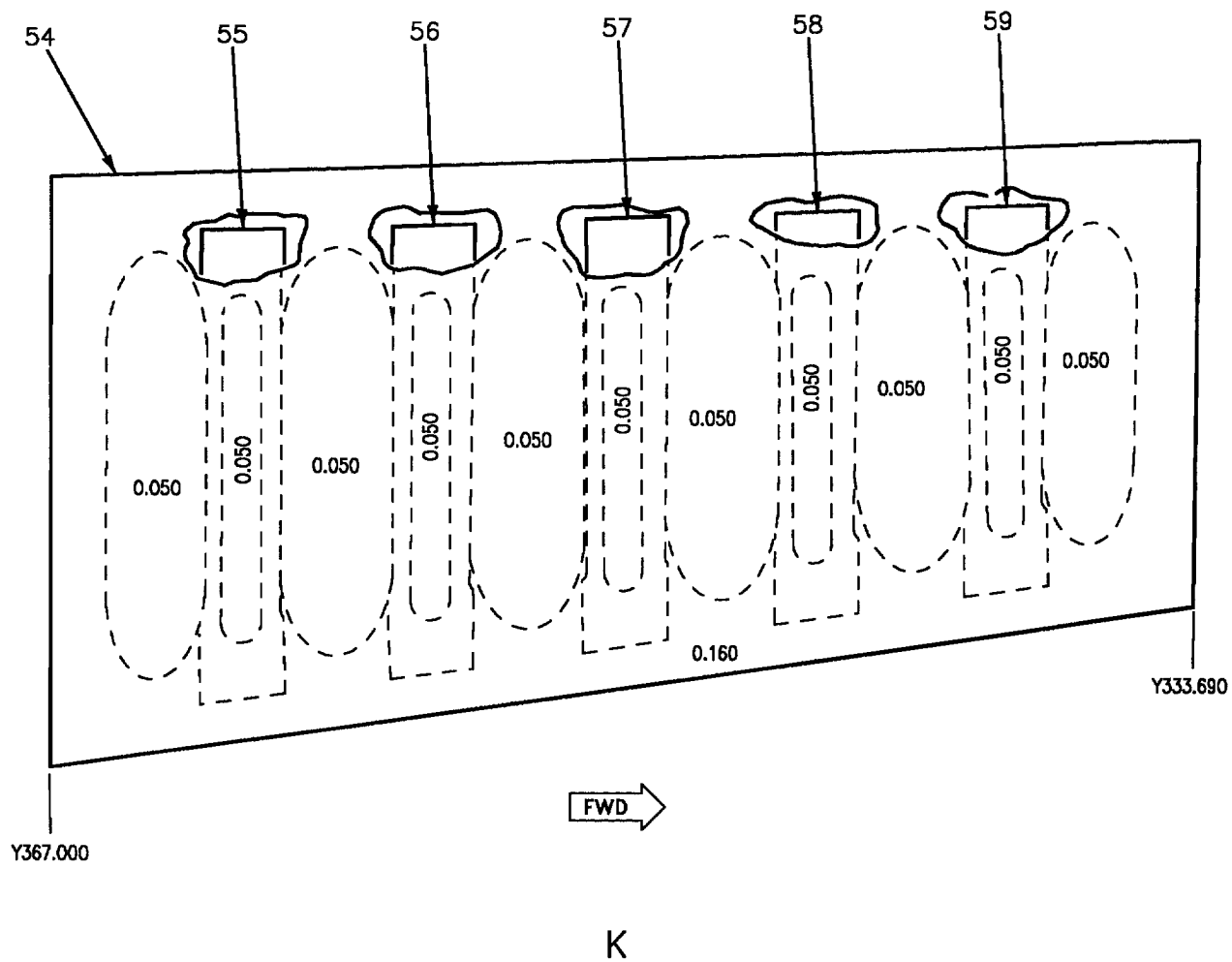


Figure 1. Material Index (Sheet 9)

























IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
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2		Skin 74A200694-2019	 Sheet	7075-T6 Alclad
3		Skin 74A200694-2017	 Sheet	7075-T6 Alclad
4		Skin 74A200694-2015	 Sheet	7075-T6 Alclad
5		Skin 74T030361-2077	 Sheet	7075-T6 Alclad
6		Skin 74T030312-2002	 Sheet	7075-T6 Alclad
7		Skin 74A200695-2008	0.071 Sheet	7075-T6 Alclad
8		Skin 74T030360-2006	0.090 Sheet	7075-T76 Alclad
9		Leading Edge 74T030315-2002	2.00 Plate	7075-T7351 Al Aly
10		Skin 74T030310-2002	 Sheet	7075-T6 Alclad
11		Skin 74T030312-2004	 Sheet	7075-T6 Alclad
12		Skin 74T030312-2006	 Sheet	7075-T6 Alclad
13		Cover (Door 23) 74T030381-2001	 Sheet	7075-T6 Alclad
14		Cover 74R200007-2003	0.125 Sheet	7075-T76 Alclad
15		Skin 74T030377-2003	0.071 Sheet	7075-T6 Alclad
16	 	Skin 74T030348-2033 74T030348-2065	 Sheet  Sheet	7075-T6 Alclad
17		Skin 74T030348-2035	 Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 10)

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19	<div>10</div> <div>11</div>	Skin 74T030348-2039 74T030348-2077	<div>4</div> Sheet	7075-T6 Alclad
20	<div>10</div> <div>11</div>	Skin 74T030348-2041 74T030348-2079	<div>4</div> Sheet	7075-T6 Alclad
21	<div>10</div> <div>11</div>	Skin 74T030348-2043 74T030348-2081	<div>4</div> Sheet	7075-T6 Alclad
22	<div>12</div>	Skin 74T030348-2045	<div>4</div> Sheet	7075-T6 Alclad
23	<div>12</div> <div>13</div>	Skin 74T030348-2047 74T030348-2059	<div>4</div> Sheet	7075-T6 Alclad
24	<div>12</div> <div>15</div> <div>11</div>	Skin 74T030348-2031 74T030348-2067 74T030348-2083	<div>6</div> Sheet	7075-T6 Alclad
25	<div>10</div> <div>11</div>	Skin 74T030348-2029 74T030348-2085	<div>6</div> Sheet	7075-T6 Alclad
26	<div>10</div> <div>11</div>	Skin 74T030348-2027 74T030348-2087	<div>6</div> Sheet	7075-T6 Alclad
27	<div>12</div> <div>15</div> <div>11</div>	Skin 74T030348-2025 74T030348-2055 74T030348-2073	0.071 Sheet	7075-T6 Alclad
28	<div>10</div>	Skin 74A200694-2023	<div>1</div> Sheet	7075-T6 Alclad
29	<div>10</div>	Skin 74A200694-2025	<div>1</div> Sheet	7075-T6 Alclad
30		Skin 74T030312-2010	<div>6</div> Sheet	7075-T6 Alclad
31		Skin 74T030312-2008	<div>6</div> Sheet	7075-T6 Alclad

Figure 1. Material Index (Sheet 11)






















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
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34		Skin 74T030377-2001	0.071 Sheet	7075-T6 Alclad
35		Skin 74T030378-2001	0.071 Sheet	7075-T6 Alclad
36	  	Skin 74A200695-2002 74A200695-2026 74A200695-2030	0.160 Sheet	7075-T6 Alclad
37		Skin 74T030311-2002	0.071 Sheet	7075-T6 Alclad
38		Skin 74A201008-2001	0.071 Sheet	7075-T6 Alclad
39		Skin 74A200978-2001	 Sheet	7075-T6 Alclad
40		Deleted		
41		Skin 74A200954-2001	 Sheet	7075-T6 Alclad
42		Skin 74A200952-2001	0.071 Sheet	7075-T6 Alclad
43		Cover (Door 23) 74A200953-2001	 Sheet	7075-T76 Alclad
44		Skin 74A200942-2007	 Sheet	7075-T6 Sheet
45		Skin 74A200942-2009	0.071 Sheet	7076-T6 Alclad
46		Cover (Door 127) 74A200948-2001	Sheet	7075-T76 Alclad
47		Stiffener 74A200948-2007	0.063 Sheet	7075-T6 Alclad
48		Strap 74A201033-2033	Machining	7075-T7351 Al Aly

Figure 1. Material Index (Sheet 12)



















IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
49		Stiffener 74A200948-2003	0.063 Sheet	7075-T6 Alclad
50		Stiffener 74A200948-2005	0.063 Sheet	7075-T6 Alclad
51		Skin 74A200942-2003	0.100 Sheet	7075-T76 Alclad
52		Skin 74A200942-2005	0.071	7075-T6 Alclad
53	 	Skin 74A200945-2003 74A200945-2011	0.100 Sheet	7075-T76 Alclad
54		Cover (Door 123) 74A200947-2001	 Sheet	7075-T76 Alclad
55		Stiffener 74A200947-2011	0.063 Sheet	7075-T6 Alclad
56		Stiffener 74A200947-2009	0.063 Sheet	7075-T6 Alclad
57		Stiffener 74A200947-2007	0.063 Sheet	7075-T6 Alclad
58		Stiffener 74A200947-2005	0.063 Sheet	7075-T6 Alclad
59		Stiffener 74A200947-2003	0.063 Sheet	7075-T6 Alclad
60		Fence 74A201031-2005	1MA10641D05 Extr	7075-T3511 Aly
LEGEND  Lands are 0.071, bays are 0.050.  Lands are 0.050, bays are 0.032.  Fastener lands are 0.071, and remaining areas are 0.035.  Fastener lands are 0.071, and remaining areas are 0.040.  Lands are 0.071, and bays are 0.045.  Fastener lands are 0.071, and remaining areas are 0.030.  161353 THRU 161519.  161520 THRU 161987.  Fastener land is 0.090, and bay is 0.060.  161353 THRU 161987.  162394 AND UP.				

Figure 1. Material Index (Sheet 13)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
12		161353 THRU 161715.		
13		161716 AND UP.		
14		Lands are 0.160, bays are 0.050.		
15		161716 THRU 161987.		
16		162394 THRU 163092.		
17		163093 AND UP.		
18		161353 THRU 161987 AFTER F18 AFC 102.		
19		162394 AND UP, AFTER F18 AFC 102.		
20		Temporary bolts, NAS674V8 and washers, AN960JD416 installed AFTER F/A-18 AFC 102 to plug attach holes for LEX fence, before fence is installed.		
21		Temporary bolts, NAS675V11 and washers, AN960JD516 installed AFTER F/A-18 AFC 102 to plug attach holes for LEX fence, before fence is installed.		
22		161353 AND UP, AFTER F/A-18 AFC 102.		

Figure 1. Material Index (Sheet 14)

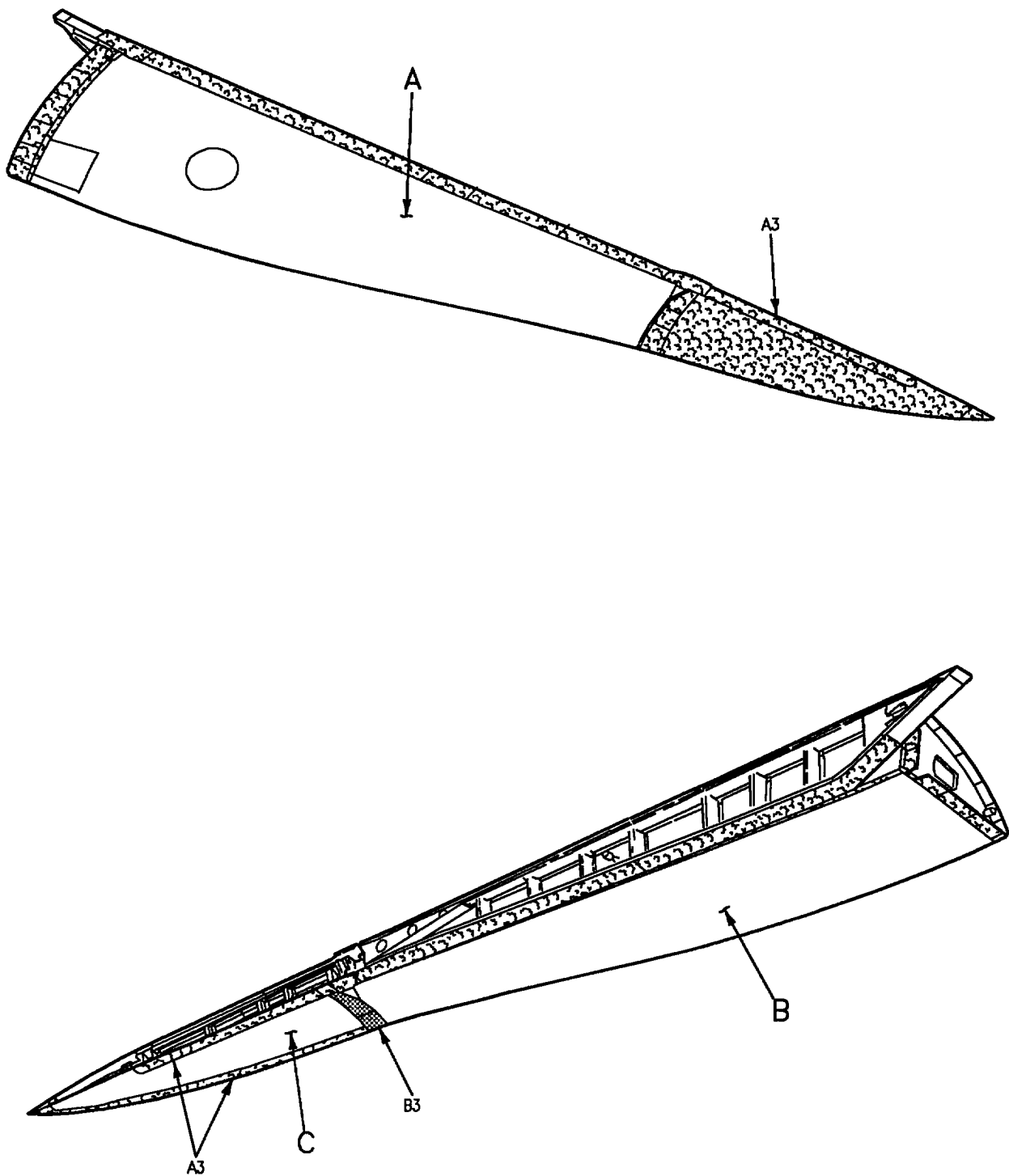


Figure 2. Repair Zones (Sheet 1)

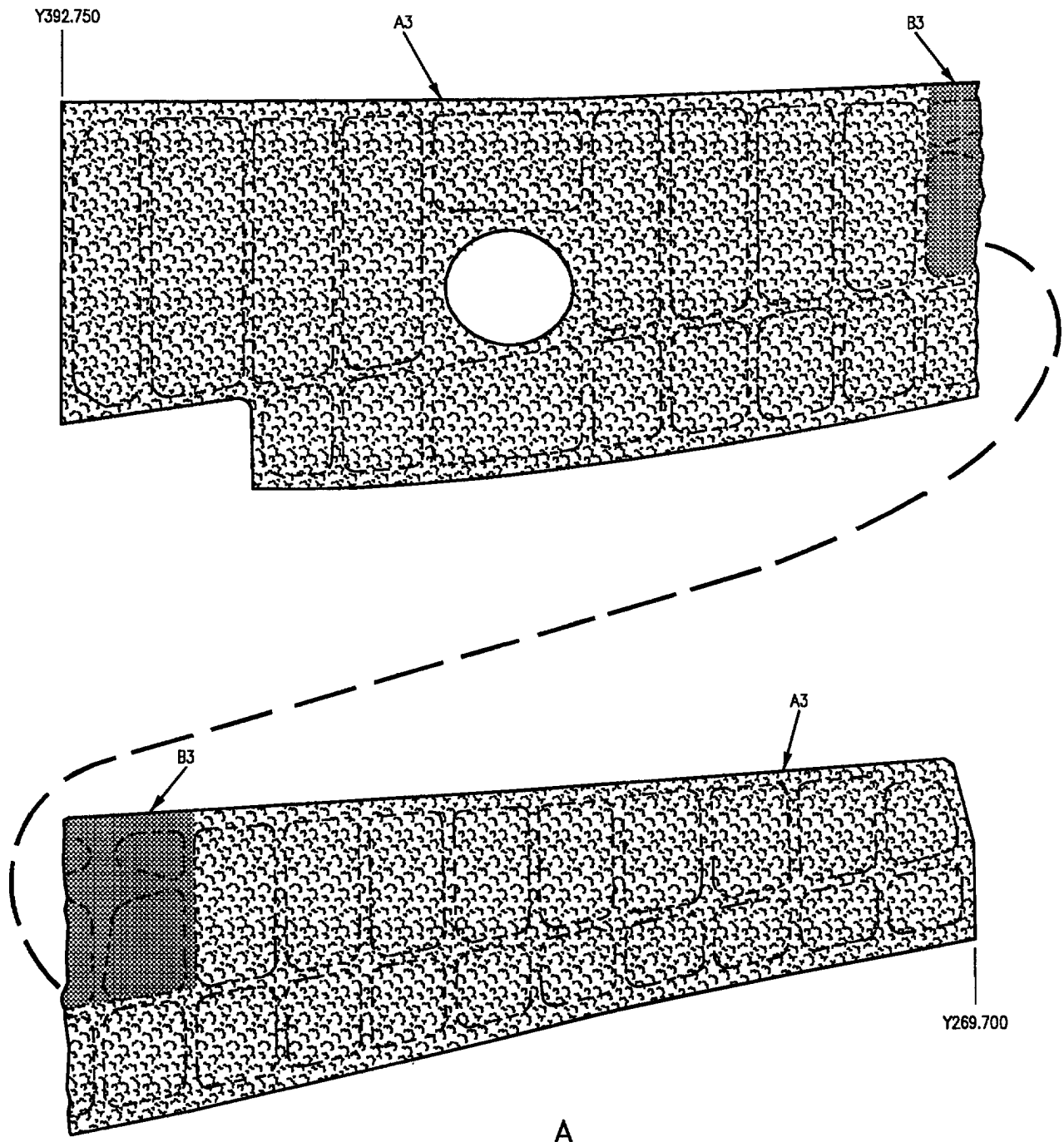


Figure 2. Repair Zones (Sheet 2)

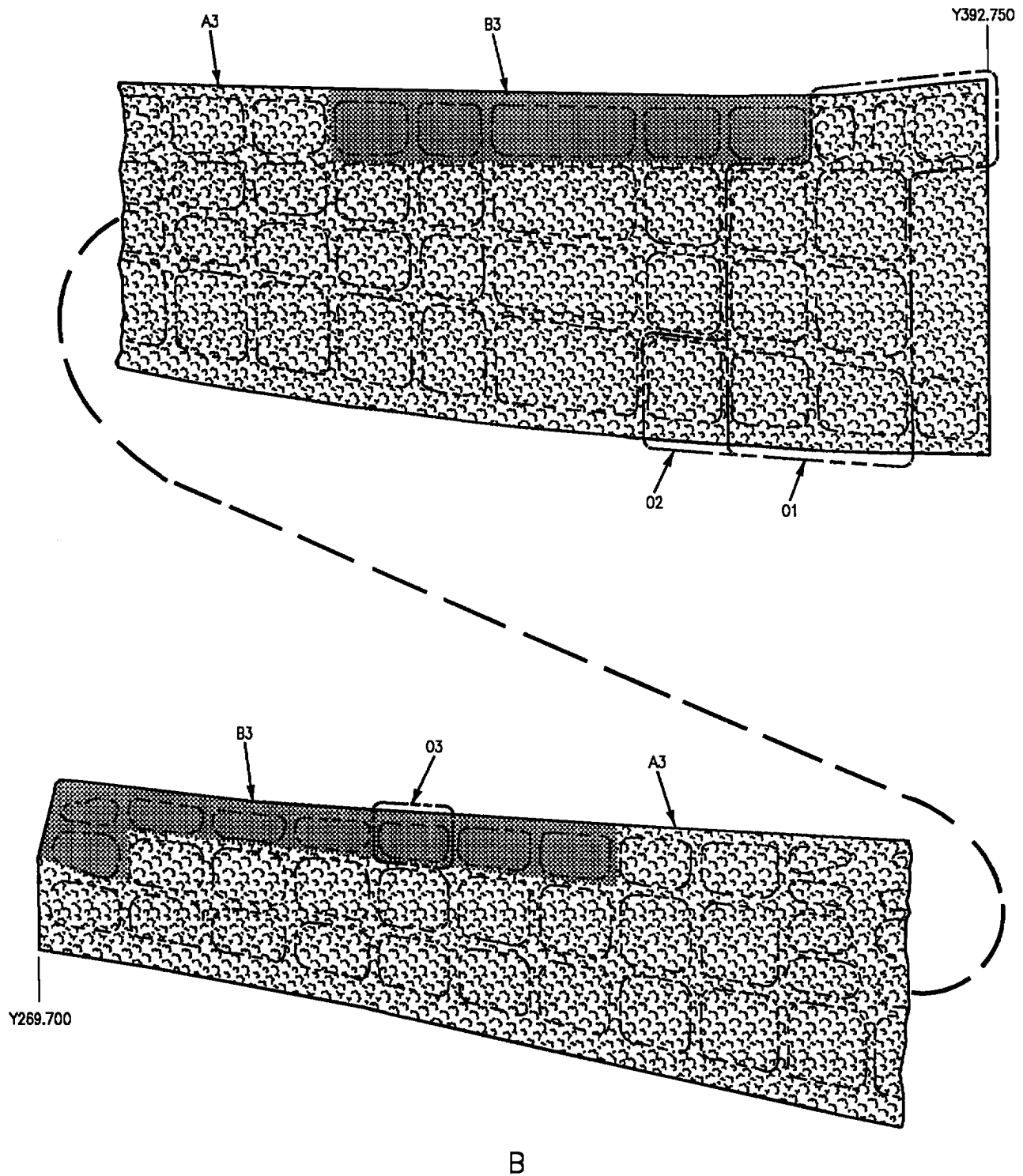


Figure 2. Repair Zones (Sheet 3)

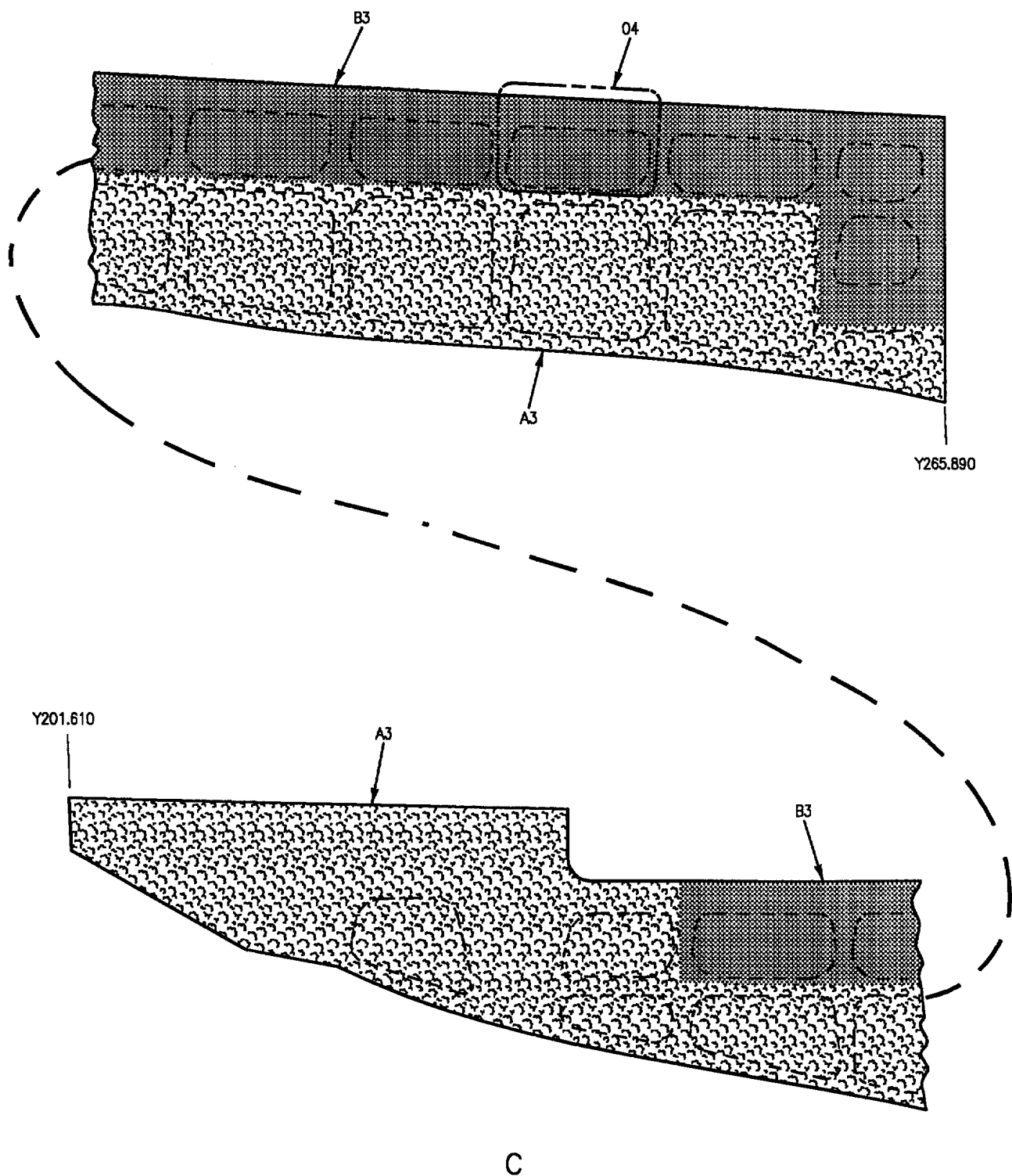


Figure 2. Repair Zones (Sheet 4)

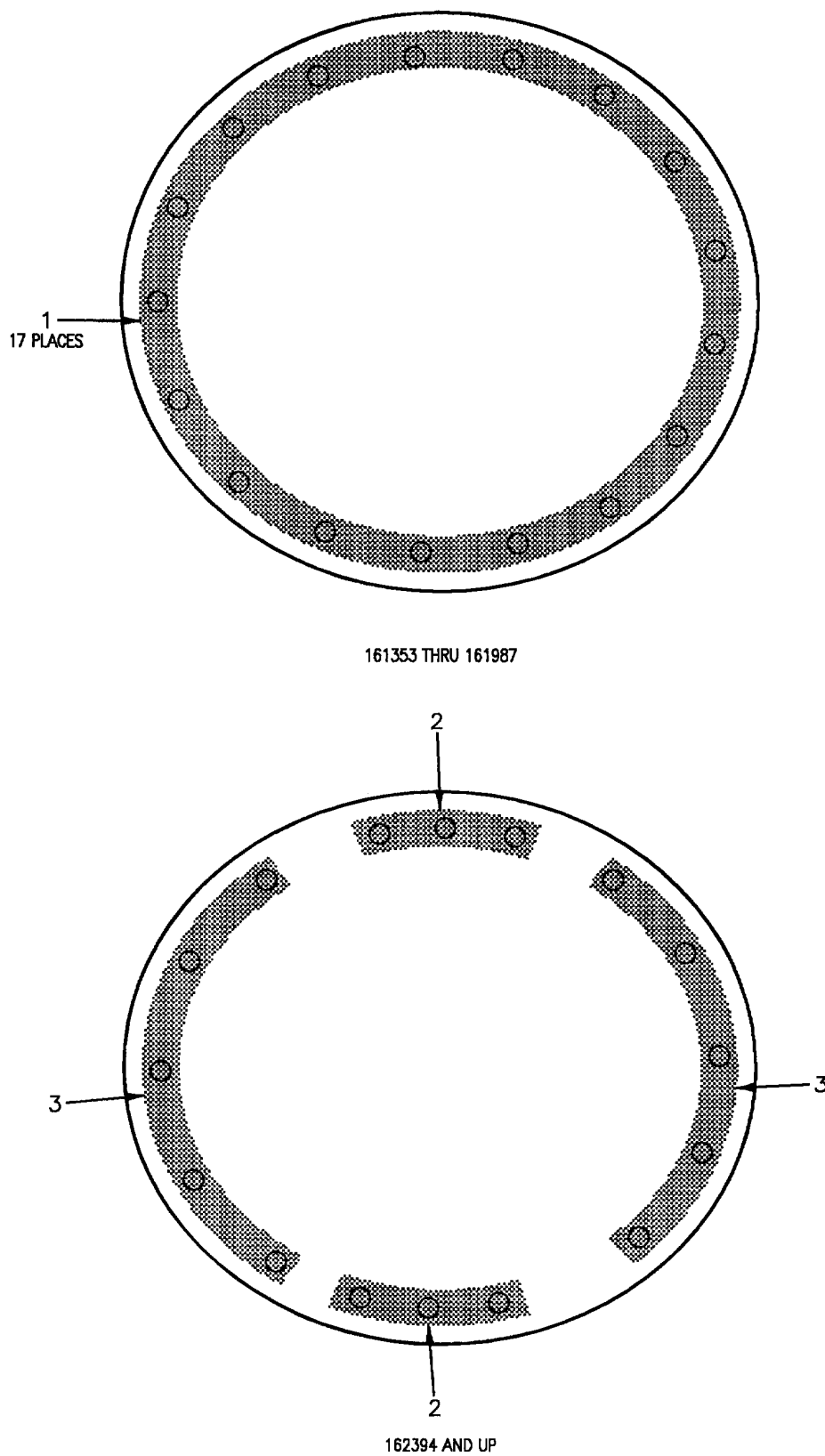


Figure 3. Cover (Door 23) Replacement (Sheet 1)





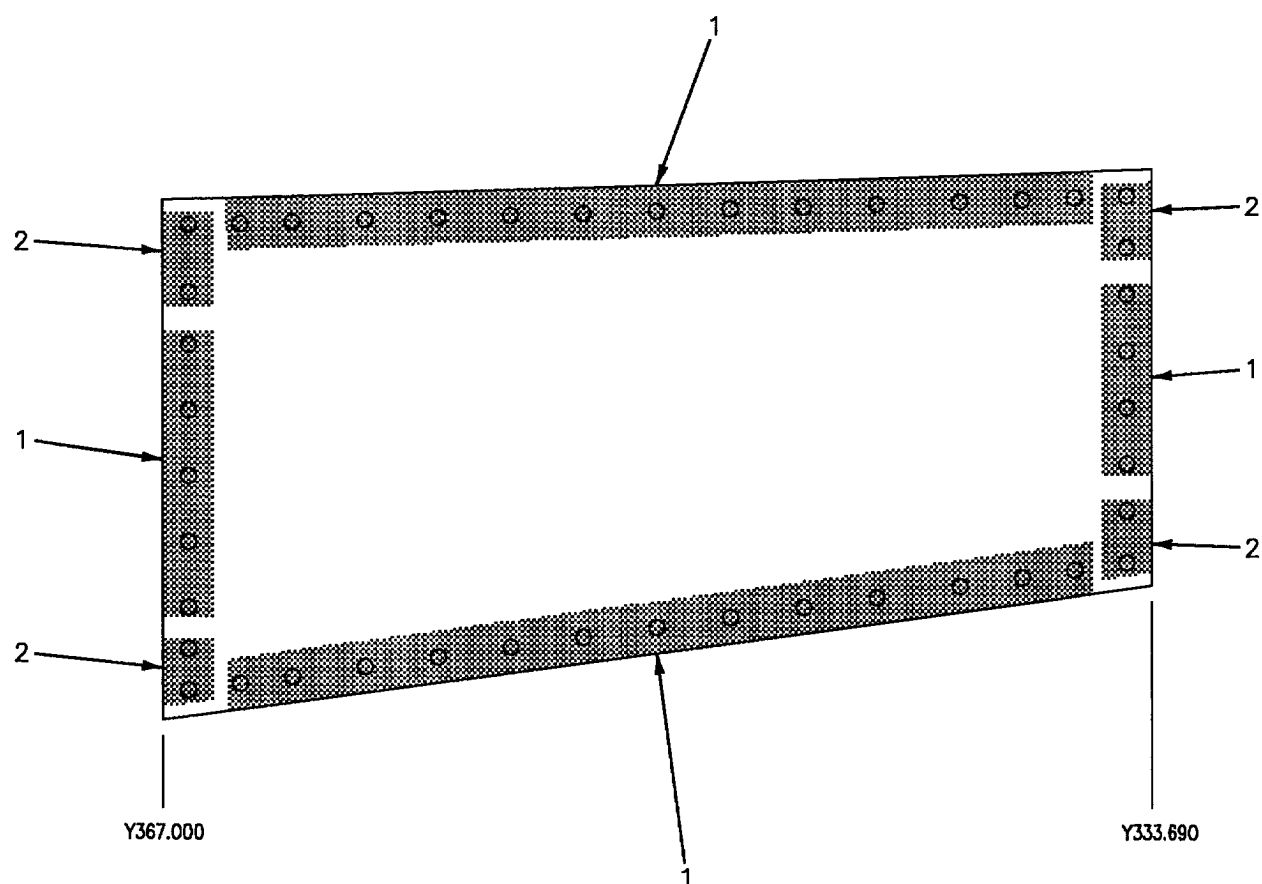
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Plate Nut Shim	MS21060L4 NAS463XDD416
2			Gang Channel	RG51031-4-1-8-42-3
3			Plate Nut	F50339-4-4
LEGEND				
 Hole diameter is 0.255 +0.007 -0.000.				

Figure 3. Cover (Door 23) Replacement (Sheet 2)



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


IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Receptacle	1950-6-9-3
2			Receptacle	1950-6-9-5
LEGEND				
 Hole diameter is 0.660 +0.010 -0.000.				

Figure 4. Cover (Door 123) Replacement

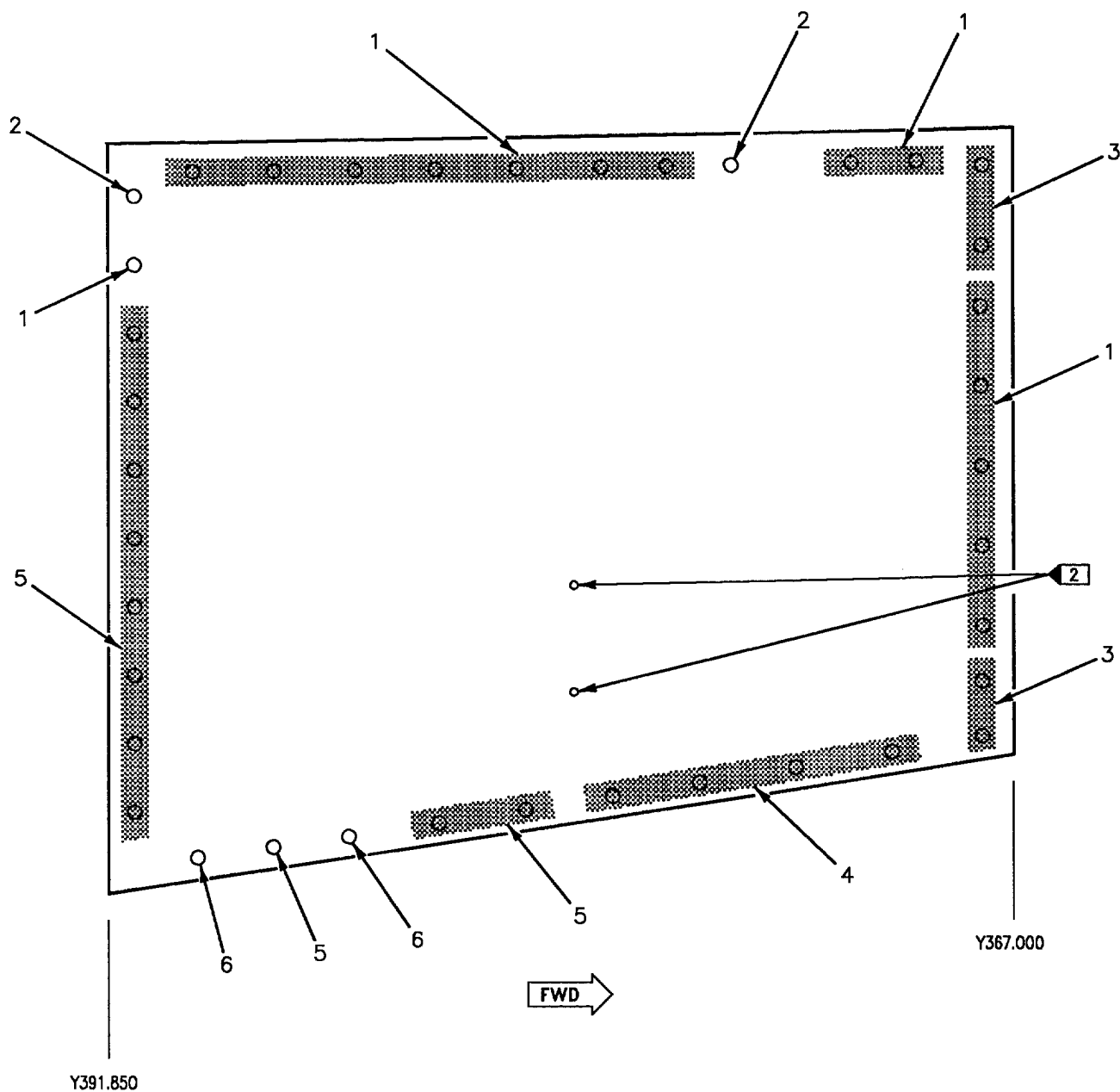


Figure 5. Cover (Door 127) Replacement (Sheet 1)









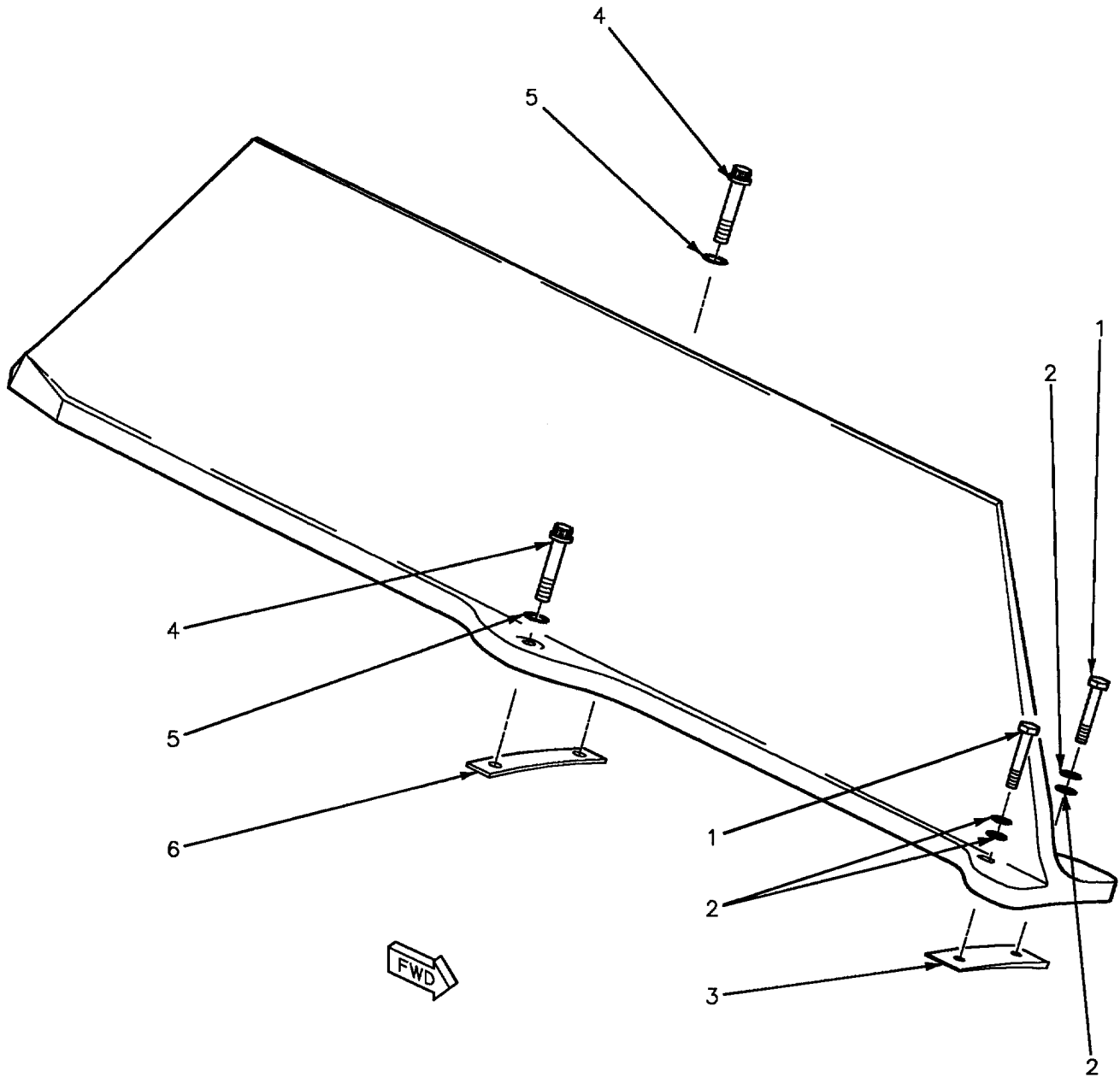
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Receptacle	1950-6-9-3
2			Receptacle	1950-6-10-4
3			Receptacle	1950-6-9-5
4			Receptacle	1950-6-9-4
5			Receptacle	1950-6-10-1
6			Receptacle	1950-6-9-2
LEGEND				
 Hole diameter is 0.385 +0.007 -0.000.				
 LEX fence attach holes.				

Figure 5. Cover (Door 127) Replacement (Sheet 2)



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Figure 6. 74A201031 (LEX) Fence Replacement (Sheet 1)











IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1			Bolt Platenut	NAS674V20H ST3M719C4M1
2			Washer	AN960C416
3			Spacer	74A201033-2035
4		 	Bolt Barrel Nut Retainer	ST3M571-5H22 NAS577B5A NAS578-5A
5			Washer	NAS1587-5C
6		 	Spacer Spacer	74R200006-2007 74A201033-2009
<p style="text-align: center;">LEGEND</p> <p> Four required, two under each bolt head.</p> <p> Fastener attaching hardware.</p> <p> F/A-18A 161213 thru 161986. F/A-18B 161217 thru 161947.</p> <p> F/A-18A 162394 thru 163175. F/A-18B 162402 thru 163123.</p>				

Figure 6. 74A201031 (LEX) Fence Replacement (Sheet 2)

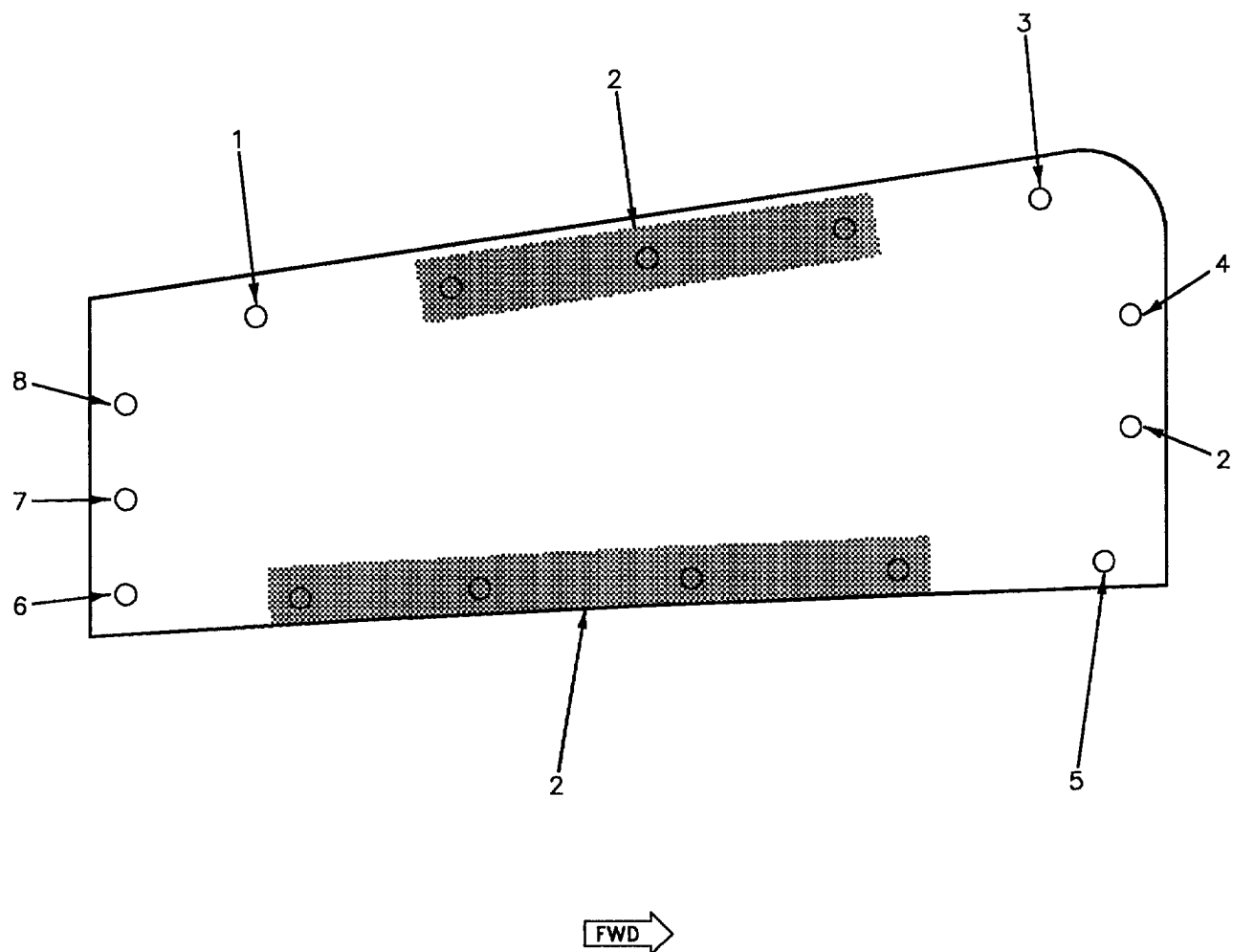


Figure 7. LEX Position Light (7DSM008) Replacement (Sheet 1)



































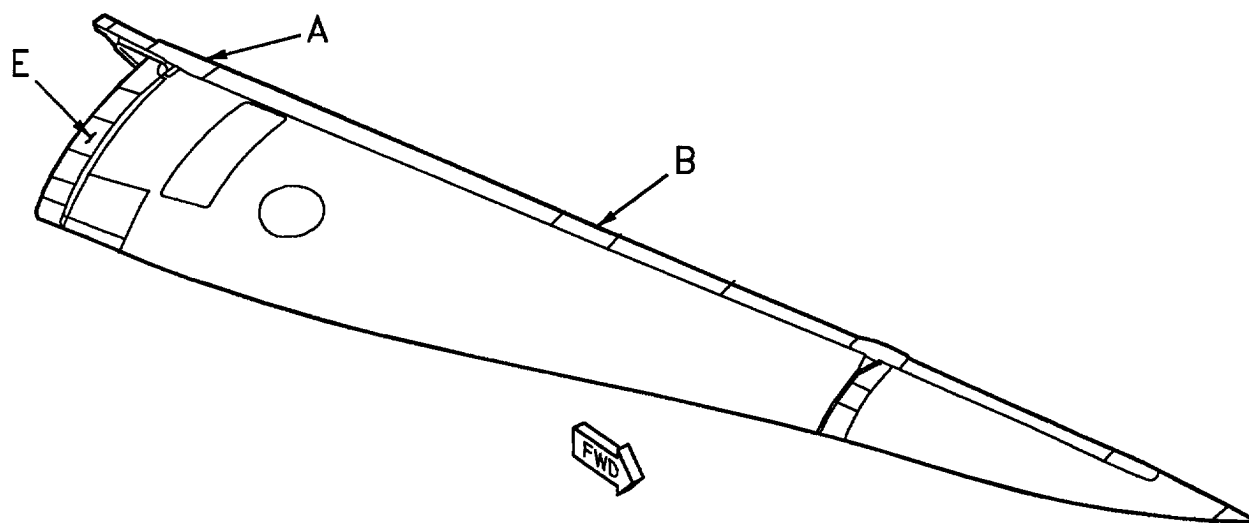
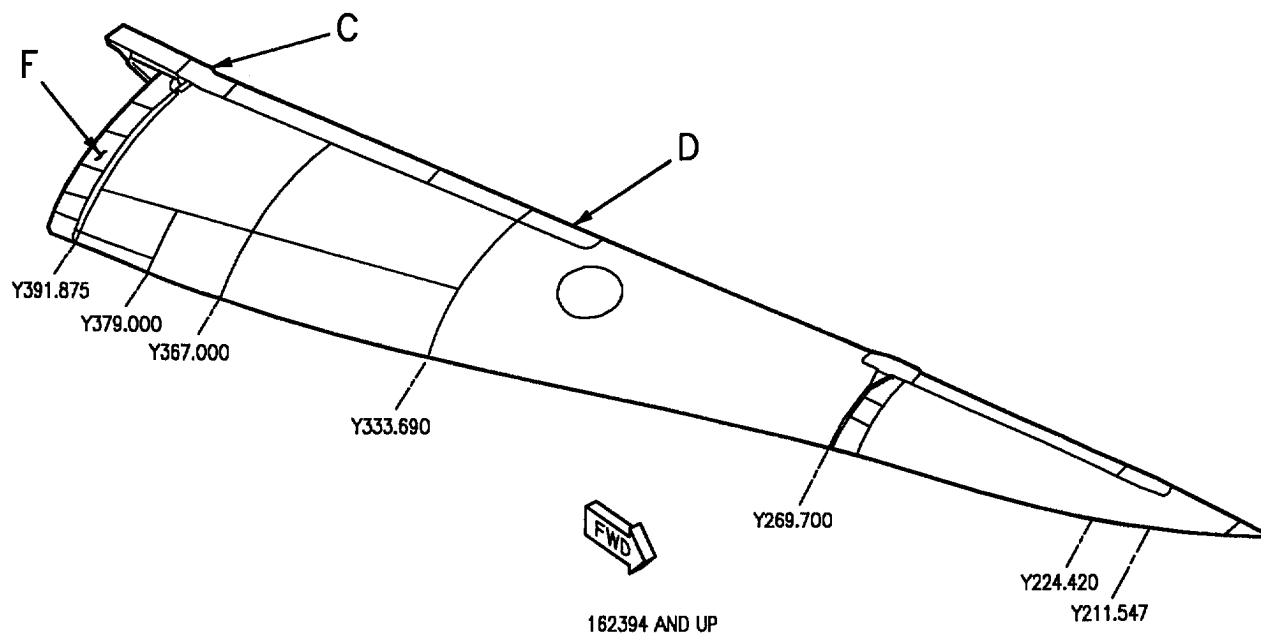
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1	 	 	Plate Nut Plate Nut	F49249E3-1 F49251E3-1
2	 	 	Plate Nut Plate Nut	F49249E3-4 F49249E3-5
3	 	 	Plate Nut Plate Nut	F49249E3-4 F49249E3-2
4	 	 	Plate Nut Plate Nut	F49249E3-4 F49249E3-1
5	 	 	Plate Nut Plate Nut	F49249E3-2 FF50403-3-4
6	 	 	Plate Nut Plate Nut	F49249E3-1 F49249E3-4
7			Plate Nut	F49249E3-4
8	 	 	Plate Nut Plate Nut	F49249E3-4 F14427-4-3
<p style="text-align: center;">LEGEND</p> <p> Hole diameter is 0.195 +0.007 -0.000.</p> <p> 161353 THRU 161987, 163100 THRU 163104, 163106 THRU 163111, 163113 THRU 163146, 163148 THRU 163150, 163152 THRU 163157, 163159 THRU 163167, 163169 AND UP.</p> <p> 162394 THRU 163099, 163105, 163112, 163147, 163151, 163158, 163168.</p> <p> 161353 THRU 161987.</p> <p> 162394 AND UP.</p>				

Figure 7. LEX Position Light (7DSM008) Replacement (Sheet 2)



161353 THRU 161987



162394 AND UP

18AC-SRM-222-(132-1)01-SCAN

Figure 8. Removable Covers, Replacement (Sheet 1)

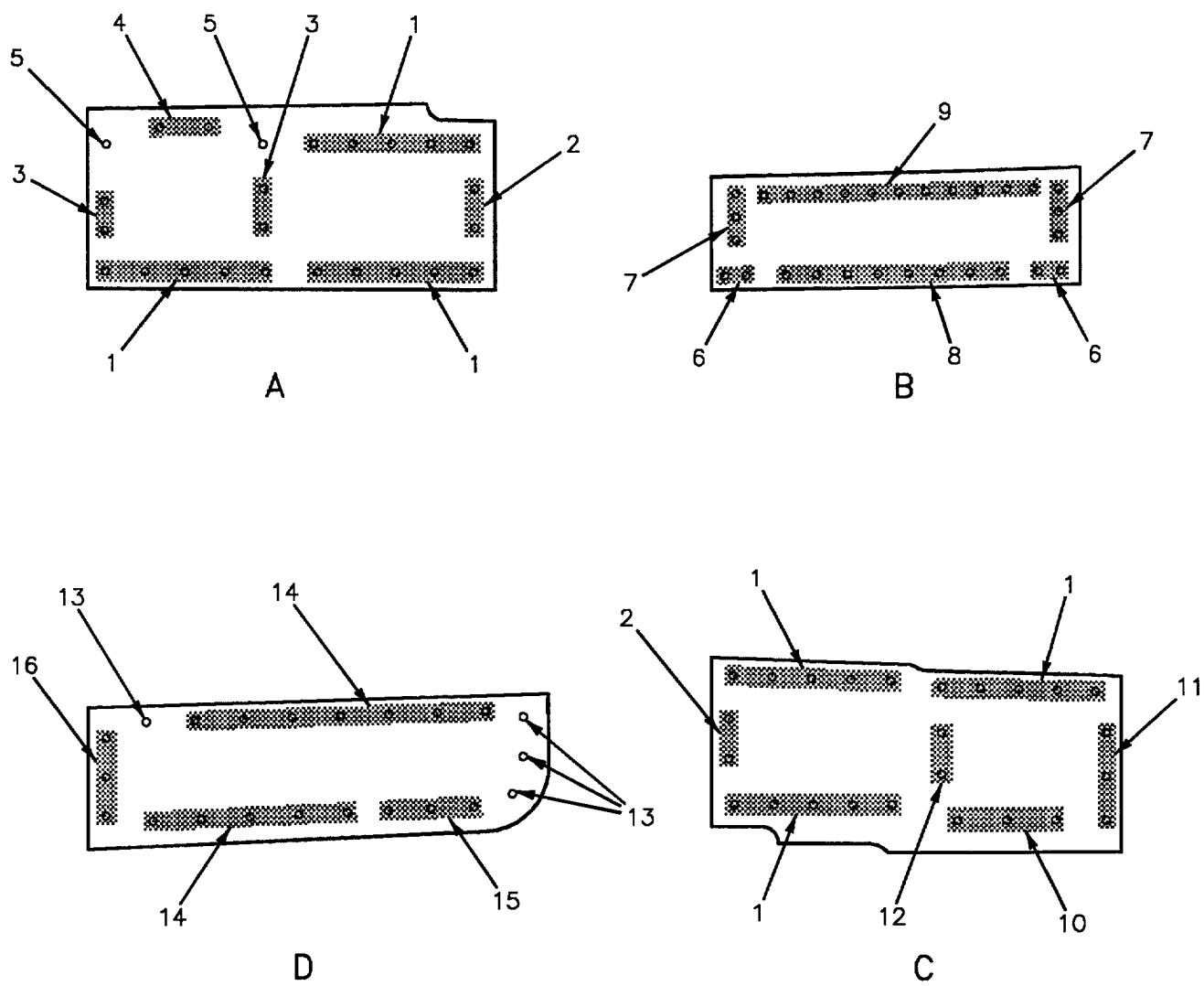


Figure 8. Removable Covers, Replacement (Sheet 2)

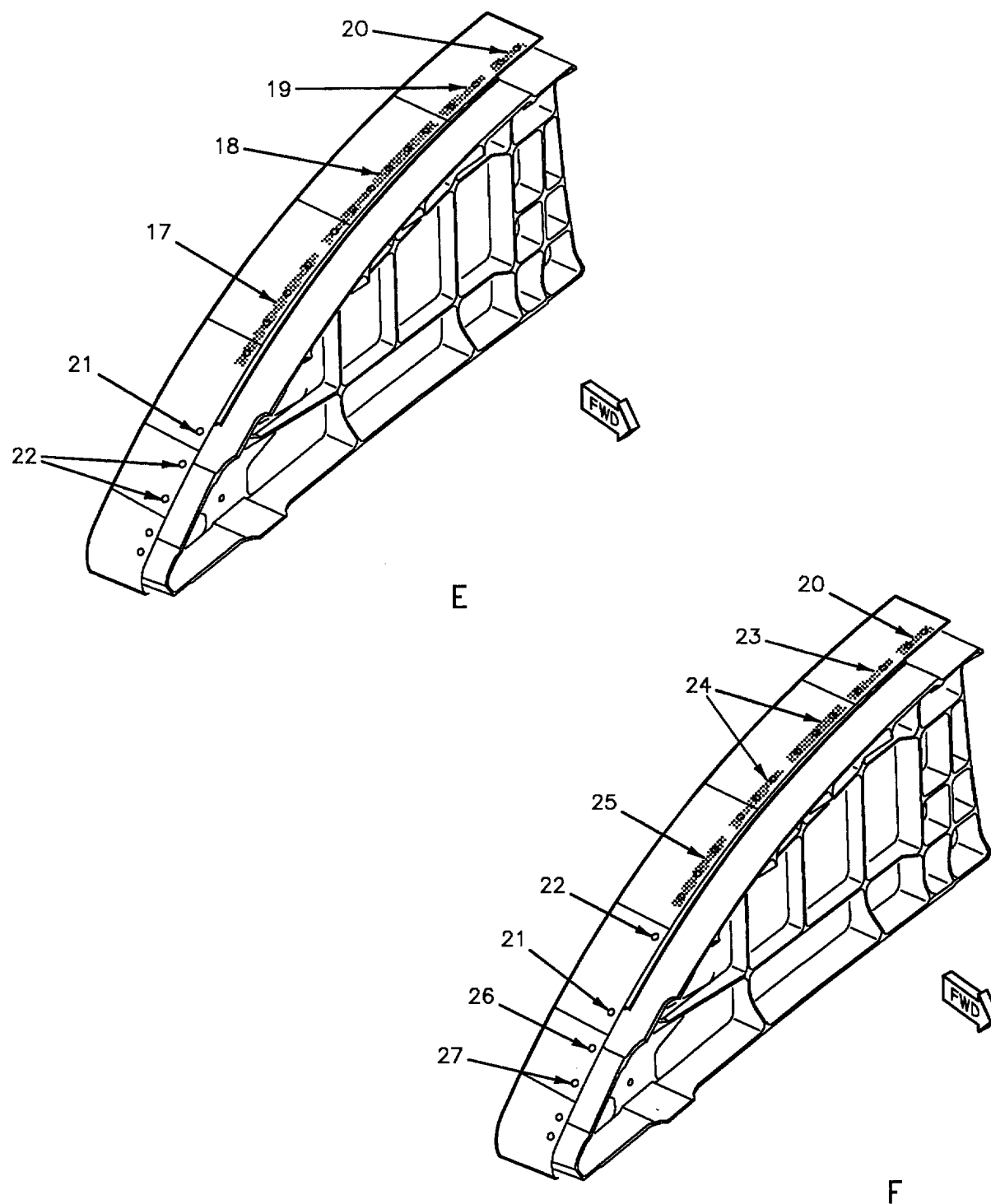


Figure 8. Removable Covers, Replacement (Sheet 3)

IDX NO.	EFT		NOMENCLATURE	PART NUMBER
1		5	Gang Channel	3M463N8A5-2
2		5	Gang Channel	3M463N7A2-2
3		5	Gang Channel	3M463N8A2F2
4		5	Gang Channel	3M463N10A2L2
5		5	Plate Nut	F49249E3-2
6		5	Gang Channel	3M463N6A2F1
7		5	Gang Channel	3M463N6A3-2
8		5	Gang Channel	3M463N8A8-2
9		5	Gang Channel	3M463N7A11-4
10		5	Gang Channel	3M463N10A3-2
11		5	Gang Channel	3M463N9A3-2
12		5	Gang Channel	3M463N9A2F4
13		5	Plate Nut	F50339-3-2
14		5	Gang Channel	ST3M723C2M10
15		5	Gang Channel	ST3M723C2M9
16		5	Gang Channel	ST3M723C2M8
17		1	Gang Channel	74T030348-2049
18		2	Gang Channel	74T030348-2051
19	3 4	6 6	Gang Channel Gang Channel	3M463N14A2-2 3M463N14A2-3
20		6	Gang Channel	3M463N8A2-1
21		6	Plate Nut	F50403-3-2
22		6	Plate Nut	F49249E3-4
23		6	Gang Channel	3M463N13A2-2
24		6	Gang Channel	3M463N9A3-4

Figure 8. Removable Covers, Replacement (Sheet 4)










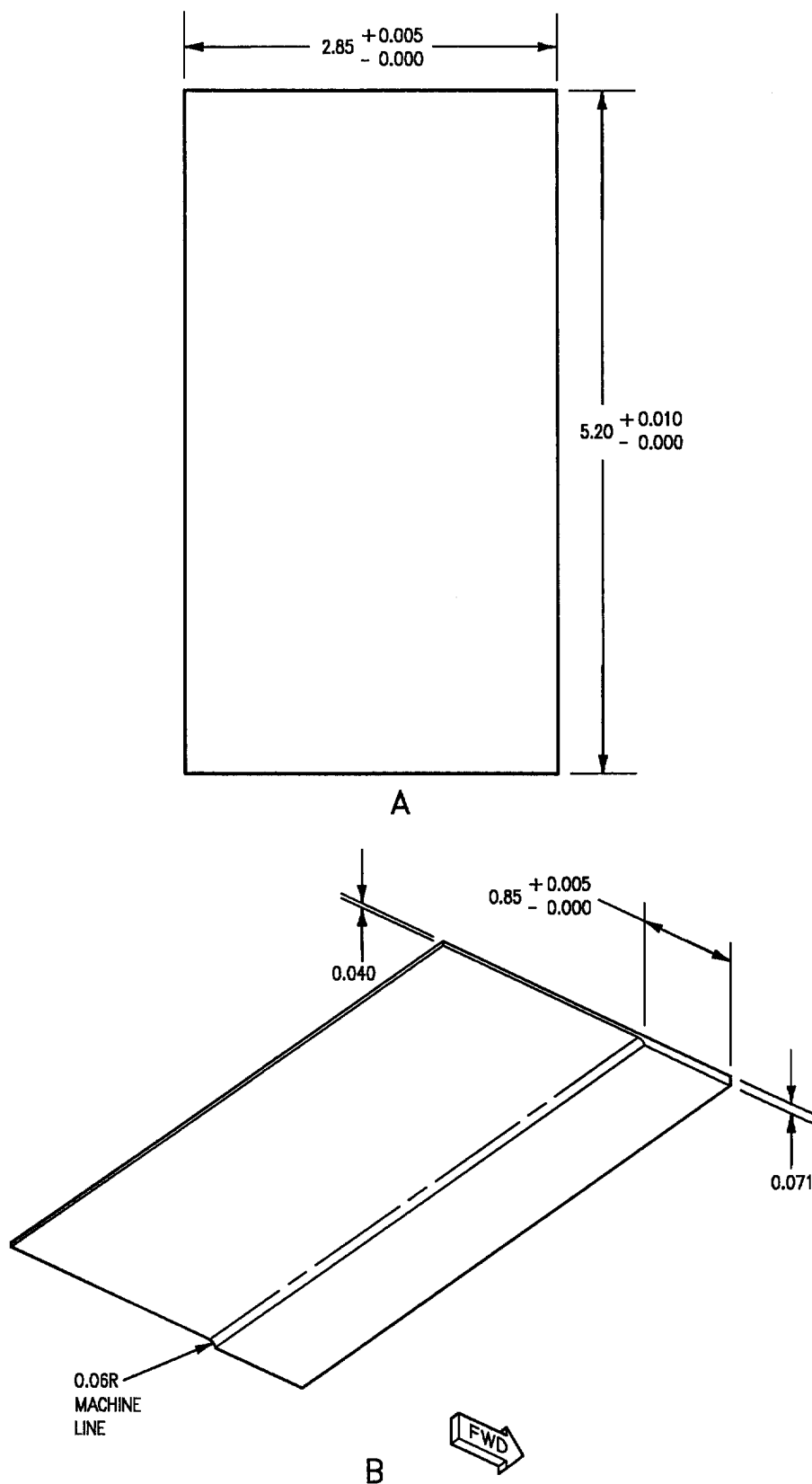
IDX NO.	EFT		NOMENCLATURE	PART NUMBER
25			Gang Channel	3M463N10A3-4
26			Plate Nut	F50403-3-4
27			Plate Nut	F49249E3-6
LEGEND				
 Make from ST3M463N12A4-4 Gang Channel.				
 Make from ST3M463N10A6-4 Gang Channel.				
 161353 THRU 161715.				
 161716 THRU 161987.				
 Hole diameter is 0.191 +0.006 -0.000.				
 Hole diameter is 0.195 +0.007 -0.000.				

Figure 8. Removable Covers, Replacement (Sheet 5)



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Figure 9. Replacement, Skin, 74T030348 (Sheet 1)

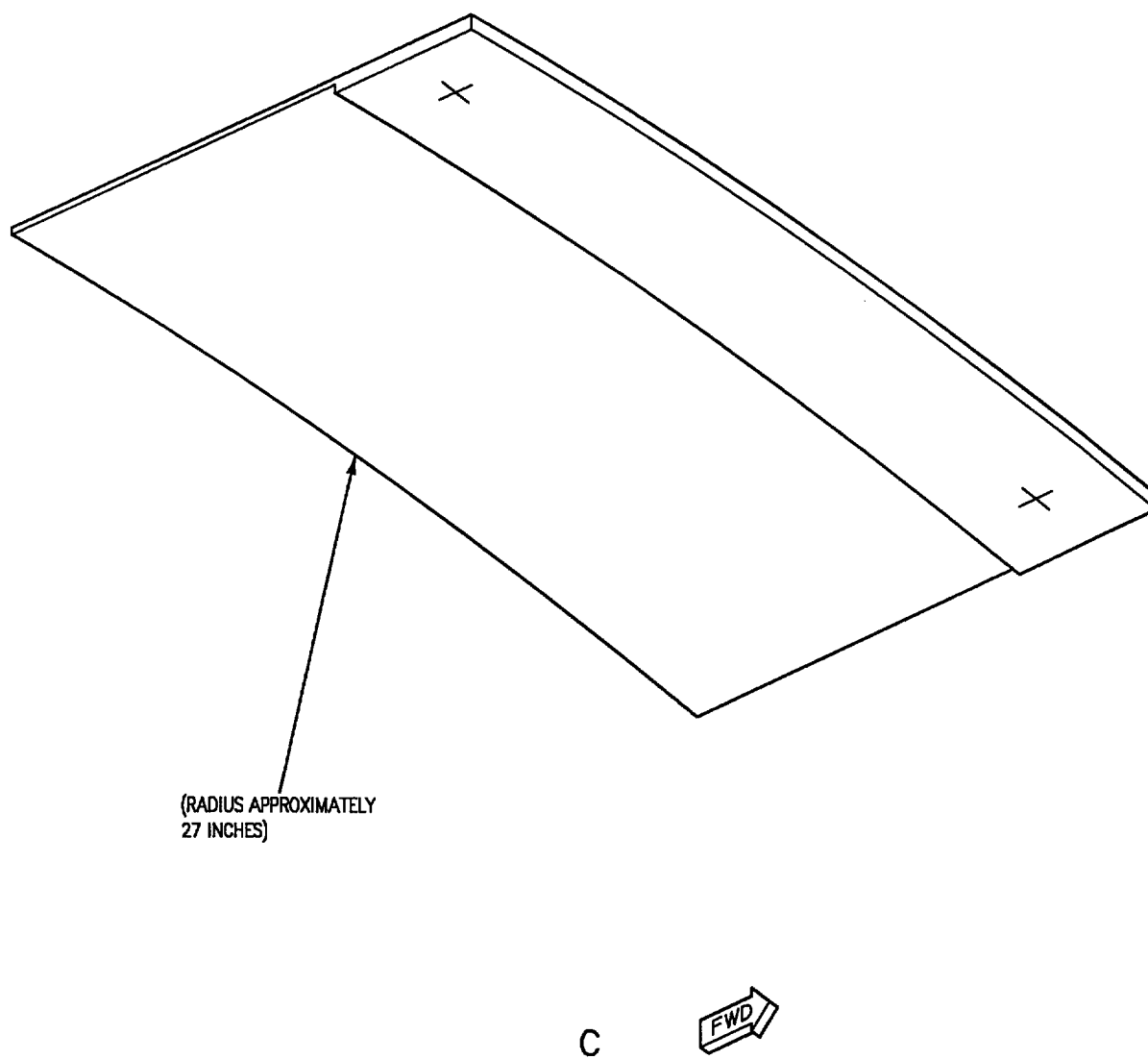


Figure 9. Replacement, Skin, 74T030348 (Sheet 2)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

FORWARD LEADING EDGE EXTENSION STRUCTURE

Reference Material

None

Alphabetical Index

Subject	Page No.
Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1

Record of Applicable Technical Directives

None

Support Equipment Required

None

3. **NEGLIGIBLE DAMAGE.** Damage requires a depot engineering disposition.

Materials Required

None

4. **REPAIRABLE DAMAGE.** Damage requires a depot engineering disposition.

1. **DAMAGE EVALUATION.** See figures 1 and 2.

5. **REPAIRS.**

2. The figure identifies types of material used. The data shown can be used to analyze the damage.

6. Repairs requires a depot engineering disposition.

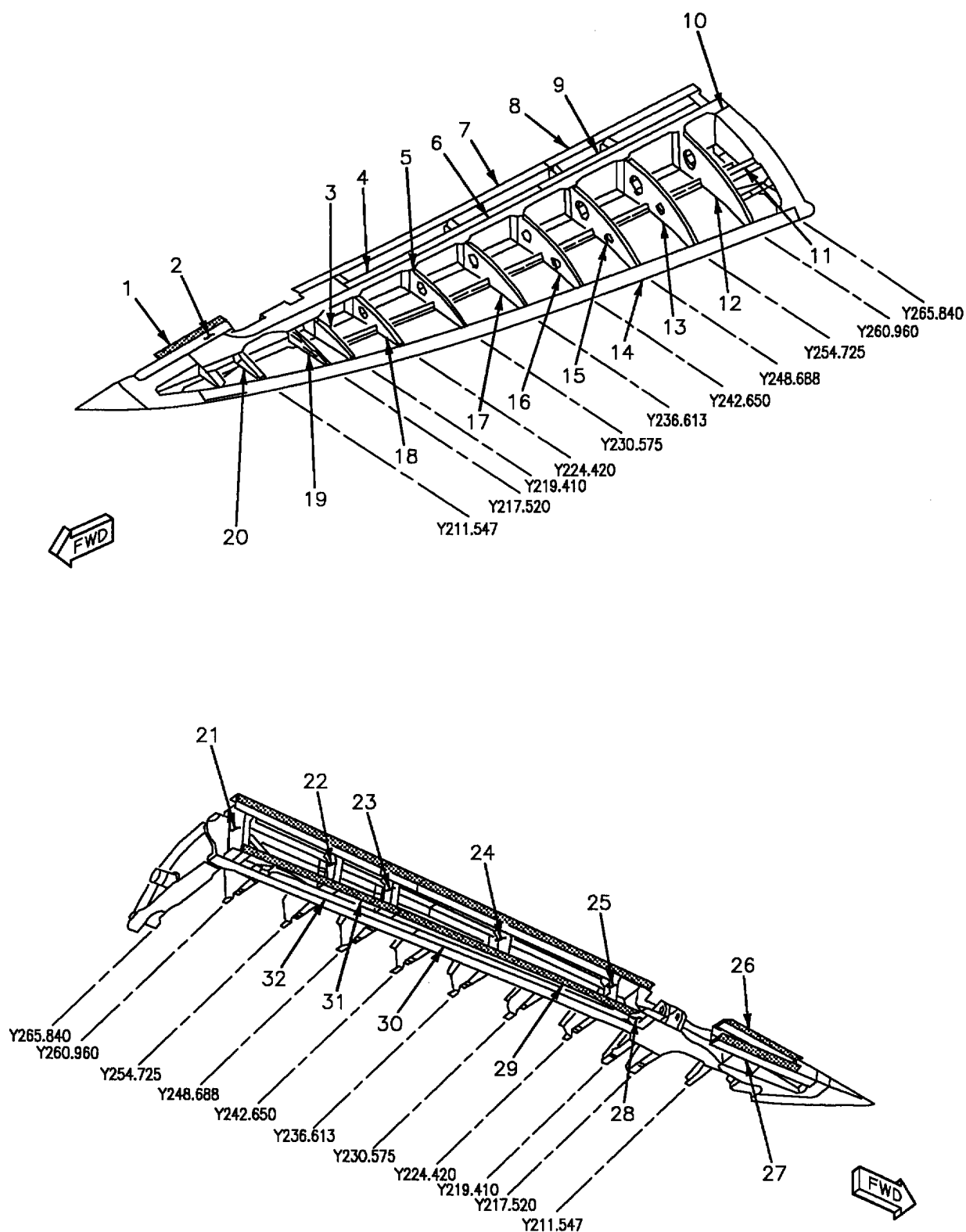


Figure 1. Left Structure Material Index (Sheet 1)


IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Seal 74T030363-2011	11M975-1	Silicone Rubber
2		Rib 74T030318-2013	0.040 Sheet	7075-T6 Alclad
3		Rib 74T030318-2007	0.063 Sheet	7075-T6 Alclad
4		Spar 74T030314-2003	Hand Forging	7050-T73652 Al Aly
5		Rib 74T030318-2011	0.040 Sheet	7075-T6 Alclad
6		Stiffener 74A200676-2069	0.063 Sheet	7075-T6 Alclad
7		Stiffener 74A200676-2077	0.063 Sheet	7075-T6 Alclad
8		Stiffener 74A200676-2075	0.063 Sheet	7075-T6 Alclad
9		Stiffener 74A200676-2067	0.063 Sheet	7075-T6 Alclad
10		Rib 74T030316-2001	Hand Forging	7050-T73652 Al Aly
11		Support 74T030317-2001	Hand Forging	7050-T73652 Al Aly
12		Rib 74T030319-2009	0.050 Sheet	7075-T6 Alclad
13		Rib 74T030319-2007	0.040 Sheet	7075-T6 Alclad
14		Edge 74T030313-2001	2.00 Plate	7075-T73511 Al Aly
15		Rib 74T030319-2005	0.040 Sheet	7075-T6 Alclad
16		Rib 74T030319-2003	0.040 Sheet	7075-T6 Alclad
17		Rib 74T030319-2001	0.040 Sheet	7075-T6 Alclad
18		Rib 74T030318-2009	0.040 Sheet	7075-T6 Alclad

Figure 1. Left Structure Material Index (Sheet 2)





IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Rib 74T030318-2003	0.063 Sheet	7075-T6 Alclad
20		Rib 74T030318-2001	0.040 Sheet	7075-T6 Alclad
21		Former 74A200677-2007	0.040 Sheet	7075-T6 Alclad
22		Former 74A200677-2017	0.040 Sheet	7075-T6 Alclad
23		Former 74A200677-2003	0.040 Sheet	7075-T6 Alclad
24		Former 74A200677-2013	0.040 Sheet	7075-T6 Alclad
25		Former 74A200677-2001	0.040 Sheet	7075-T6 Alclad
26		Rib 74T030318-2017	0.040 Sheet	7075-T6 Alclad
27		Rib 74T030318-2015	0.040 Sheet	7075-T6 Alclad
28		Filler 74A200677-2009	0.063 Sheet	7075-T6 Alclad
29		Stiffener 74A200676-2081	0.063 Sheet	7075-T6 Alclad
30		Stiffener 74A200676-2073	0.063 Sheet	7075-T6 Alclad
31		Stiffener 74A200676-2079	0.063 Sheet	7075-T6 Alclad
32		Stiffener 74A200676-2071	0.063 Sheet	7075-T6 Alclad
LEGEND				
	161353 THRU 161719.			
	161720 AND UP.			

Figure 1. Left Structure Material Index (Sheet 3)

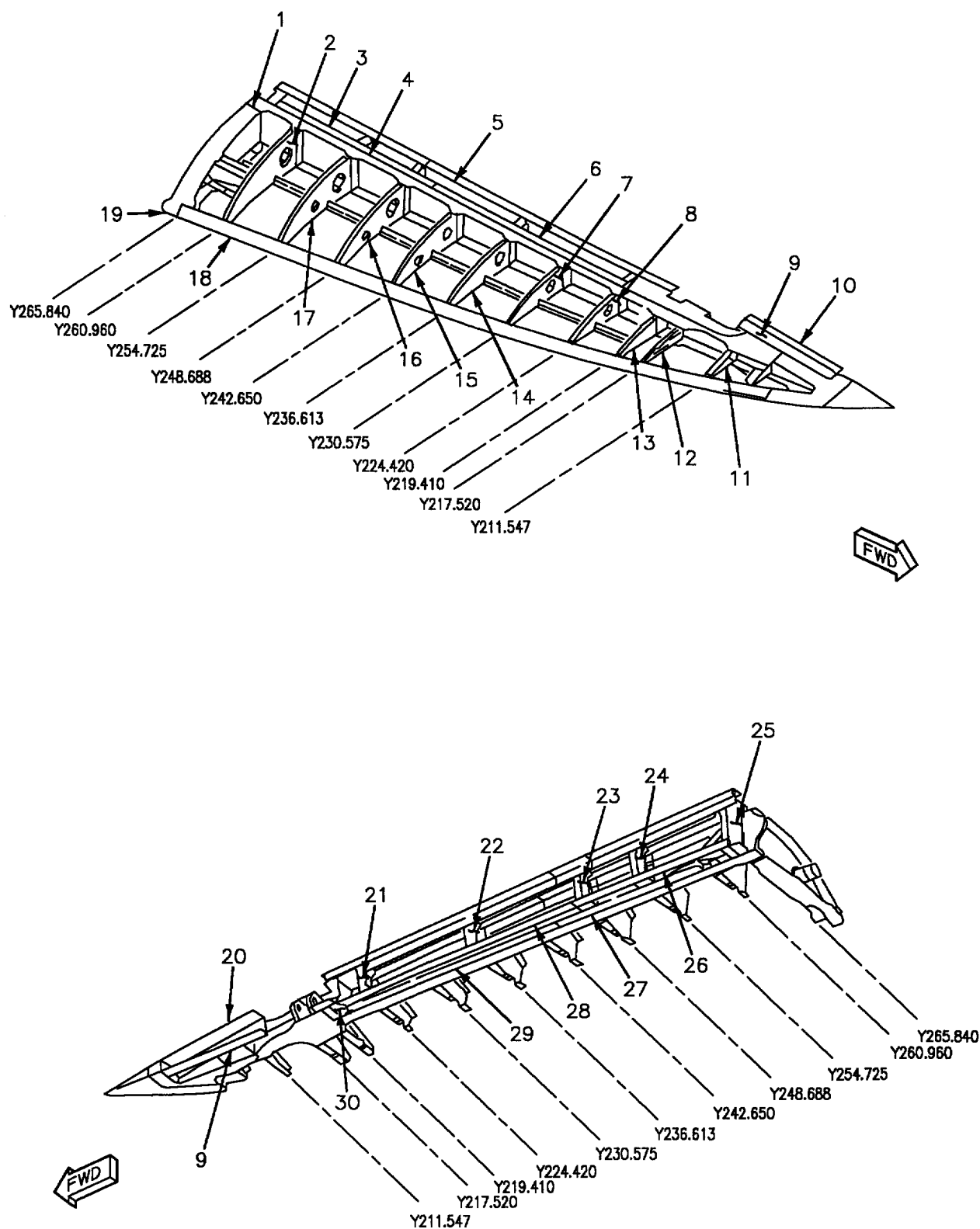


Figure 2. Right Structure Material Index (Sheet 1)


IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Stiffener 74A200676-2076	0.063 Sheet	7075-T6 Alclad
2		Rib 74T030319-2010	0.050 Sheet	7075-T6 Alclad
3		Stiffener 74A200676-2068	0.063 Sheet	7075-T6 Alclad
4		Spar 74T030314-2004	Hand Forging	7075-T73652 Al Aly
5		Stiffener 74A200676-2078	0.063 Sheet	7075-T6 Alclad
6		Stiffener 74A200676-2070	0.063 Sheet	7075-T6 Alclad
7		Rib 74T030318-2012	0.040 Sheet	7075-T6 Alclad
8		Rib 74T030318-2010	0.040 Sheet	7075-T6 Alclad
9		Rib 74T030318-2014	0.040 Sheet	7075-T6 Alclad
10		Seal 74T030363-2012	11M975-1	Silicone Rubber
11		Rib 74T030318-2002	0.040 Sheet	7075-T6 Alclad
12		Rib 74T030318-2004	0.063 Sheet	7075-T6 Alclad
13		Rib 74T030318-2008	0.063 Sheet	7075-T6 Alclad
14		Rib 74T030319-2002	0.040 Sheet	7075-T6 Alclad
15		Rib 74T030319-2004	0.040 Sheet	7075-T6 Alclad
16		Rib 74T030319-2006	0.040 Sheet	7075-T6 Alclad
17		Rib 74T030319-2008	0.040 Sheet	7075-T6 Alclad
18		Edge 74T030313-2002	2.00 Plate	7075-T73511 Al Aly

Figure 2. Right Structure Material Index (Sheet 2)




IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Rib 74T030316-2002	Hand Forging	7050-T73652 Al Aly
20		Rib 74T030318-2018	0.040 Sheet	7075-T6 Alclad
21		Former 74A200677-2002	0.040 Sheet	7075-T6 Alclad
22		Former 74A200677-2014	0.040 Sheet	7075-T6 Alclad
23		Former 74A200677-2004	0.040 Sheet	7075-T6 Alclad
24		Former 74A200677-2018	0.040 Sheet	7076-T6 Alclad
25		Former 74A200677-2008	0.040 Sheet	7075-T6 Alclad
26		Stiffener 74A200676-2080	0.063 Sheet	7075-T6 Alclad
27		Stiffener 74A200676-2072	0.063 Sheet	7075-T6 Alclad
28		Stiffener 74A200676-2082	0.063 Sheet	7075-T6 Alclad
29		Stiffener 74A200676-2074	0.063 Sheet	7075-T6 Alclad
30		Stiffener 74A200677-2009	0.063 Sheet	7075-T6 Alclad
LEGEND				
	161353 THRU 161719.			
	161720 AND UP.			

Figure 2. Right Structure Material Index (Sheet 3)

ORGANIZATIONAL MAINTENANCE

STRUCTURE REPAIR

AFT LEADING EDGE EXTENSION STRUCTURE

Reference Material

None

Alphabetical Index

Subject	Page No.
Damage Evaluation	1
Negligible Damage	1
Repairable Damage	1
Repairs	1

Record of Applicable Technical Directives

Type/ Number	Date	Title and ECP No.	Date Incorp.	Remarks
F18 AFC 102	-	Leading Edge Extension Fence, Provisions for (ECP MDA-F/A-18-00300)	-	-

Support Equipment Required

None

Materials Required

None

1. **DAMAGE EVALUATION.** See figure 1, 2, and 3.

2. The figure identifies types of material used. The data shown can be used to analyze the damage.

3. **NEGLIGIBLE DAMAGE.** Damage requires depot engineering disposition.

4. **REPAIRABLE DAMAGE.** Damage requires depot engineering disposition.

5. **REPAIRS.**

6. Repairs requires depot engineering disposition.

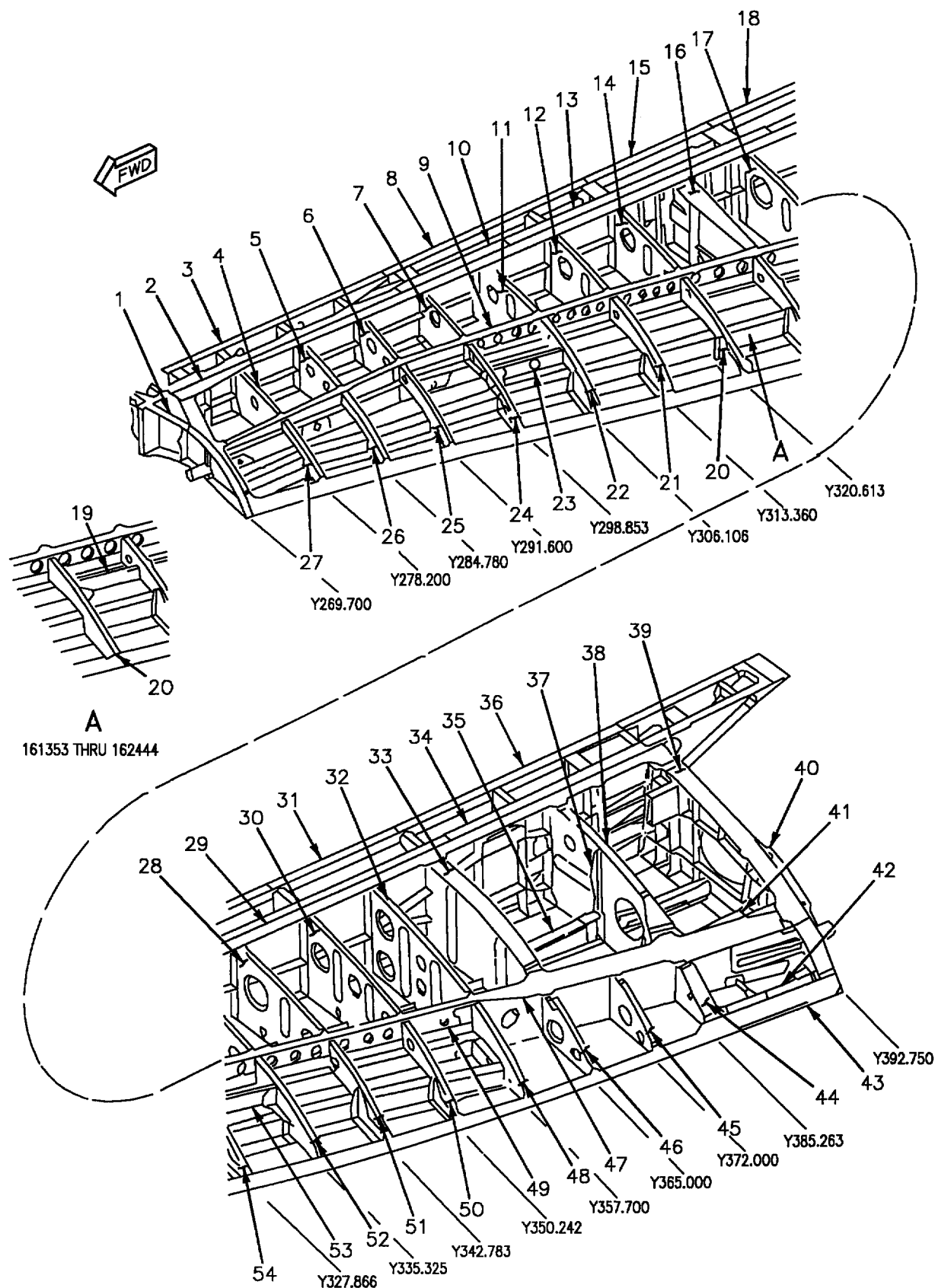
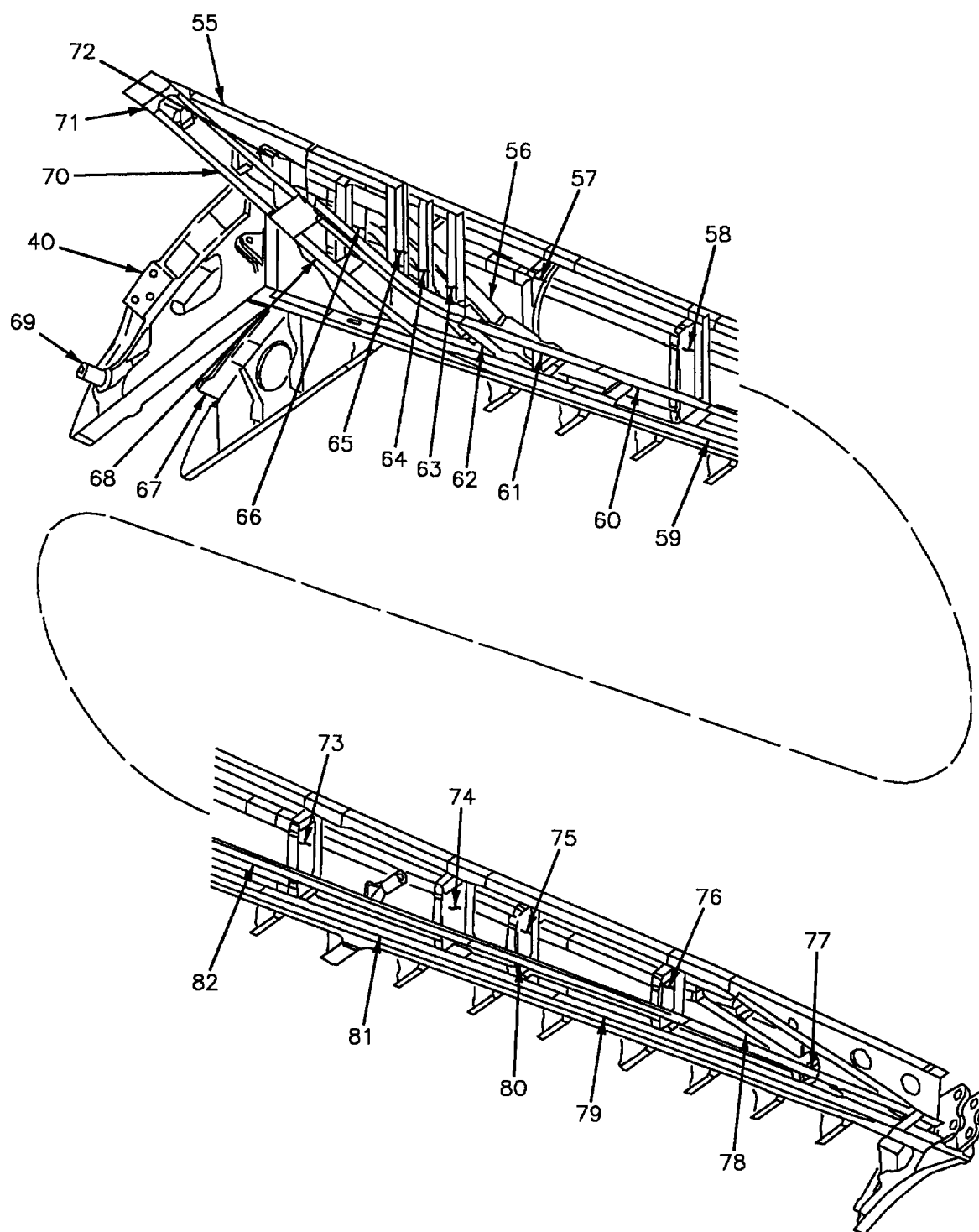


Figure 1. Left Structure Material Index (Sheet 1)



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Figure 1. Left Structure Material Index (Sheet 2)



IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Rib 74T030325-2001	Hand Forging	6Al-4V Ti Anl
2	 	Spar 74T030328-2003 74T030328-2009	Hand Forging	7050-T73652 Al Aly
3		Spar 74T030361-2081	0.032 Sheet	7075-T6 Alclad
4		Rib 74T030342-2001	0.040 Sheet	7075-T6 Alclad
5		Rib 74T030342-2007	0.040 Sheet	7075-T6 Alclad
6		Rib 74T030342-2027	0.040 Sheet	7075-T6 Alclad
7		Rib 74T030342-2019	0.040 Sheet	7075-T6 Alclad
8		Stiffener 74A200676-2007	0.063 Sheet	7075-T6 Alclad
9		Spar 74T030329-2001	Hand Forging	7050-T73652 Al Aly
10		Stiffener 74A200676-2025	0.063 Sheet	7075-T6 Alclad
11		Rib 74T030343-2001	0.040 Sheet	7075-T6 Alclad
12		Rib 74T030343-2011	0.040 Sheet	7075-T6 Alclad
13		Stiffener 74A200676-2023	0.063 Sheet	7075-T6 Alclad
14		Rib 74T030343-2017	0.040 Sheet	7075-T6 Alclad
15		Stiffener 74A200676-2005	0.063 Sheet	7075-T6 Alclad
16		Rib 74T030326-2001	Hand Forging	6Al-4V Ti Anl
17		Rib 74T030343-2023	0.040 Sheet	7075-T6 Alclad

Figure 1. Left Structure Material Index (Sheet 3)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
18		Stiffener 74A200676-2085	0.063 Sheet	7075-T6 Alclad
19	5	Intercostal 74T042741-2001	0.063 Sheet	7075-T6 Alclad
20	6 7	Rib 74T042742-2001 74T042742-2003	2.50 Plate	7075-T7351 Al Aly
	8	Former 74T030341-2027	0.040 Sheet	7075-T6 Alclad
21		Former 74T030341-2001	0.040 Sheet	7075-T6 Alclad
22		Rib 74T030343-2003	0.040 Sheet	7075-T6 Alclad
23		Intercostal 74T030346-2007	0.063 Sheet	7075-T6 Alclad
24	3 4	Rib 74T030339-2011 74T030339-2021	3.00 Plate	7075-T7351 Al Aly
25	3 4	Rib 74T030339-2017 74T030339-2025	3.25 Plate	7075-T7351 Al Aly
26	3 4	Rib 74T030339-2013 74T030339-2019	2.75 Plate	7075-T7351 Al Aly
27	3 4	Rib 74T030339-2015 74T030339-2023	1.75 Plate	7075-T7351 Al Aly
28		Rib 74T030344-2001	0.040 Sheet	7075-T6 Alclad
29		Stiffener 74A200676-2021	0.063 Sheet	7075-T6 Alclad
30		Rib 74T030344-2017	0.040 Sheet	7075-T6 Alclad
31		Stiffener 74A200676-2003	0.063 Sheet	7075-T6 Alclad
32		Rib 74T030344-2015	0.040 Sheet	7075-T6 Alclad

Figure 1. Left Structure Material Index (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
33		Rib 74T030346-2001	0.040 Sheet	7075-T6 Alclad
34		Stiffener 74A200676-2019	0.063 Sheet	7075-T6 Alclad
35		Stringer 74T030350-2005	1MA160D01-10273 Extr	7075-T76 Al Aly
36		Stiffener 74A200676-2001	0.063 Sheet	7075-T6 Alclad
37		Stiffener 74T030345-2025	0.050 Sheet	7075-T6 Alclad
38		Rib 74T030345-2023	0.063 Sheet	7075-T6 Alclad
39		Rib 74T030327-2001	Hand Forging	7050-T411 Al Aly
40	15	Support 74A201033-2001	Machining	7075-T7351 Al Aly
41		Stringer 74T030350-2003	1MA160D01-10273 Extr	7075-T76 Al Aly
42		Sill 74T030349-2001	0.063 Sheet	7075-T6 Alclad
43	5 8	Edge 74T030336-2001 74T030336-2003	0.040 Sheet	7075-T6 Alclad
44		Rib 74T030345-2019	0.040 Sheet	7075-T6 Alclad
45		Rib 74T030345-2013	0.032 Sheet	7075-T6 Alclad
46		Rib 74T030345-2009	0.040 Sheet	7075-T6 Alclad
47		Spar 74T030331-2001	3.00 Plate	7075-T7351 Al Aly
48		Former 74T030341-2017	0.040 Sheet	7075-T6 Alclad
49		Spar 74T030330-2001	1MA10472D05 Extr	7075-T73511 Al Aly

Figure 1. Left Structure Material Index (Sheet 5)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
50		Former 74T030341-2013	0.040 Sheet	7076-T6 Alclad
51		Former 74T030341-2009	0.040 Sheet	7075-T6 Alclad
52	9 10	Rib 74T030340-2001 74T030340-2005	3.00 Plate	7075-T7351 Al Aly
53		Intercostal 74T030346-2011	0.050 Sheet	7075-T6 Alclad
54		Former 74T030341-2005	0.040 Sheet	7075-T6 Alclad
55		Channel 74A200723-2003	0.063 Sheet	7075-T6 Alclad
56		Stringer 74A200729-2007	1MA160D01-10326 Extr	7075-T76 Al Aly
57		Former 74A200674-2197	0.040 Sheet	7075-T6 Alclad
58		Former 74A200674-2027	0.040 Sheet	7075-T6 Alclad
59		Stiffener 74A200676-2029	0.063 Sheet	7075-T6 Alclad
60		Stiffener 74A200676-2011	0.063 Sheet	7075-T6 Alclad
61		Stringer 74A200729-2027	1MA160D01-10326 Extr	7075-T76 Alclad
62	11 12	Stiffener 74A200725-2001 74A200725-2007	1MA160D01-10348 Extr	7075-T76 Al Aly
63		Stiffener 74A200729-2009	0.063 Sheet	7075-T6 Alclad
64		Stiffener 74A200729-2013	0.063 Sheet	7075-T6 Alclad
65		Stiffener 74A200729-2017	1MA180D06-10237 Extr	7075-T76511 Al Aly
66		Tee 74A200674-2153	1MA160D06-10218 Extr	7075-T76511 Al Aly

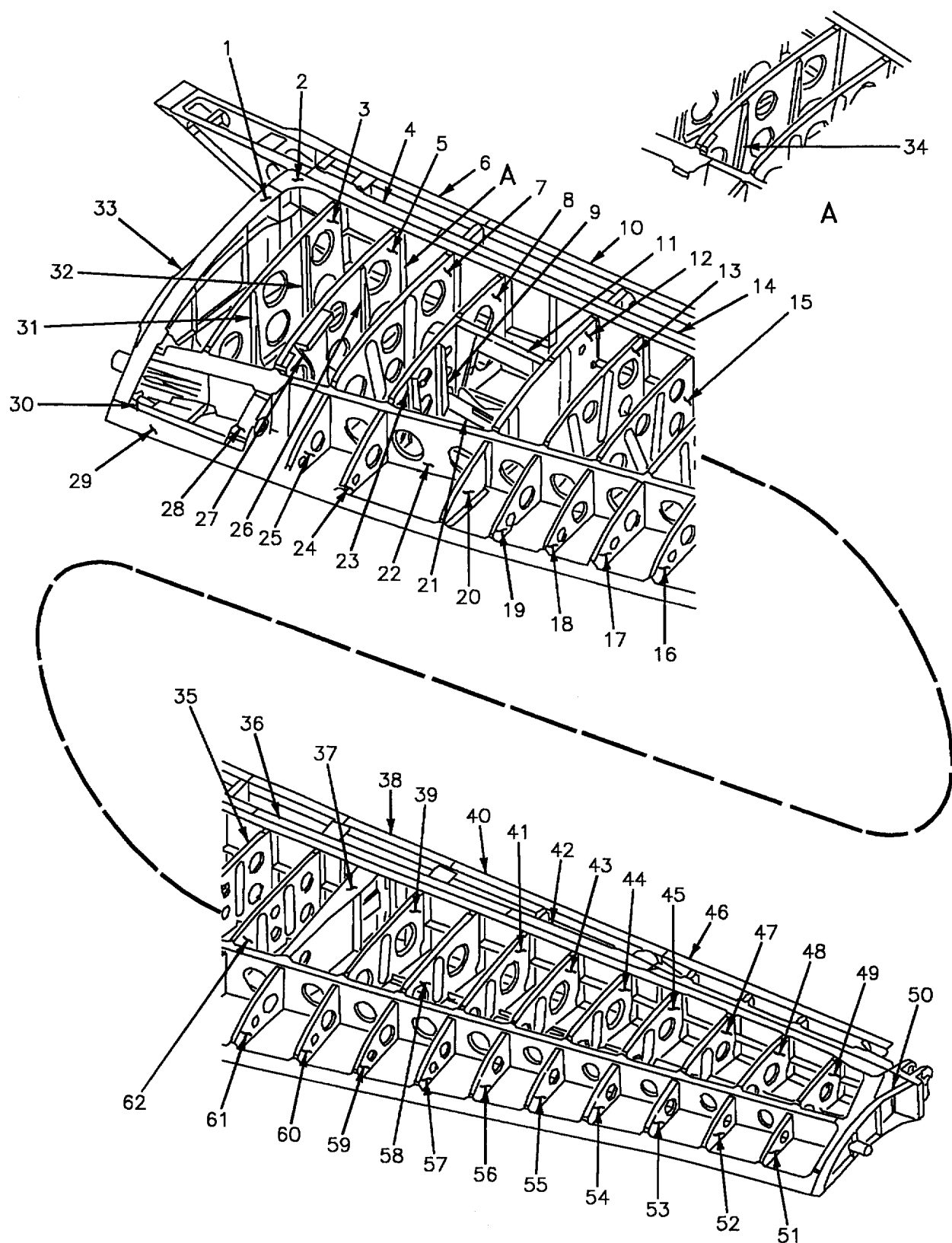
Figure 1. Left Structure Material Index (Sheet 6)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL	
67	<div>15</div>	Support 74A201033-2003	Machining	7075-T7351 Al Aly	
68		Stiffener 74A200676-2027	1MA160D01-10503 Extr	7075-T6 Alclad	
69		Spar 74T030332-2001	Hand Forging	6Al-4V Ti Anl	
70		Channel 74A200723-2001	0.063 Sheet	7075-T6 Alclad	
71		Arrowhead 74A200722-2001	1.25 Plate	7075-T7351 Al Aly	
72		Tee 74A200674-2171	1MA160D06-10218 Extr	7075-T76511 Al Aly	
73		Former 74A200674-2205	0.040 Sheet	7075-T6 Alclad	
74		Former 74A200674-2011	0.040 Sheet	7075-T6 Alclad	
75		Former 74A200674-2073	0.040 Sheet	7075-T6 Alclad	
76		<div>13</div> <div>14</div>	Former 74A200674-2207	0.040 Sheet	7075-T6 Alclad
			74A200674-2233		
77		Former 74A200674-2001	0.040 Sheet	7075-T6 Alclad	
78		Stiffener 74A200676-2017	0.063 Sheet	7075-T6 Alclad	
79		Stiffener 74A200676-2033	0.063 Sheet	7075-T6 Alclad	
80		Stiffener 74A200676-2015	0.063 Sheet	7075-T6 Alclad	
81		Stiffener 74A200676-2031	0.063 Sheet	7075-T6 Alclad	
82		Stiffener 74A200676-2013	0.063 Sheet	7075-T6 Alclad	
LEGEND					
<div>1</div> 161353 THRU 161528.					

Figure 1. Left Structure Material Index (Sheet 7)

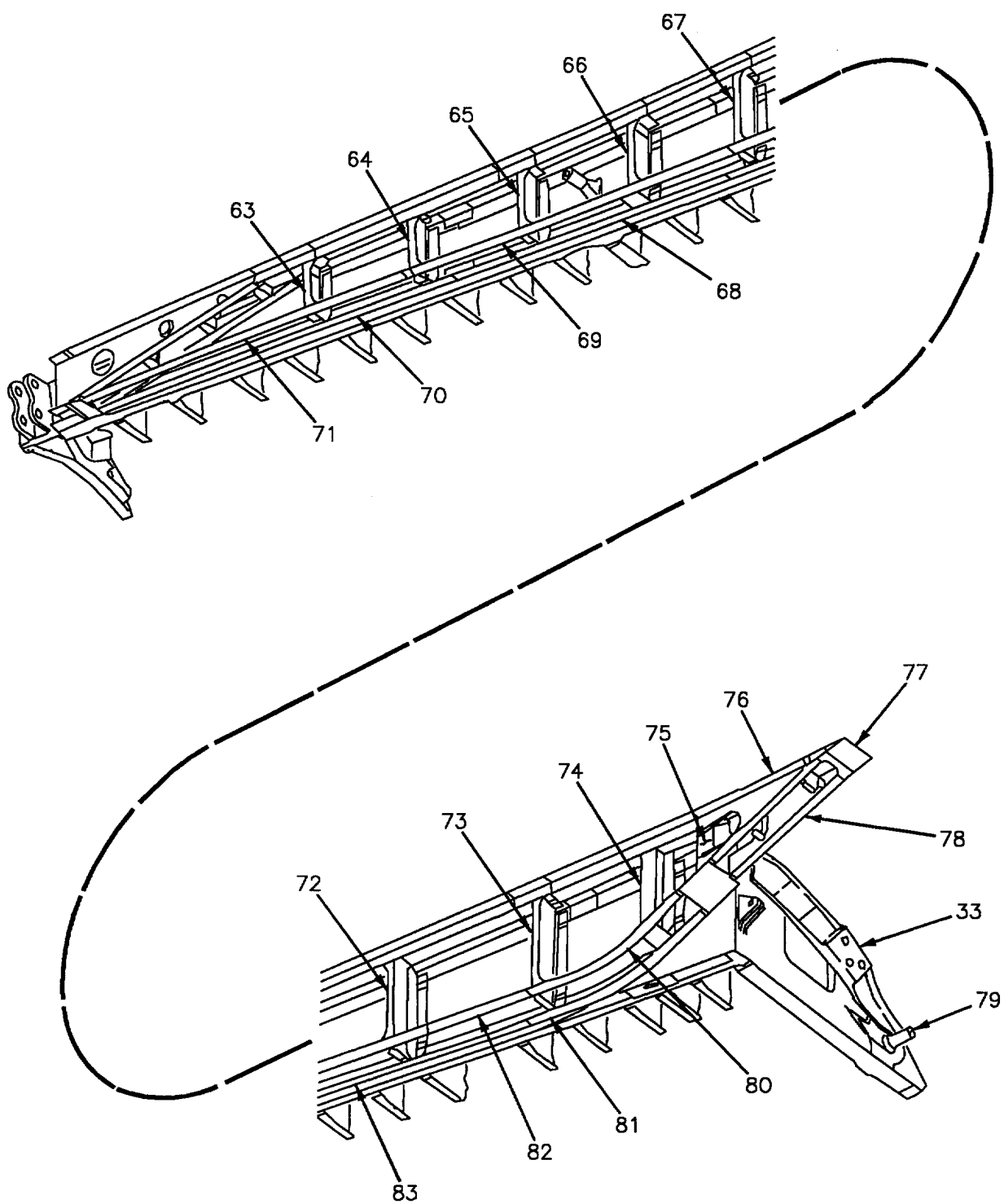
IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
2		161702 AND UP.		
3		161353 THRU 161718.		
4		161720 AND UP.		
5		161353 THRU 162444.		
6		161353 THRU 161759.		
7		161760 THRU 162444.		
8		162445 AND UP.		
9		161353 THRU 161734.		
10		161735 AND UP.		
11		161353 THRU 161527.		
12		161528 AND UP.		
13		161353 THRU 161359.		
14		161360 AND UP.		
15		F/A-18A, F/A-18B AFTER F/A-18 AFC 102.		

Figure 1. Left Structure Material Index (Sheet 8)



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Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 1)



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Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 2)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Rib 74T030372-2007	Hand Forging	7050-T411 Al Aly
2		Spar 74T030373-2003	Hand Forging	7050-T-73652 Al Aly
3		Rib 74T030386-2029	0.040 Sheet	7075-T6 Alclad
4		Stiffener 74A200676-2057	0.063 Sheet	7075-T6 Alclad
5		Rib 74T030386-2031	0.040 Sheet	7075-T6 Alclad
6		Stiffener 74A200676-2041	0.063 Sheet	7075-T6 Alclad
7		Rib 74T030386-2001	0.040 Sheet	7075-T6 Alclad
8		Rib 74T030385-2017	0.040 Sheet	7075-T6 Alclad
9		Stiffener 74T030380-2013	0.040 Sheet	7075-T6 Alclad
10		Stiffener 74A200676-2039	0.063 Sheet	7075-T6 Alclad
11		Support 74T030380-2007	0.040 Sheet	7075-T6 Alclad
12		Rib 74T030385-2009	0.040 Sheet	7075-T6 Alclad
13		Rib 74T030385-2005	0.040 Sheet	7075-T6 Alclad
14		Stiffener 74A200676-2055	0.063 Sheet	7075-T6 Alclad
15		Rib 74T030385-2001	0.040 Sheet	7075-T6 Alclad
16		Rib 74T030384-2009	0.032 Sheet	7075-T6 Alclad
17		Rib 74T030384-2013	0.032 Sheet	7075-T6 Alclad
18		Rib 74T030385-2003	0.032 Sheet	7075-T6 Alclad

Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 3)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Rib 74T030385-2007	0.032 Sheet	7075-T6 Alclad
20		Rib 74T030385-2011	0.032 Sheet	7075-T6 Alclad
21		Support 74T030380-2005	0.050 Sheet	7075-T6 Alclad
22		Spar 74T030374-2005	0.040 Sheet	7075-T6 Alclad
23		Stiffener 74T030380-2013	0.040 Sheet	7075-T6 Alclad
24		Rib 74T030385-2015	0.032 Sheet	7075-T6 Alclad
25		Rib 74T030386-2003	0.032 Sheet	7075-T6 Alclad
26		Stiffener 74T030386-2007	0.040 Sheet	7075-T6 Alclad
27	2	Support 74A201033-2031	Machining	7075-T7351 Al Aly
28		Rib 74T030386-2013	0.040 Sheet	7075-T6 Alclad
29		Edge 74T030379-2001	0.040 Sheet	7075-T6 Alclad
30		Sill 74T030349-2002	0.063 Sheet	7075-T6 Alclad
31		Stiffener 74T030386-2033	0.040 Sheet	7075-T6 Alclad
32		Stiffener 74T030386-2019	0.040 Sheet	7075-T6 Alclad
33	2	Support 74A201033-2027	Machining	7075-T7351 Al Aly
34	1	Stiffener 74T030386-2009	0.040 Sheet	7075-T6 Alclad
35		Rib 74T030384-2011	0.040 Sheet	7075-T6 Alclad
36		Stiffener 74A200676-2053	0.063 Sheet	7075-T6 Alclad

Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
37		Rib 74T030371-2001	Hand Forging	6Al-4V Ti Anl
38		Stiffener 74A200676-2037	0.063 Sheet	7075-T6 Alclad
39		Rib 74T030384-2001	0.040 Sheet	7076-T6 Alclad
40		Stiffener 74A200676-2083	0.063 Sheet	7075-T6 Alclad
41		Rib 74T030383-2009	0.040 Sheet	7075-T6 Alclad
42		Stiffener 74A200676-2051	0.063 Sheet	7075-T6 Alclad
43		Rib 74T030383-2005	0.040 Sheet	7075-T6 Alclad
44		Rib 74T030383-2001	0.040 Sheet	7075-T6 Alclad
45		Rib 74T030382-2013	0.040 Sheet	7075-T6 Alclad
46		Stiffener 74A200676-2035	0.032 Sheet	7075-T6 Alclad
47		Rib 74T030382-2009	0.040 Sheet	7075-T6 Alclad
48		Rib 74T030382-2005	0.040 Sheet	7075-T6 Alclad
49		Rib 74T030382-2001	0.040 Sheet	7075-T6 Alclad
50		Rib 74T030370-2001	Hand Forging	6Al-4V Ti Anl
51		Rib 74T030382-2003	0.032 Sheet	7075-T6 Alclad
52		Rib 74T030382-2007	0.032 Sheet	7075-T6 Alclad
53		Rib 74T030382-2011	0.032 Sheet	7075-T6 Alclad
54		Rib 74T030382-2015	0.032 Sheet	7075-T6 Alclad

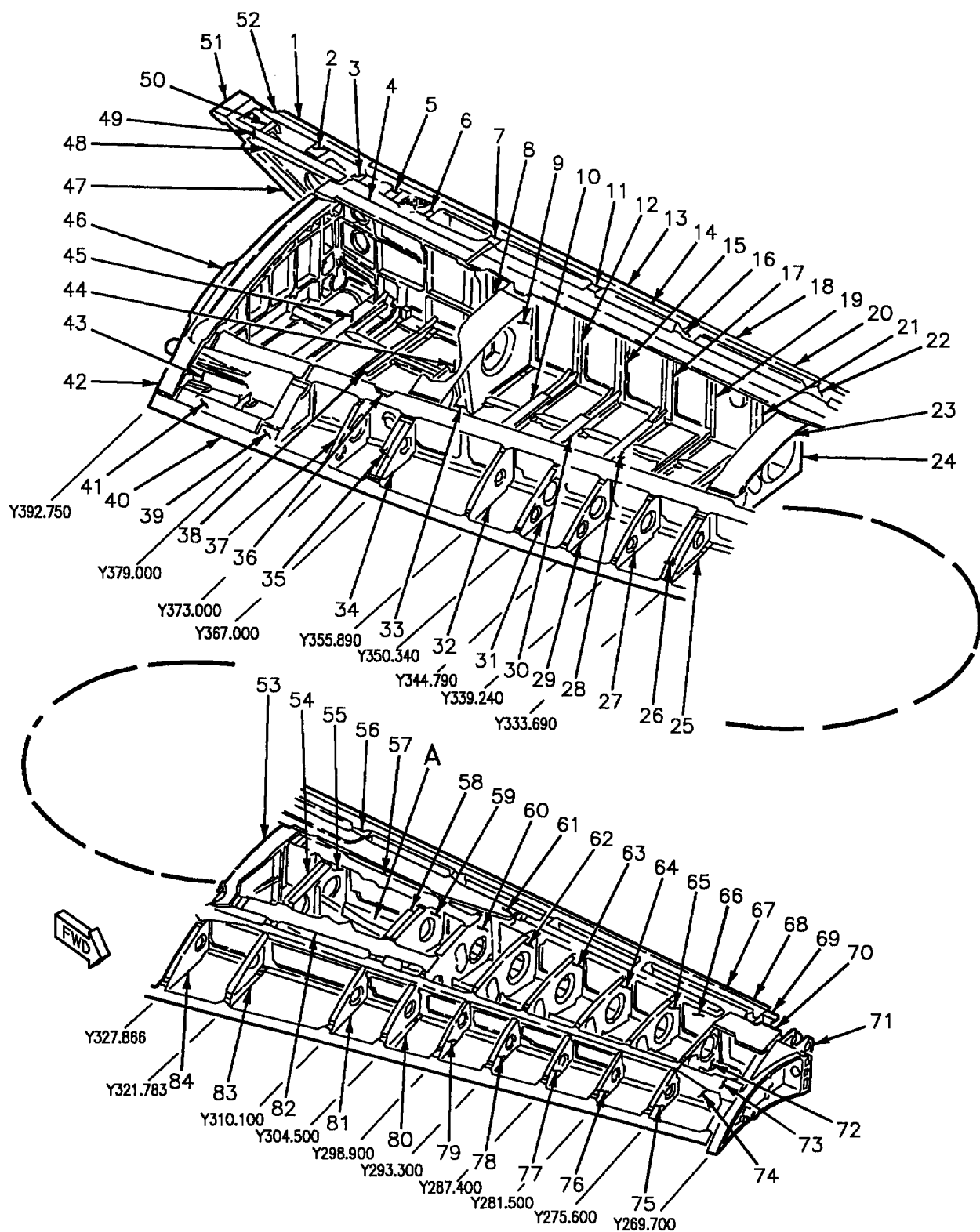
Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 5)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
55		Rib 74T030383-2003	0.032 Sheet	7075-T6 Alclad
56		Rib 74T030383-2007	0.032 Sheet	7075-T6 Alclad
57		Rib 74T030383-2011	0.032 Sheet	7075-T6 Alclad
58		Rib 74T030383-2013	0.040 Sheet	7075-T6 Alclad
59		Rib 74T030383-2015	0.032 Sheet	7075-T6 Alclad
60		Rib 74T030384-2003	0.032 Sheet	7075-T6 Alclad
61		Rib 74T030384-2005	0.032 Sheet	7075-T6 Alclad
62		Rib 74T030384-2007	0.040 Sheet	7075-T6 Alclad
63		Former 74A200674-2207	0.040 Sheet	7075-T6 Alclad
64		Former 74A200674-2073	0.040 Sheet	7075-T6 Alclad
65		Former 74A200674-2045	0.040 Sheet	7075-T6 Alclad
66		Former 74A200674-2053	0.040 Sheet	7075-T6 Alclad
67		Former 74A200674-2061	0.040 Sheet	7075-T6 Alclad
68		Stiffener 74A200676-2061	0.063 Sheet	7075-T6 Alclad
69		Stiffener 74A200676-2045	0.063 Sheet	7075-T6 Alclad
70		Stiffener 74A200676-2059	0.063 Sheet	7075-T6 Alclad
71		Stiffener 74A200676-2043	0.063 Sheet	7075-T6 Alclad
72		Former 74A200674-2065	0.040 Sheet	7075-T6 Alclad

Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 6)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
73		Former 74A200674-2069	0.040 Sheet	7075-T6 Alclad
74		Tee 74A200674-2223	1MA160D06-10218 Extr	7075-T76511 Al Aly
75		Tee 74A200674-2172	1MA160D06-10218 Extr	7075-T76511 Al Aly
76		Channel 74A200723-2002	0.063 Sheet	7075-T6 Alclad
77		Arrowhead 74A200722-2002	1.25 Plate	7075-T7351 Al Aly
78		Channel 74A200723-2004	0.063 Sheet	7075-T6 Alclad
79		Spar 74T030332-2001	Hand Forging	6Al-4V Ti Anl
80		Stiffener 74A200676-2049	0.063 Sheet	7075-T6 Alclad
81		Stiffener 74A200676-2065	0.063 Sheet	7075-T6 Alclad
82		Stiffener 74A200676-2047	0.063 Sheet	7075-T6 Alclad
83		Stiffener 74A200676-2063	0.063 Sheet	7075-T6 Alclad
LEGEND				
<div>1</div> F/A-18A, F/A-18B BEFORE F/A-18 AFC 102.				
<div>2</div> F/A-18A, F/A-18B AFTER F/A-18 AFC 102.				

Figure 2. Right Structure Material Index (161353 THRU 161987) (Sheet 7)



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Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 1)

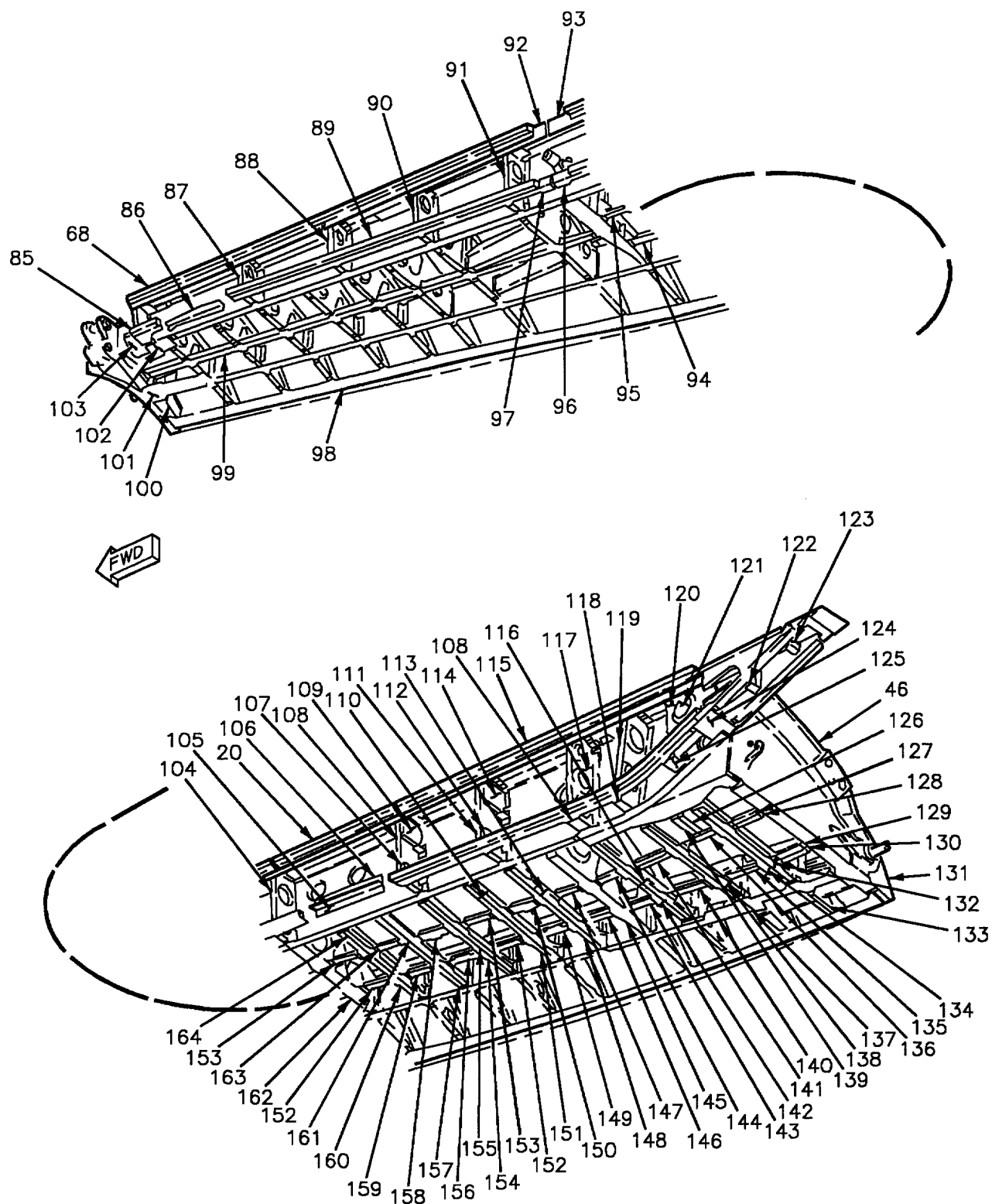


Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 2)

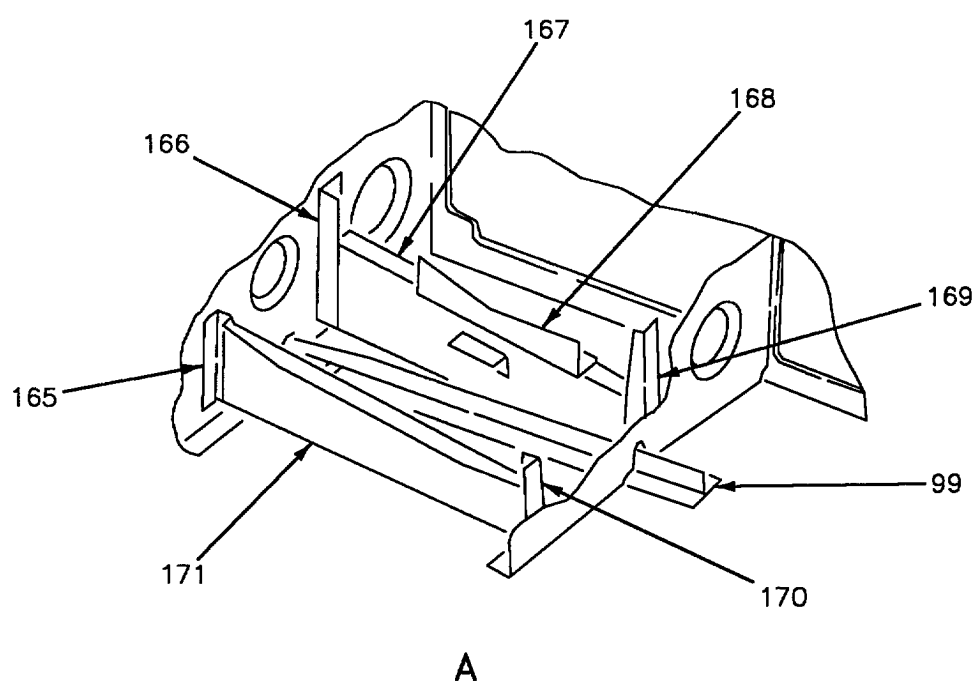


Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 3)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
1		Seal 74A200723-2019	11M975-1 Extr	Silicon Rubber
2		Tee 74A200723-2012	1MA160D06-10449 Extr	7075-T76511 Al Aly
3		Angle 74A200971-2011	0.063 Sheet	7075-T6 Al Aly
4		Spar 74A200930-2003	Hand Forging	7050-T73652 Al Aly
5		Tee 74A200982-2015	1MA160D01-10218 Extr	7075-T76 Al Aly
6		Former 74A200982-2015	0.050 Sheet	7075-T6 Al Aly
7		Tee 74A200982-2017	1MA160D01-10274 Extr	7075-T76 Al Aly
8		Rib 74A200940-2001	2.50 Plate	7075-T7351 Al Aly
9		Rib 74A200974-2001	0.071 Sheet	7075-T6 Al Aly
10		Cap 74A200976-2041	0.032 Sheet	7075-T6 Alclad
11		Tee 74A200982-2025	1MA160D01-10237 Extr	7075-T76 Al Aly
12		Stiffener 74A200973-2021	1MA160D01-10518 Extr	7075-T76 Al Aly
13		Seal 74A200963-2027	11M1021-1 Extr	Silicon Rubber
14		Stiffener 74A200951-2005	1MA10564D01 Extr	7075-T76 Al Aly
15		Stiffener 74A200973-2019	1MA160D01-10518 Extr	7075-T76 Al Aly
16		Tee 74A200982-2031	1MA160D01-10468 Extr	7075-T76 Al Aly
17		Stiffener 74A200973-2017	1MA160D01-10518 Extr	7075-T76 Al Aly
18		Stiffener 74A200951-2003	1MA10564D01 Extr	7075-T76 Al Aly

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 4)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
19		Stiffener 74A200973-2015	1MA160D01-10518 Extr	7075-T76 Al Aly
20		Seal 74A200963-2025	11M1021-1 Extr	Silicon Rubber
21		Stiffener 74A200973-2013	1MA160D01-10518 Extr	7075-T76 Al Aly
22		Tee 74A200982-2035	1MA160D01-10468 Extr	7075-T76 Al Aly
23		Rib Cap 74A200939-2001	2.25 Plate	7075-T7351 Al Aly
24		Rib 74A200964-2001	0.063 Sheet	7075-T6 Alclad
25		Rib 74A200972-2005	0.040 Sheet	7075-T6 Alclad
26		Angle 74A200972-2007	0.040 Sheet	7075-T6 Alclad
27		Rib 74A200981-2001	0.032 Sheet	7075-T6 Alclad
28		Cap 74A200976-2037	0.040 Sheet	7075-T6 Alclad
29		Rib 74A200985-2001	0.032 Sheet	7075-T6 Alclad
30		Cap 74A200976-2039	0.032 Sheet	7075-T6 Alclad
31		Rib 74A200980-2003	0.032 Sheet	7075-T6 Alclad
32		Rib 74A200986-2001	0.032 Sheet	7075-T6 Alclad
33		Angle 74A200968-2003	0.050 Sheet	7075-T6 Alclad
34		Rib 74A200988-2001	0.050 Sheet	7075-T6 Alclad
35		Rib 74A200988-2003	0.050 Sheet	7075-T6 Alclad
36		Angle 74A200991-2001	0.125 Sheet	7075-T76 Al Aly

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 5)


IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
37		Rib 74A200984-2001	0.032 Sheet	7075-T6 Alclad
38		Cap 74A200976-2045	0.063 Sheet	7075-T6 Alclad
39		Rib 74A200946-2001	2.75 Plate	7075-T7351 Al Aly
40		Edge Section 74T030379-2005	0.040 Sheet	7075-T6 Alclad
41		Sill 74T030349-2004	0.063 Sheet	7075-T6 Alclad
42		Rib 74A200941-2001	Hand Forging	7050-T73652 Al Aly
43		Support 74A200932-2003	Hand Forging	7050-T73652 Al Aly
44		Cap 74A200976-2043	0.032 Sheet	7075-T6 Alclad
45		Cap 74A200976-2047	0.032 Sheet	7075-T6 Alclad
46		Support 74A201033-2029	Machining	7075-T7351 Al Aly
47		Seal 74A200723-2025	11M975-1 Extr	Silicon Rubber
48		Seal 74A200723-2021	11M975-1 Extr	Silicon Rubber
49		Channel 74A200723-2002	0.063 Sheet	7075-T6 Alclad
50		Angle 74A200723-2016	0.063 Sheet	7075-T6 Alclad
51		Arrow Head 74A200722-2002	1.25 Plate	7075-T7351 Al Aly
52		Channel 74A200723-2004	0.063 Sheet	7075-T6 Alclad
53		Rib 74A200938-2001	Hand Forging	6Al-4V Ti Aly
54		Rib 74A200995-2005	0.071 Sheet	7075-T6 Alclad

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 6)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
55		Rib 74A200995-2001	0.071 Sheet	7075-T6 Alclad
56		Tee 74A200982-2037	1MA160D01-10468 Extr	7075-T76 Al Aly
57		Stringer 74A200994-2001	1MA160D01-10149 Extr	7075-T76 Al Aly
58		Rib 74A200957-2007	0.071 Sheet	7075-T6 Alclad
59		Rib 74A200957-2003	0.071 Sheet	7075-T6 Alclad
60		Rib 74A200956-2003	0.063 Sheet	7075-T6 Alclad
61		Rib 74A200936-2001	0.040 Sheet	7075-T6 Alclad
62		Rib 74A200955-2001	0.040 Sheet	7075-T6 Alclad
63		Rib 74A200967-2001	0.040 Sheet	7075-T6 Alclad
64		Rib 74A200966-2001	0.040 Sheet	7075-T6 Alclad
65		Rib 74A200965-2001	0.040 Sheet	7075-T6 Alclad
66		Spar 74A200929-2001	0.090 Sheet	7075-T76 Alclad
67		Stiffener 74A200951-2001	1MA10564D01 Extr	7075-T76 Al Aly
68		Seal 74A200963-2023	11M1021-1 Extr	Silicon Rubber
69		Plate 74A200982-2041	0.190 Sheet	7075-T76 Alclad
70	<div><div>1</div><div>2</div></div>	Splice Fitting 74A200931-2005 74A200931-2003	2.75 Plate	7075-T7351 Al Aly
71		Rib 74A200933-2003	Hand Forging	6Al-4V Ti Aly

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 7)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
72		Rib 74A200935-2001	0.040 Sheet	7075-T6 Alclad
73		Tee 74A200949-2001	1MA160D01-10519 Extr	7075-T76 Al Aly
74		Spar 74A200927-2003	0.063 Sheet	7075-T6 Alclad
75		Rib 74A201000-2001	0.032 Sheet	7075-T6 Alclad
76		Rib 74A201000-2003	0.032 Sheet	7075-T6 Alclad
77		Rib 74A201000-2005	0.032 Sheet	7075-T6 Alclad
78		Rib 74A201000-2007	0.032 Sheet	7075-T6 Alclad
79		Rib 74A201001-2001	0.032 Sheet	7075-T6 Alclad
80		Rib 74A201001-2003	0.032 Sheet	7075-T6 Alclad
81		Rib 74A201001-2005	0.032 Sheet	7075-T6 Alclad
82		Stringer 74A200994-2003	1MA160D01-10149 Extr	7075-T76 Al Aly
83		Rib 74A201002-2001	0.032 Sheet	7075-T6 Alclad
84		Rib 74A201002-2003	0.032 Sheet	7075-T6 Alclad
85	3 4	Former 74A200982-2043 74A200982-2055	0.040 Sheet	7075-T6 Alclad
86		Stiffener 74A200973-2023	1MA100D01-10387 Extr	7075-T76 Al Aly
87		Former 74A200969-2001	0.040 Sheet	7075-T6 Alclad
88		Former 74A200969-2007	0.040 Sheet	7075-T6 Alclad

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 8)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
89	<div>5</div> <div>6</div>	Seal 74A200963-2029 74A200963-2037	11M1021-1 Extr	Silicon Rubber
90		Former 74A200969-2009	0.040 Sheet	7075-T6 Alclad
91		Former 74A200970-2001	0.050 Sheet	7075-T6 Alclad
92		Stiffener 74A200951-2001	1MA10564D01 Extr	7075-T76 Al Aly
93		Stiffener 74A200951-2005	1MA10564D01 Extr	7075-T76 Al Aly
94		Stiffener 74A200996-2003	1MA161D01-10000 Extr	7075-T76 Al Aly
95		Stiffener 74A200996-2001	1MA161D01-10000 Extr	7075-T76 Al Aly
96		Stiffener 74A200951-2009	1MA10564D01 Extr	7075-T76 Al Aly
97		Stiffener 74A200951-2007	1MA10564D01 Extr	7075-T76 Al Aly
98		Edge Section 74T030379-2005	0.040 Sheet	7075-T6 Alclad
99		Stringer 74A201007-2001	1MA160D01-10273 Extr	7075-T76 Al Aly
100		Rib 74A200933-2003	Hand Forging	6Al-4V Ti Aly
101		Strap 74A200937-2003	0.071 Sheet	7075-T6 Alclad
102	<div>1</div> <div>2</div>	Splice Fitting 74A200931-2005 74A200931-2003	2.75 Plate	7075-T73651 Al Aly
103		Plate 74A200982-2053	0.160 Sheet	7075-T76 Al Aly
104		Former 74A200970-2003	0.050 Sheet	7075-T6 Alclad
105		Stiffener 74A200973-2025	1MA100D01-10387 Extr	7075-T76 Al Aly

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 9)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
106		Stiffener 74A200973-2027	1MA100D01-10047 Extr	7075-T76 Al Aly
107		Former 74A200970-2007	0.040 Sheet	7075-T6 Alclad
108		Tee 74A200982-2019	1MA160D01-10274 Extr	7075-T76 Alclad
109		Former 74A200970-2005	0.040 Sheet	7075-T6 Alclad
110		Former 74A200976-2015	0.040 Sheet	7075-T6 Alclad
111		Angle 74A200982-2051	1MA100D06-10014 Extr	7075-T76511 Al Aly
112		Former 74A200970-2011	0.040 Sheet	7076-T6 Alclad
113		Former 74A200976-2019	0.040 Sheet	7075-T6 Alclad
114		Former 74A200970-2009	0.040 Sheet	7075-T6 Alclad
115		Seal 74A200963-2027	11M1021-1 Extr	Silicon Rubber
116		Former 74A200976-2023	0.040 Sheet	7075-T6 Alclad
117		Former 74A200971-2017	0.040 Sheet	7075-T6 Alclad
118		Angle 74A200971-2003	0.050 Sheet	7075-T6 Alclad
119		Former 74A201003-2001	0.050 Sheet	7075-T6 Alclad
120		Web 74A200971-2005	0.050 Sheet	7075-T6 Alclad
121		Web 74A200971-2001	0.050 Sheet	7075-T6 Alclad
122		Intercostal 74A200723-2030	0.063 Sheet	7075-T6 Alclad
123		Intercostal 74A200723-2014	0.063 Sheet	7075-T6 Alclad

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 10)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
124		Tee 74A200982-2005	1MA160D06-10523 Extr	7075-T76511 Al Aly
125		Tee 74A200982-2013	1MA160D01-10254 Extr	7075-T6 Al Aly
126		Former 74A200976-2035	0.050 Sheet	7075-T6 Alclad
127		Former 74A201006-2005	0.040 Sheet	7075-T6 Alclad
128		Former 74A201006-2007	0.040 Sheet	7075-T6 Alclad
129		Former 74A201006-2009	0.040 Sheet	7075-T6 Alclad
130		Former 74A201006-2011	0.040 Sheet	7075-T6 Alclad
131		Rib 74A200941-2001	Hand Forging	7050-T73652 Al Aly
132		Former 74A200976-2031	0.040 Sheet	7075-T6 Alclad
133		Rib 74A200925-2001	0.040 Sheet	7075-T6 Alclad
134		Former 74A200976-2029	0.040 Sheet	7075-T6 Alclad
135		Stiffener 74A200996-2025	1MA161D01-10003 Extr	7075-T76 Al Aly
136		Stiffener 74A200996-2029	1MA161D01-10003 Extr	7075-T76 Al Aly
137		Strap 74A200937-2005	0.071 Sheet	7075-T6 Alclad
138		Former 74A200976-2025	0.063 Sheet	7075-T6 Alclad
139		Former 74A200976-2033	0.050 Sheet	7075-T6 Alclad
140		Stiffener 74A200996-2023	1MA161D01-10000 Extr	7075-T76 Al Aly
141		Former 74A201006-2001	0.040 Sheet	7075-T6 Alclad

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 11)

IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
142		Former 74A200976-2021	0.040 Sheet	7075-T6 Alclad
143		Stiffener 74A200996-2021	1MA161D01-10000 Extr	7075-T76 Al Aly
144		Stiffener 74A200996-2027	1MA161D01-10000 Extr	7075-T76 Al Aly
145		Cap 74A200959-2001	1MA160D01-10089 Extr	7075-T76 Al Aly
146		Stiffener 74A200996-2019	1MA161D01-10000 Extr	7075-T76 Al Aly
147		Stiffener 74A200996-2017	1MA161D01-10000 Extr	7075-T76 Al Aly
148		Former 74A200976-2017	0.040 Sheet	7075-T6 Alclad
149		Stiffener 74A200996-2015	1MA161D01-10003 Extr	7075-T76 Al Aly
150		Stiffener 74A200996-2013	1MA161D01-10003 Extr	7075-T76 Al Aly
151		Former 74A200976-2013	0.040 Sheet	7075-T6 Alclad
152		Stiffener 74A200996-2011	1MA161D01-10000 Extr	7075-T76 Al Aly
153		Stiffener 74A200996-2009	1MA161D01-10000 Extr	7075-T76 Al Aly
154		Former 74A200976-2009	0.050 Sheet	7075-T6 Alclad
155		Former 74A200976-2011	0.050 Sheet	7075-T6 Alclad
156		Stiffener 74A200996-2007	1MA161D01-10003 Extr	7075-T76 Al Aly
157		Former 74A200976-2005	0.050 Sheet	7075-T6 Alclad
158		Stiffener 74A200996-2005	1MA161D01-10003 Extr	7075-T76 Al Aly
159		Stiffener 74A200996-2033	1MA161D01-10000 Extr	7075-T76 Al Aly

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 12)








IDX NO.	EFT	NOMENCLATURE AND PART NO.	DESCRIPTION	MATERIAL
160		Former 74A200976-2001	0.040 Sheet	7075-T6 Alclad
161		Former 74A200976-2007	0.050 Sheet	7075-T6 Alclad
162		Cap 74A200998-2001	1MA160D01-10449 Extr	7075-T76 Al Aly
163		Stiffener 74A200996-2031	1MA161D01-10000 Extr	7075-T76 Al Aly
164		Former 74A200976-2003	0.040 Sheet	7075-T6 Alclad
165		Angle 74A200943-2025	0.040 Sheet	7075-T6 Alclad
166		Angle 74A200943-2019	0.040 Sheet	7075-T6 Alclad
167		Support 74A200943-2017	0.050 Sheet	7075-T6 Alclad
168		Angle 74A200943-2031	1MA100D05-10269 Extr	7075-T73511 Al Aly
169		Angle 74A200943-2021	0.040 Sheet	7075-T6 Alclad
170		Angle 74A200943-2027	0.040 Sheet	7075-T6 Alclad
171		Support 74A200943-2023	0.040 Sheet	7075-T6 Alclad
LEGEND				
	162394 THRU 162414.			
	162415 AND UP.			
	162394 THRU 162439.			
	162440 AND UP.			
	162394 THRU 162909.			
	163092 AND UP.			
	F/A-18A, F/A-18B AFTER F/A-18 AFC 102.			

Figure 3. Right Structure Material Index (162394 AND UP) (Sheet 13)

ORGANIZATIONAL MAINTENANCE**STRUCTURE REPAIR****LEADING EDGE EXTENSION REMOVAL AND INSTALLATION**

Reference Material

Line Maintenance Procedures	A1-F18AC-LMM-000
Line Maintenance Access Doors	A1-F18AC-LMM-010
Seat, Canopy, Survival Equipment and Boarding Ladder	A1-F18AC-120-300
Removal and Installation - Boarding Ladder or Drag Brace Assembly	WP122 00
Lighting System	A1-F18AC-440-300
LEX Position Light	WP005 00
Environmental Control Systems	A1-F18AC-440-300-
Radar Liquid Cooling System Ground Cooling Fan	WP117 00
Radar Liquid Cooling Liquid to Air Heat Exchanger	WP118 00
Radar Liquid Cooling Centrifugal Pump Unit	WP119 00
Radar Liquid Cooling Ram Air Airscoop	WP120 00
Radar Liquid Cooling Ram Air Airscoop Actuator	WP121 00
Inertial Navigation, and Backup Attitude and Navigation Systems	A1-F18AC-730-300
Magnetic Azimuth Detector	WP009 00
Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Left Leading Edge Extension	WP039 00
Right Leading Edge Extension	WP039 01
Structure Repair, General Information	A1-F18AC-SRM-200
Adhesive and Sealant, Preparation and Application	WP011 00
Wiring Repair with Parts Data General Wiring Repair Procedures	A1-F18AC-WRM-000
ST5M1345 and 5M392 Splice Combinations and ST5M1653 End Caps	WP013 00
Wiring Diagrams, F/A-18A 161353 AND UP	A1-F18AC-WDM-000
Splice No. WTN015	FIG L613 00
Splice No. WTM016	FIG L119 00
Wiring Diagrams, F/A-18B 161354 AND UP	A1-F18AD-WDM-000
Splice No. WTN015	FIG L613 00
Splice No. WTM016	FIG L120-00

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Subject	Page No.
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Left Aft Leading Edge Extension	4
Right Aft Leading Edge Extension	5
Left and Right Forward Leading Edge Extension	5
Removal	2
Left Aft Leading Edge Extension	2
Right Aft Leading Edge Extension	3
Left and Right Forward Leading Edge Extension	2

Record of Applicable Technical Directives

None

Support Equipment Required

Part Number or
Type Designation

Nomenclature

Fabricate Per
Figure 2

Guide Pin

-

Torque Wrench,
0 to 100
Inch-Pounds

Use guide pin on bolt (48) during removal.
Damage to bolt or structure could occur if
guide pin is not used.

NOTE

Guide pin is fabricated per figure 2.

Materials Required

Specification
or Part Number

Nomenclature

MS24665-153

Cotter Pin

MS24665-302

Cotter Pin

MIL-S-83430

Sealing Compound

CLASS A-1/2

-

Scraper, Formica



Insure all mechanical disconnects are clear for
LEX removal, failure could cause damage to
structure.

1. **REMOVAL.** See figure 1.

2. **LEFT AND RIGHT FORWARD LEADING
EDGE EXTENSION.**

NOTE

Make sure that electrical and hydraulic power is
removed from aircraft (A1-F18AC-LMM-000).

a. For left LEX remove fairings (1, 2, 3, 13, 14,
16, 17, and 18).

b. For right LEX remove fairings (27, 28, 29, 30,
31, 44, 45, and 46).

c. Cut and remove sealing compound from forward
end with nonmetallic scraper.

d. Remove bolt (49) and attaching hardware from
jumper and forward fuselage, detail A.

e. Remove bolt (53) and attaching hardware from
jumper and aft LEX, detail C.

f. Support LEX, remove bolt (52) and attaching
hardware, detail C.

g. Remove cotter pin, nut, and washer from bolt
(48), and install guide pin, detail A.

h. Remove forward attach bolt (48) with guide pin
installed on bolt, detail A.

i. Move forward end of LEX outboard enough to
clear forward attach lug, move LEX forward until
LEX support (54) clears aft LEX, detail C.

3. **LEFT AFT LEADING EDGE EXTENSION.**

NOTE

Make sure that electrical and hydraulic power is
removed from aircraft (A1-F18AC-LMM-000).

a. Remove LEX fence (A1-F18AC-SRM-220,
WP039 00).

b. Remove fairings (4, 5, 7, 8, 9, 10, 11, 12, 15,
19, 20, 21, 22, and 23), structure assembly (6), and
doors 22, 163, 112, and 32L (A1-F18AC-LMM-010).

c. Cut wires for light and boarding ladder switch
at splice no. WTM016 (72) (A1-F18AC-WRM-000,
WP013 00, for F/A-18A A1-F18AC-WDM-000, FIG
L119 00 and for F/A-18B A1-F18AD-WDM-000, FIG
L120 00), remove connectors (60 and 69), grounds
(62, 63, 70, and 73), clamps (61, 64, 65, 66, 67, 68,
and 71) and pull wires aft into center fuselage.

- d. Disconnect liquid cooling lines (76 and 77).
- e. Disconnect liquid cooling air duct (75) remove 2 bolts (74) and slide sleeve (78) aft.
- f. Remove position light and transformer (A1-F18AC-440-300, WP005 00).
- g. Remove boarding ladder (A1-F18AC-120-300, WP122 00).
- h. Remove radar liquid cooling system ground cooling fan (A1-F18AC-410-300, WP117 00).
- i. Remove radar liquid cooling centrifugal pump unit (A1-F18AC-410-300, WP119 00).
- j. Remove radar liquid cooling liquid to air heat exchanger (A1-F18AC-410-300, WP118 00).
- k. Remove radar liquid cooling ram air airscoop actuator (A1-F18AC-410-300, WP121 00).
- l. Remove radar liquid cooling ram air airscoop (A1-F18AC-410-300, WP120 00).
- m. Cut and remove sealing compound around center support (55) and 4 bolts (56) with a nonmetallic scraper. Remove 4 bolts (56) and attaching hardware and slide support (55) outboard, detail D.
- n. Remove bolt (58) and attaching hardware from center fuselage and jumper, detail E.
- o. Remove bolt (57) and attaching hardware, detail E.
- p. Remove 2 bolts (50) and attaching hardware from 2 bushings (51) upper and lower forward attach points. Support LEX and remove 2 bushings (51) from upper and lower forward attach points, detail B.



Insure all mechanical, electrical, and liquid cooling system disconnects are clear for LEX removal, failure could cause damage to structure, electrical, or liquid cooling system.

- q. Cut and remove sealing compound from aft end with nonmetallic scraper.
- r. Move forward end of aft LEX outboard until LEX clears attach lugs on forward fuselage. Slide LEX forward on ramp support pin (47) until aft sup-

port (59) is clear of center fuselage. Lift aft end to clear support pin (47) and remove from aircraft.

4. RIGHT AFT LEADING EDGE EXTENSION.

NOTE

Make sure that electrical and hydraulic power is removed from aircraft.

- a. Remove LEX fence (A1-F18AC-SRM-220, WP039 01).
- b. Remove fairings (25, 26, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42 and 43), structure assembly (24) and doors 23, 32R, and 94 (A1-F18AC-LMM-010).
- c. Cut wires for light and magnetic azimuth detector at splice no. WPN015 (79) (A1-F18AC-WRM-000, WP013 00, for F/A-18A A1-F18AC-WDM-000, FIG L613 00 and for F/A-18B A1-F18AD-WDM-000, FIG L613 00), remove clamps (80, 81, 82 and 83). Pull wires forward into LEX.
- d. Remove magnetic azimuth detector (A1-F18AC-730-300, WP009 00).
- e. Cut and remove sealing compound around center support (55) and 4 bolts (56) with a nonmagnetic scraper. Remove 4 bolts (56) and attaching hardware and slide support (55) outboard, detail D.
- f. Remove bolt (58) and attaching hardware from center fuselage and jumper, detail E.
- g. Remove bolt (57) and attaching hardware, detail E.
- h. Remove 2 bolts (50) and attaching hardware from 2 bushings (51) upper and lower forward attach points. Support LEX and remove 2 bushings (51) from upper and lower forward attach points, detail B.



Insure all mechanical, electrical, and liquid cooling system disconnects are clear for LEX removal, failure could cause damage to structure, electrical, or liquid cooling system.

- i. Cut and remove sealing compound from aft end with nonmetallic scraper.

j. Move forward end of aft LEX outboard until LEX clears attach lugs on forward fuselage. Slide LEX forward on ramp support pin (47) until aft support (59) is clear of center fuselage. Lift aft end to clear support pin (47) and remove from aircraft.

5. **INSTALLATION.** See figure 1.

6. **LEFT AFT LEADING EDGE EXTENSION.**



Make sure all mechanical, electrical, and liquid cooling system disconnects are clear for LEX installation. Failure to do so could cause damage to structure, electrical, or liquid cooling system.

To prevent nut retainers from being dislodged from fuselage and falling into fuel cell cavity, make sure threads are clean.

a. Clean bolts (56) and nut threads in fuselage for attaching center support (55).

b. Lift aft end of LEX and align and insert ramp support pin (47) into forward end of support pin slot, install upper link bolt (57) and attaching hardware, torque to 50 to 70 inch-pounds, detail E.

c. Align aft support (59) with center fuselage and install by sliding LEX aft, detail F.

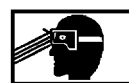
d. Move forward end of LEX inboard and align with attach lugs on forward fuselage.

e. Install 2 bushings (51) into upper and lower attach lugs, install 2 bolts (50) and attaching hardware into bushings, detail B.

f. Install bolt (58) and attaching hardware into jumper and aft end of LEX, detail E.

g. Slide center support (55) inboard until flush with forward fuselage, making sure that cut out end of support is aft, detail D.

h. Install 4 bolts (56) into support (55) and forward fuselage, torque to 50 to 70 inch-pounds, detail D.



Sealing Compound, MIL-S-83430, Class A-1/2

6

i. Fillet seal with sealing compound around support (55) and bolt heads (56), detail D (A1-F18AC-SRM-200, WP011 00).

j. Install position light and transformer (A1-F18AC-440-300, WP005 00).

k. Install boarding ladder (A1-F18AC-120-300, WP122 00).

l. Install radar liquid cooling system ground cooling fan (A1-F18AC-410-300, WP117 00).

m. Install radar liquid cooling centrifugal pump unit (A1-F18AC-410-300, WP119 00).

n. Install radar liquid cooling liquid to air heat exchanger (A1-F18AC-410-300, WP118 00).

o. Install radar liquid cooling ram air airscoop actuator (A1-F18AC-410-300, WP121 00).

p. Install radar liquid cooling ram air airscoop (A1-F18AC-410-300, WP120 00).

q. Position air duct (75), slide sleeve (78) in place and install 2 bolts (74).



To prevent possible reversal of radar liquid cooling flow, make sure coolant pressure (77) and return (76) hoses are connected to the correct bulkhead fittings, by way of flow arrows on LEX rib.

r. Install liquid cooling lines (76 and 77).

s. Reroute wires forward into LEX, install clamps (61, 64, 65, 66, 67, 68 and 71), grounds (62, 63, 70, and 73), connectors (60 and 69) and splice no. WTM016 (72) (A1-F18AC-WRM-000, WP013 00, for F/A-18A A1-F18AC-WDM-000, FIG L119 00 and for F/A-18B A1-F18AD-WDM-000, FIG L120 00).

t. Install fairings (4, 5, 7, 8, 9, 10, 11, 12, 15, 19, 20, 21, 22, and 23), structure assembly (6) and doors (22, 163, 112, and 32L) (A1-F18AC-LMM-010).

u. Fillet seal with sealing compound around aft end of LEX, see figure (A1-F18AC-SRM-200, WP011 00).

v. Install LEX fence (WP039 00).

7. RIGHT AFT LEADING EDGE EXTENSION.



Make sure all mechanical, electrical, and liquid cooling system disconnects are clear for LEX installation. Failure to do so could cause damage to structure, electrical, or liquid cooling system.

To prevent nut retainers from being dislodged from fuselage and falling into fuel cell cavity, make sure threads are clean.

a. Clean bolts (56) and nut threads in fuselage for attaching center support (55).

b. Lift aft end of LEX and align and insert ramp support pin (47) into forward end of support pin slot, install upper link bolt (57) and attaching hardware, torque to 50 to 70 inch pounds, detail E.

c. Align aft support (59) with center fuselage and install by sliding LEX aft, detail F.

d. Move forward end of LEX inboard and align with lugs on forward fuselage.

e. Install 2 bushings (51) into upper and lower attach lugs, install 2 bolts (50) and attaching hardware into bushings, detail B.

f. Install bolt (58) and attaching hardware into jumper and aft end of LEX, detail E.

g. Slide center support (55) inboard until flush with forward fuselage, making sure that cutout end of support is aft, detail D.

h. Install 4 bolts (56) into support (55) and forward fuselage, torque to 50 to 70 inch-pounds, detail D.



Sealing Compound, MIL-S-83430, Class A-1/2

6

i. Fillet seal with sealing compound around support (55) and bolt heads (56), detail D (A1-F18AC-SRM-200, WP011 00).

j. Install LEX position light and transformer (A1-F18AC-440-300, WP005 00).

k. Position air duct (75), slide sleeve (78) in place and install 2 bolts (74).

l. Install liquid cooling lines (76 and 77).

m. Reroute light and magnetic azimuth detector wires aft into center fuselage, install clamps (80, 81, and 83) and splice no. WTN015 (79) (A1-F18AC-WRM-000, WP013 00, for F/A-18A A1-F18AC-WDM-000, FIG L613 00 and for F/A-18B A1-F18AD-WDM-000, FIG L613 00).

n. Install fairings (25, 26, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42 and 43), structure assembly (24), and doors (23, 32R, and 94) (A1-F18AC-LMM-010).

o. Fillet seal with sealing compound around aft end of LEX (A1-F18AC-SRM-200, WP011 00).

p. Install LEX fence (WP039 01).

8. LEFT AND RIGHT FORWARD LEADING EDGE EXTENSION.



Inspect LEX to forward fuselage attach areas for obstructions, failure could cause damage to structure.

NOTE

Make sure that electrical and hydraulic power is removed from aircraft (A1-F18AC-LMM-000).

a. Align support (54) with aft LEX and install by moving forward LEX aft, detail C.

b. Align forward attach points with fuselage attach points, install guide pin into attach point and install bolt (48) into guide pin. Install bolt (48) with guide installed into attach points. Remove guide pin from bolt (48) and install attaching hardware, detail A.

c. Align aft attach points, install bolt (52) and attaching hardware, detail C.

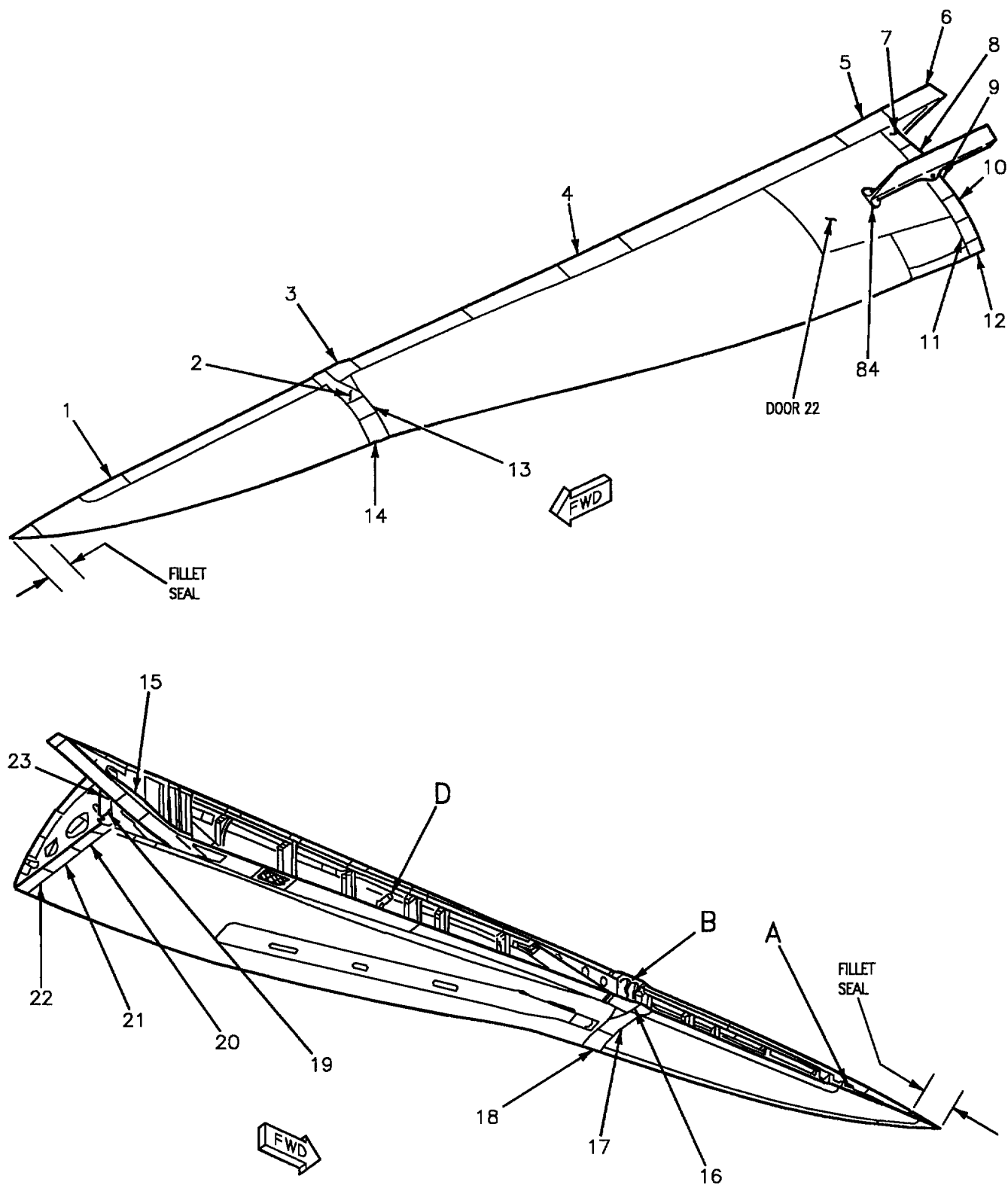
d. Install bolt (53) and attaching hardware to jumper and aft LEX, detail C.

e. Install bolt (49) and attaching hardware to jumper and forward fuselage, detail A.

f. Fillet seal with sealing compound around forward end of LEX, see figure (A1-F18AC-SRM-200, WP011 00).

g. For left LEX install fairings (1, 2, 3, 13, 14, 16, 17, and 18).

h. For right LEX install fairings (27, 28, 29, 30, 31, 44, 45, and 46).



18AC-SRM-222-(138-1)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 1)

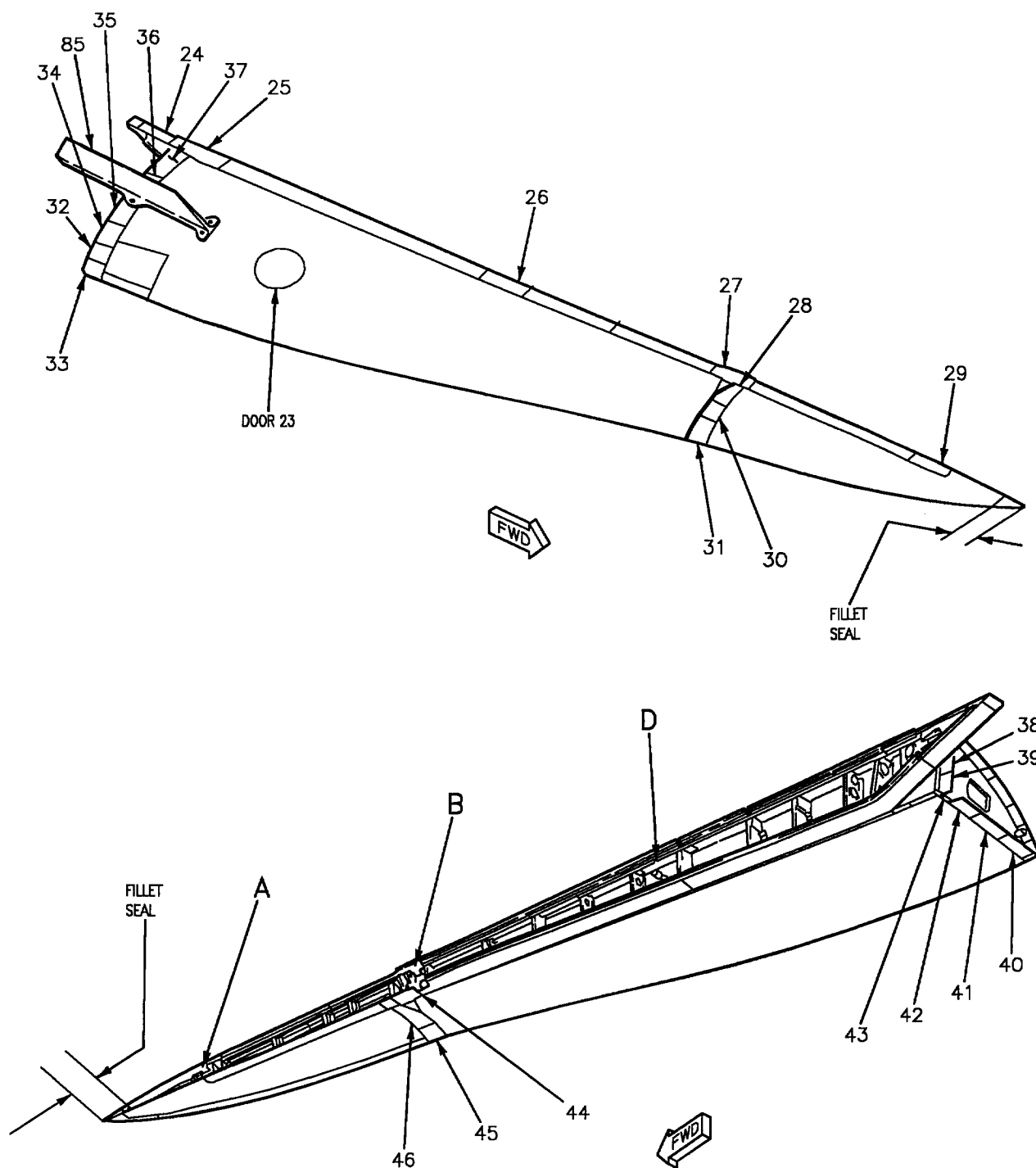


Figure 1. Leading Edge Extension Removal and Installation (Sheet 2)

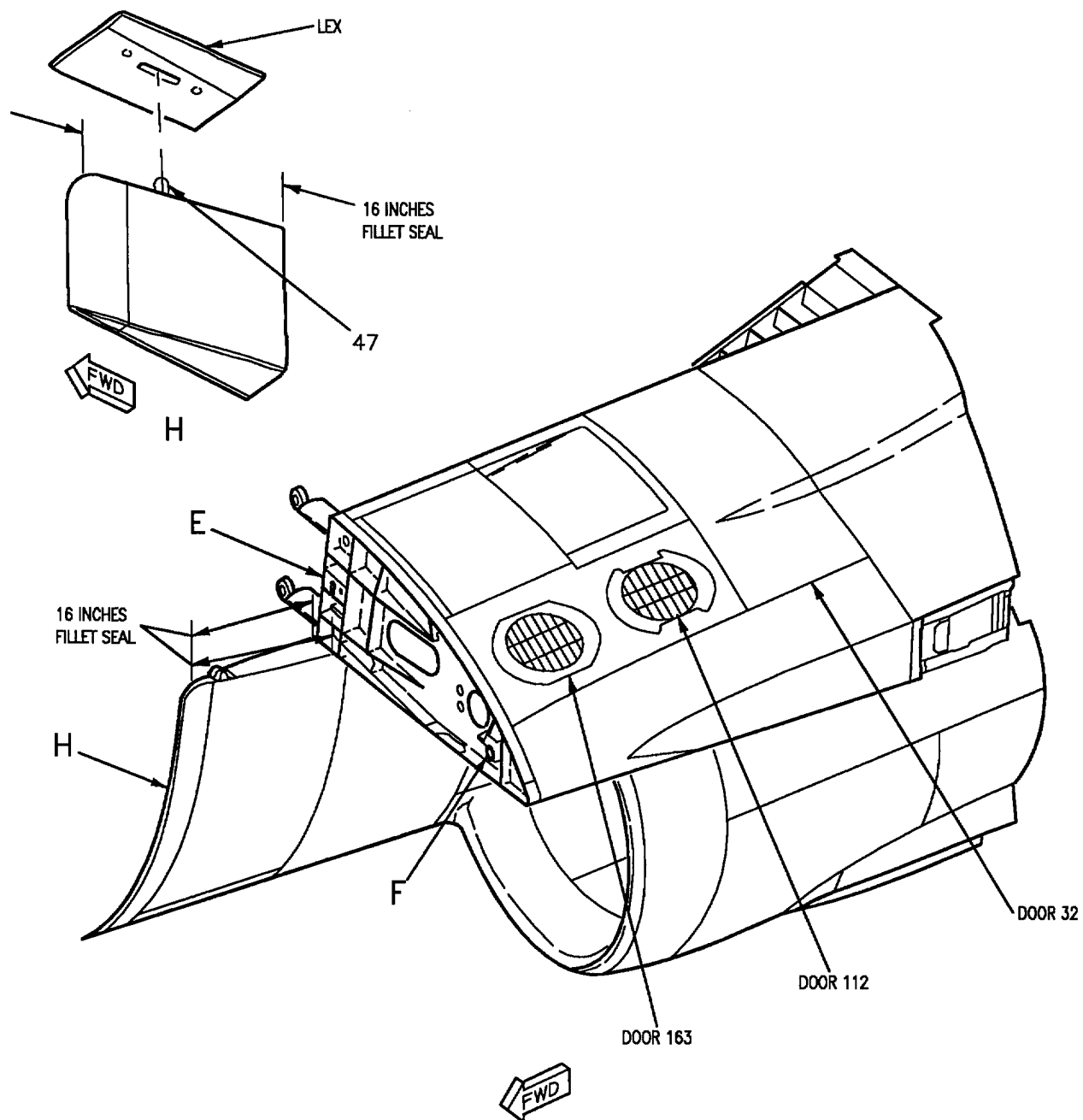


Figure 1. Leading Edge Extension Removal and Installation (Sheet 3)

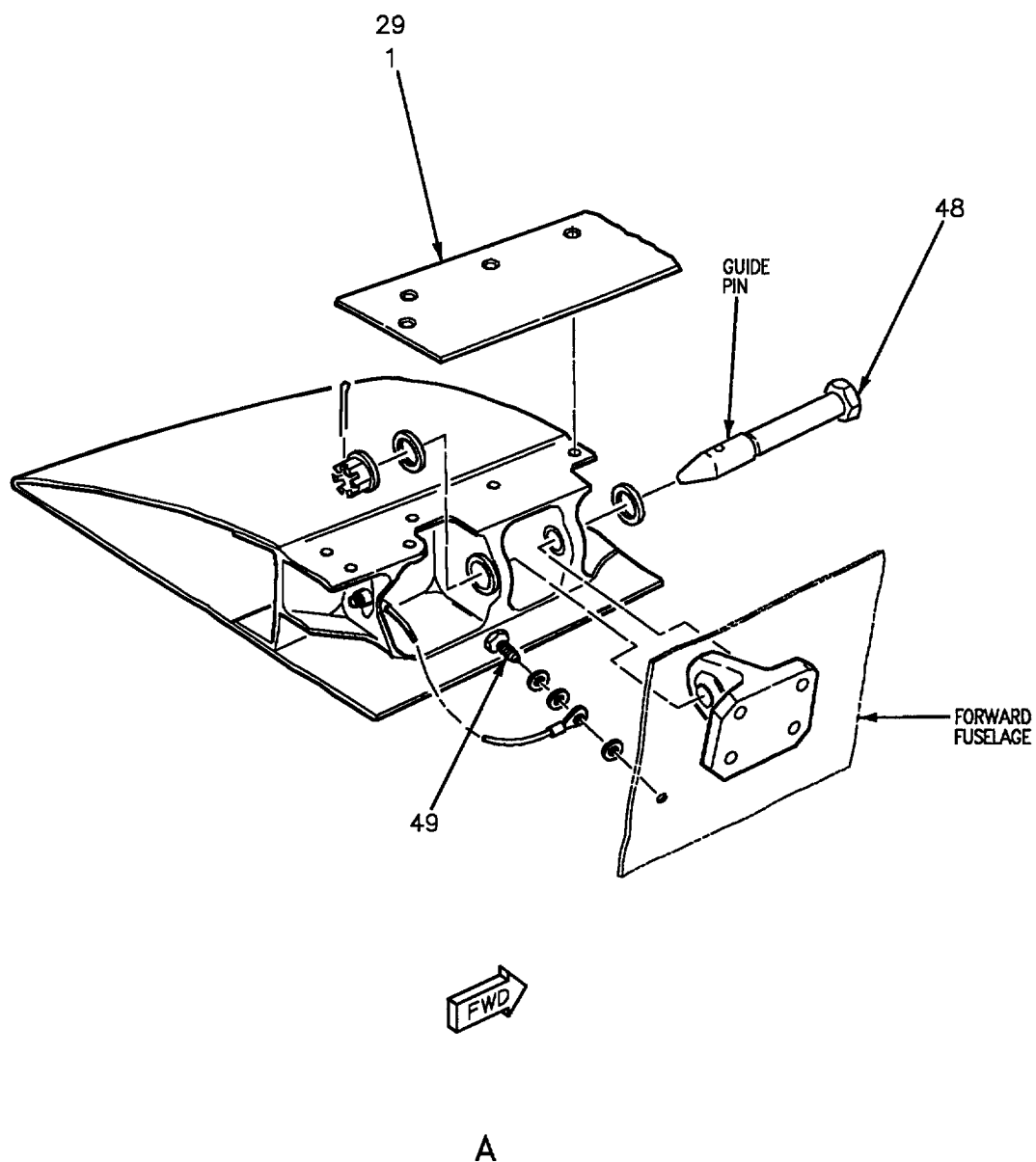
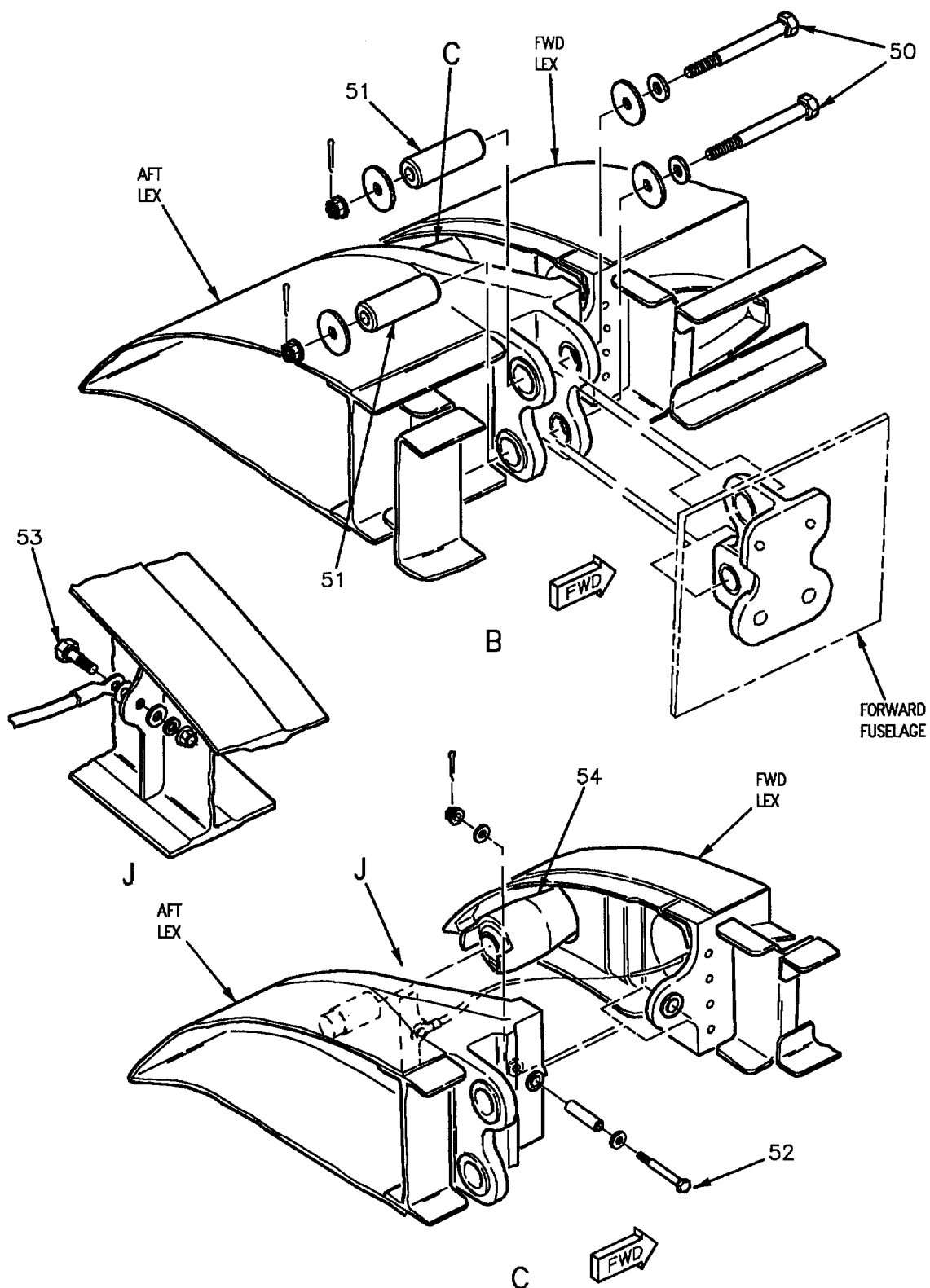
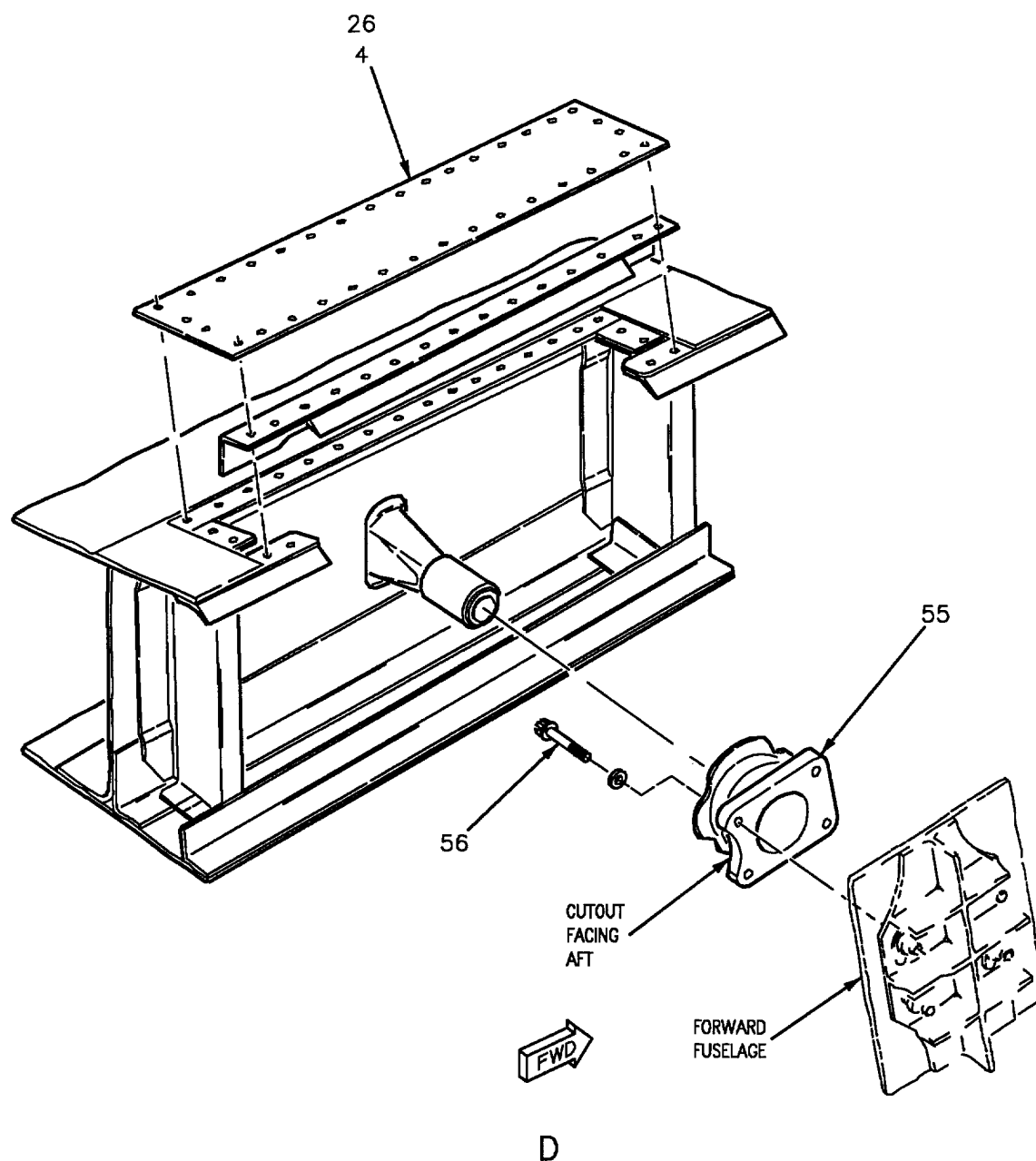


Figure 1. Leading Edge Extension Removal and Installation (Sheet 4)



18AC-SRM-222-(138-5)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 5)



18AC-SRM-222-(138-6)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 6)

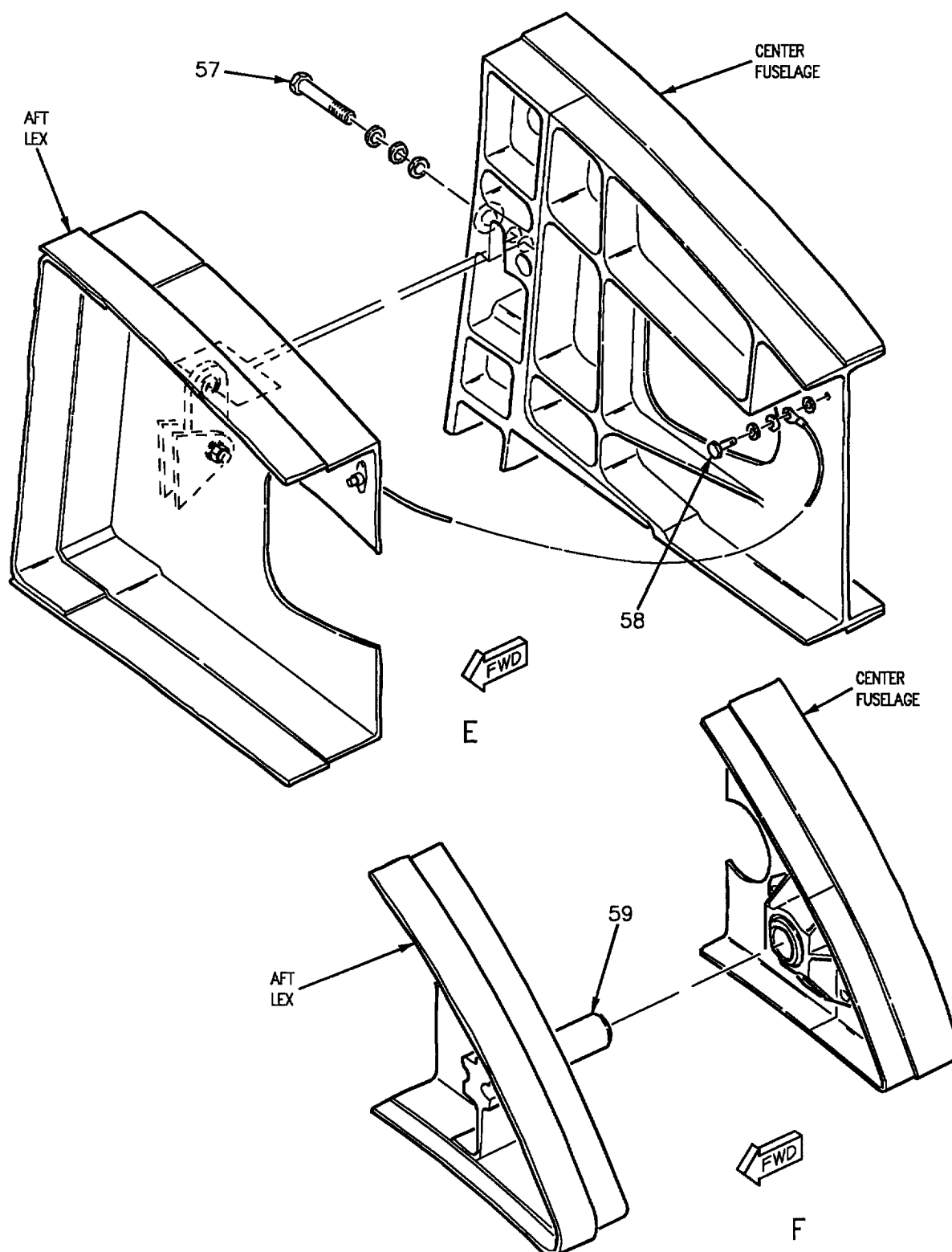
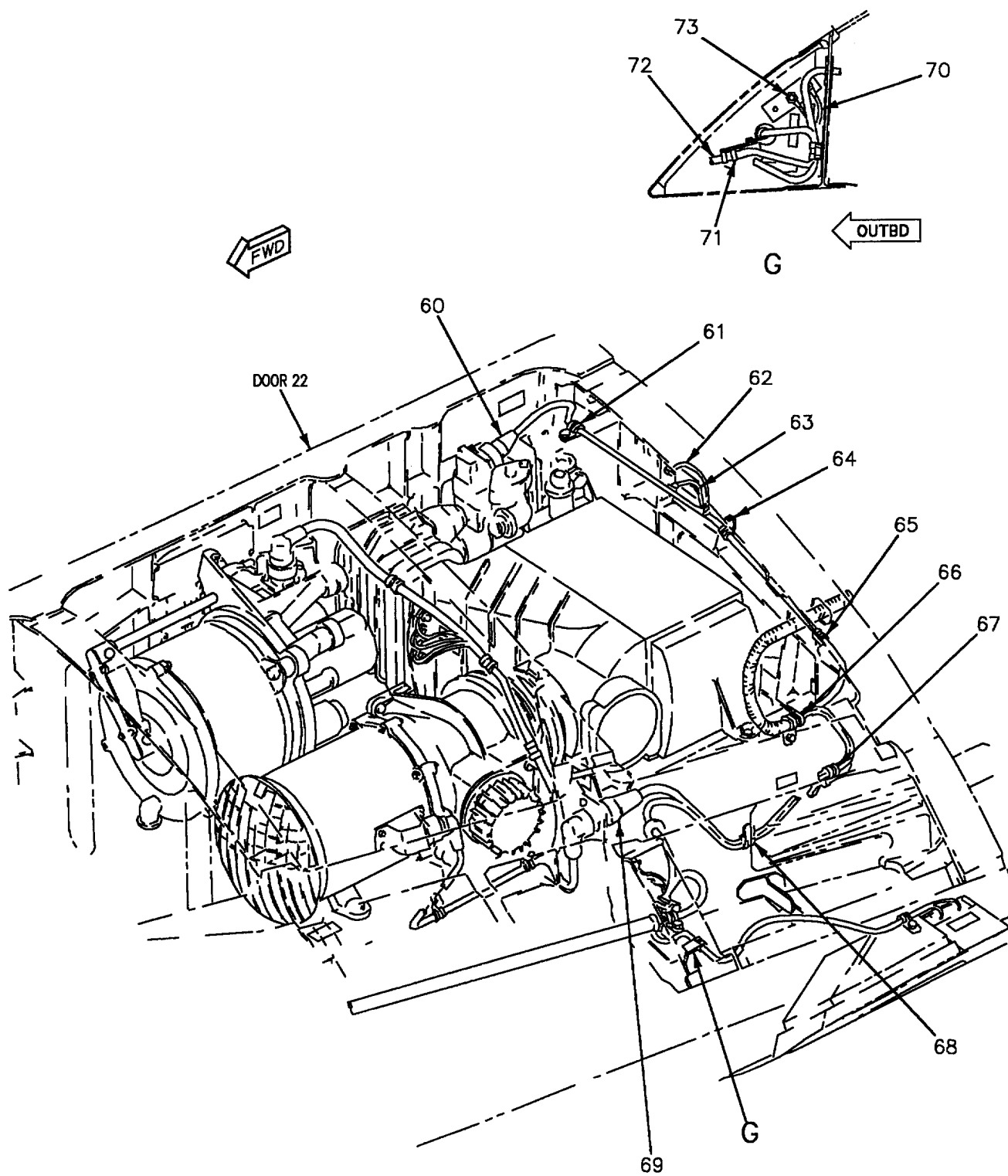
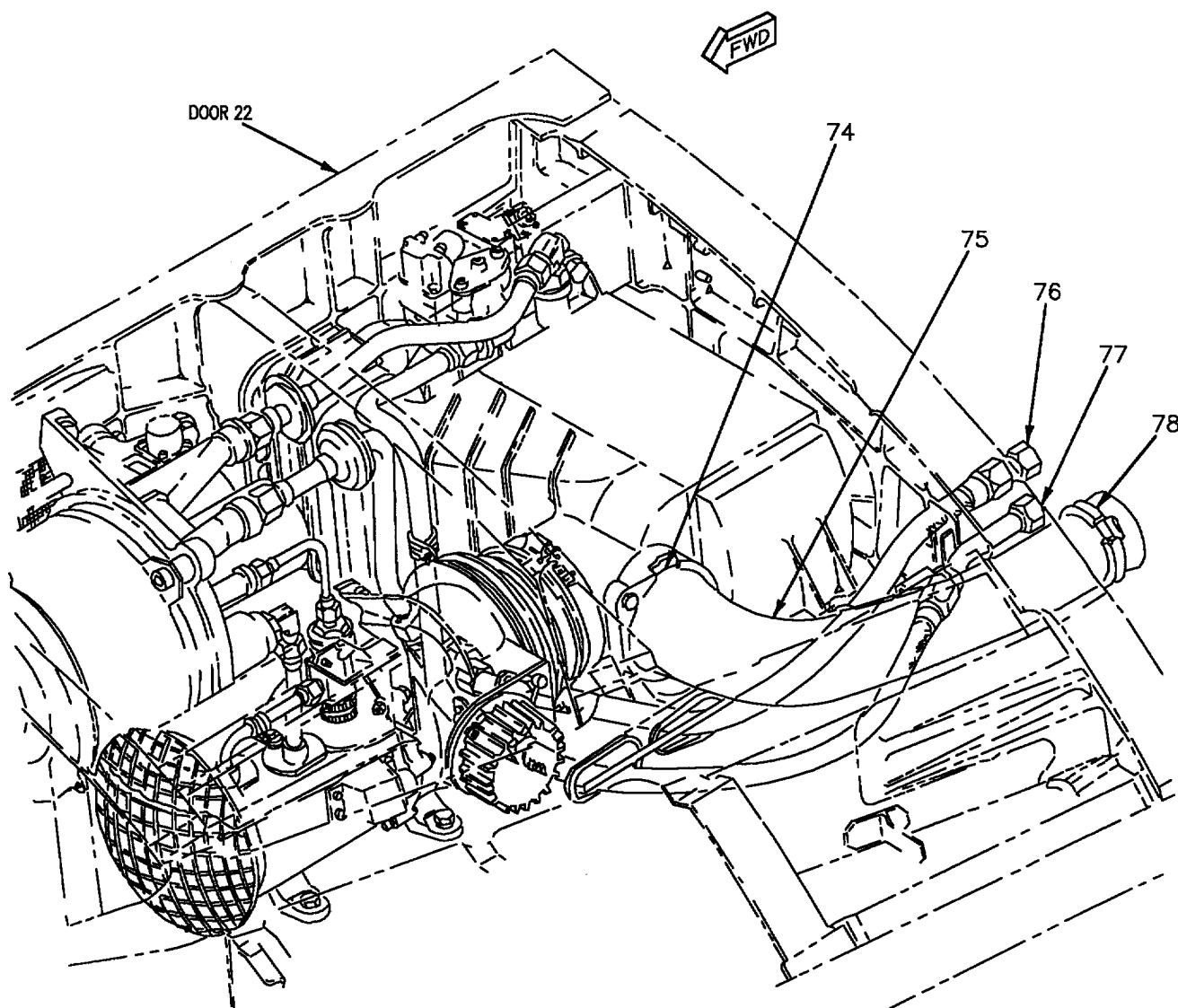


Figure 1. Leading Edge Extension Removal and Installation (Sheet 7)



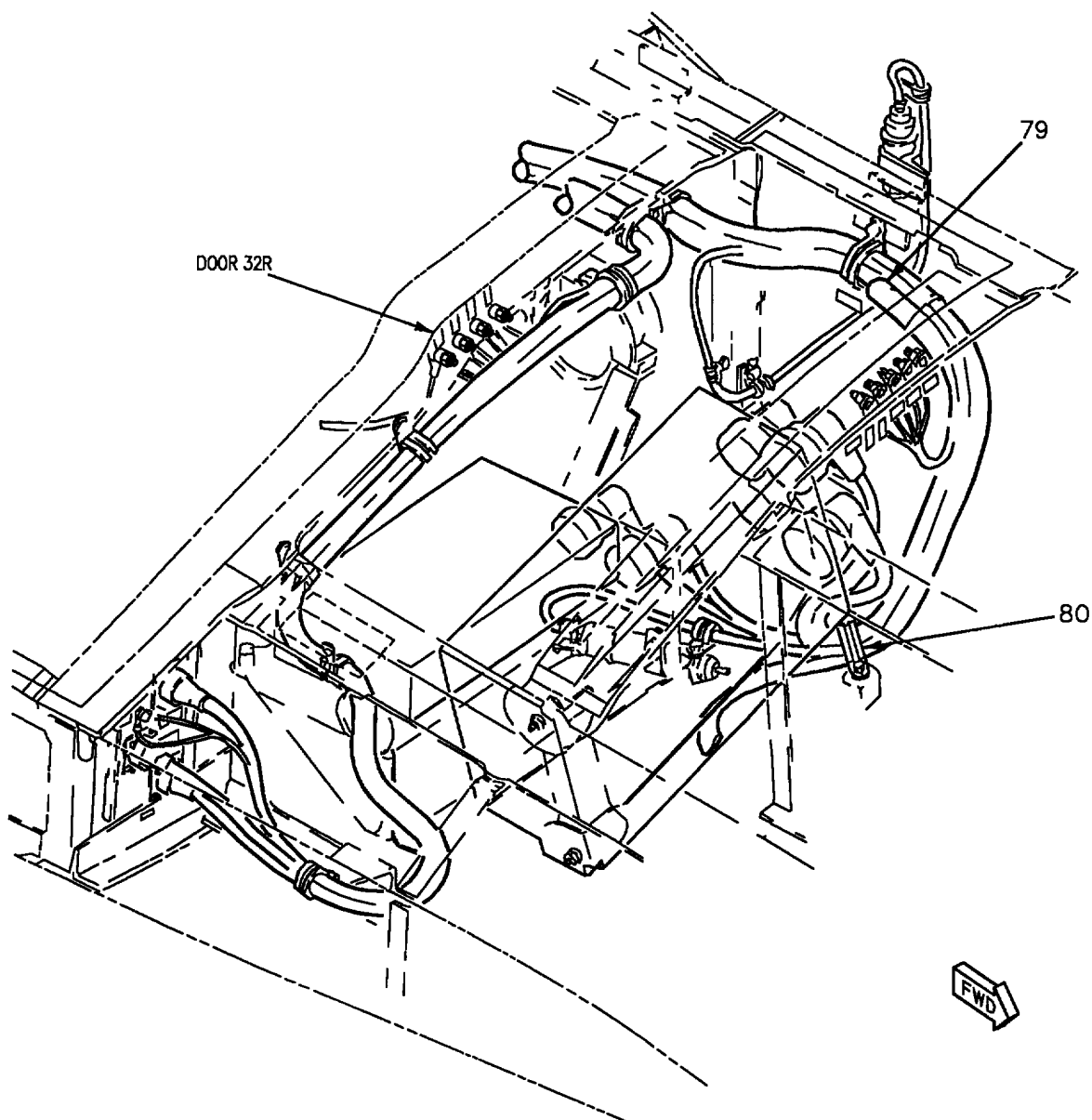
18AC-SRM-222-(138-8)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 8)



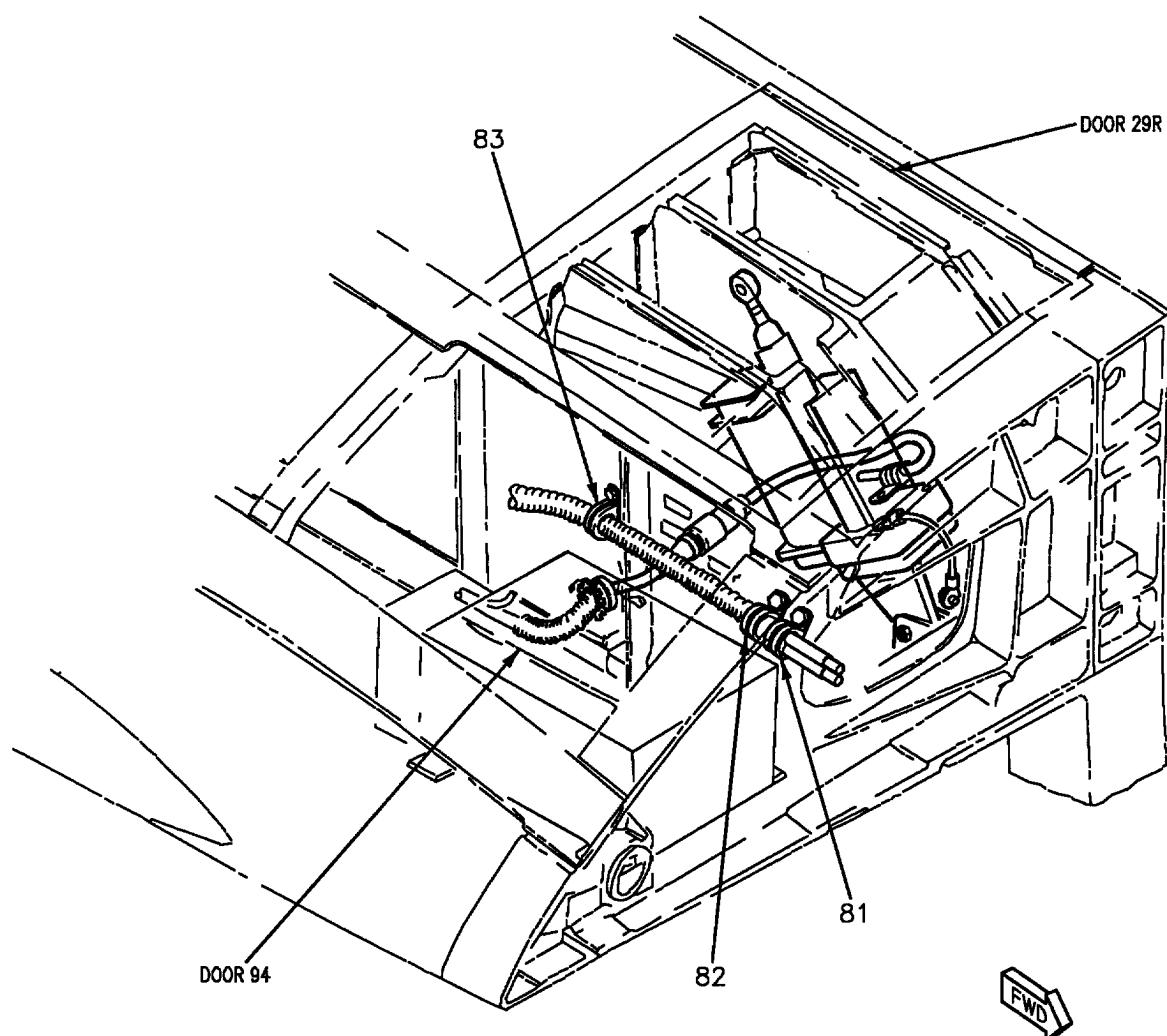
18AC-SRM-222-(138-9)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 9)



18AC-SRM-222-(138-10)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 10)



18AC-SRM-222-(138-11)01-SCAN

Figure 1. Leading Edge Extension Removal and Installation (Sheet 11)

INDEX NO	NOMENCLATURE
1	FAIRING
2	FAIRING
3	FAIRING
4	FAIRING
5	FAIRING
6	STRUCTURE ASSEMBLY
7	FAIRING
8	FAIRING
9	FAIRING
10	FAIRING
11	FAIRING
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16	FAIRING
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24	STRUCTURE ASSEMBLY
25	FAIRING
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40	FAIRING
41	FAIRING
42	FAIRING

INDEX NO	NOMENCLATURE
43	FAIRING
44	FAIRING
45	FAIRING
46	FAIRING
47	RAMP SUPPORT PIN
48	BOLT
49	BOLT
50	BOLT
51	BUSHING
52	BOLT
53	BOLT
54	LEX SUPPORT
55	CENTER SUPPORT
56	BOLT
57	BOLT
58	BOLT
59	AFT SUPPORT
60	CONNECTOR
61	CLAMP
62	GROUND
63	GROUND
64	CLAMP
65	CLAMP
66	CLAMP
67	CLAMP
68	CLAMP
69	CONNECTOR
70	GROUND
71	CLAMP
72	SPLICE
73	GROUND
74	BOLT
75	AIR DUCT
76	LIQUID COOLING LINES
77	LIQUID COOLING LINES
78	SLEEVE
79	SPLICE
80	CLAMP
81	CLAMP
82	CLAMP
83	CLAMP
84	LEFT FENCE
85	RIGHT FENCE

Figure 1. Leading Edge Extension Removal and Installation (Sheet 12)

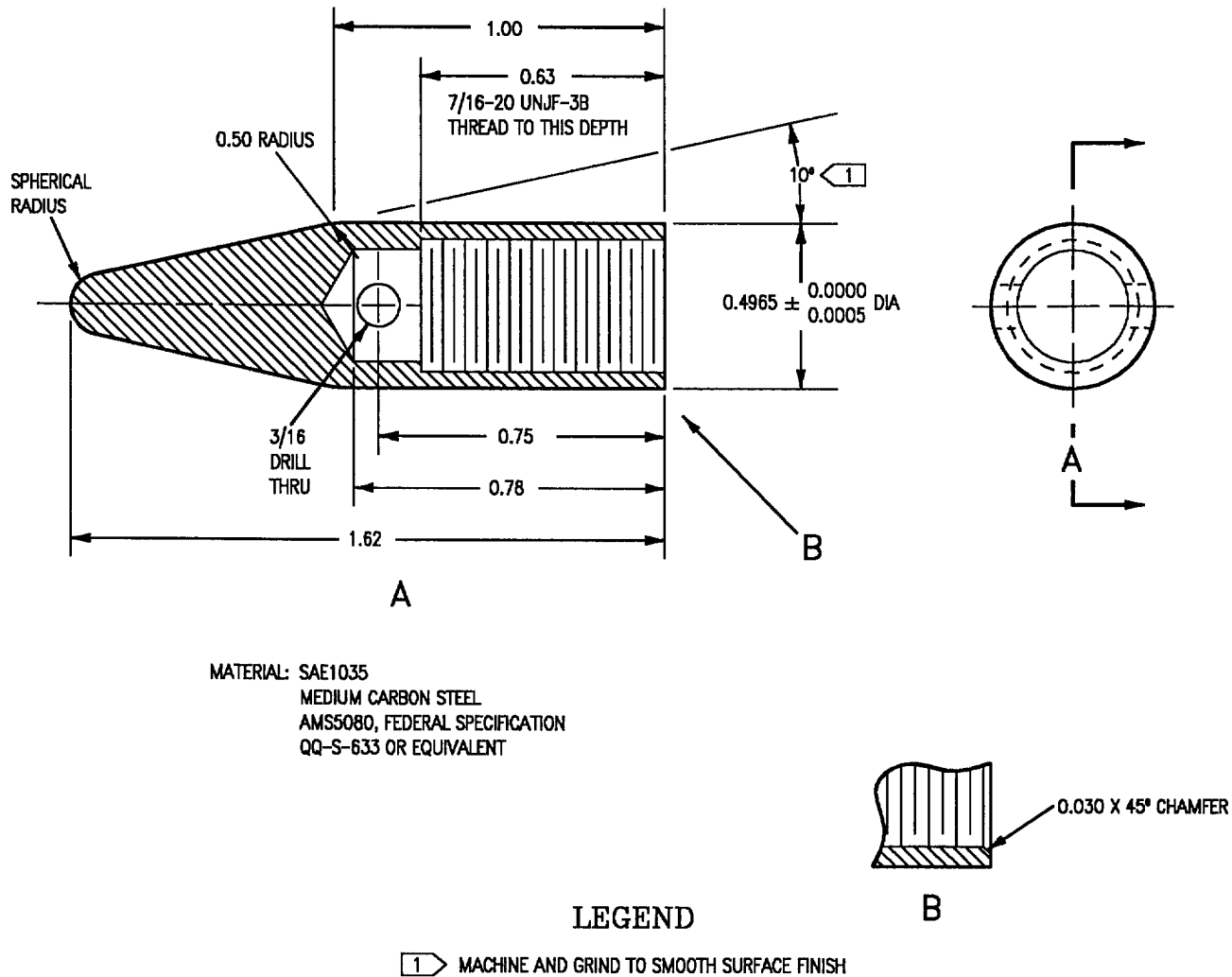


Figure 2. Guide Pin

DEPOT MAINTENANCE

MAGNETIC AZIMUTH DETECTOR DT-604/A MOUNT BORESIGHTING

Reference Material

Inertial Navigation, and Backup Attitude and Navigation Systems	A1-F18AC-730-300
Magnetic Azimuth Detector DT-604/A (75A-N001)	WP009 00
Line Maintenance Access Doors	A1-F18AC-LMM-010
Plane Captain Manual	A1-F18AC-PCM-000
Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Boresight Reference Frame Assembly	WP044 00
Triaxial Alignment Set Check Fixture	WP045 00

Alphabetical Index

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Aircraft Boresight Requirements	2
Aircraft Preparation	2
Alignment Verification/Realignment Procedure	2
Initial Alignment Procedure	5
Introduction	1
General Instructions	1

Record of Applicable Technical Directives

None

1. INTRODUCTION.

2. This work package contains depot level maintenance instructions for boresighting the magnetic azimuth detector mount located in the right LEX. The boresighting instructions are divided into two separate procedures; an alignment verification/realignment procedure and an initial alignment procedure. The two procedures are described below:

a. Alignment verification/realignment procedure, refer to paragraph 7. This procedure is used to determine if the magnetic azimuth detector mount yaw reference plane is aligned within tolerance and provides a step by step procedure for realigning the mount when required.

b. Initial alignment procedure, refer to paragraph 8. This procedure is used to initially align the magnetic

azimuth detector mount when it has been repaired or replaced.

3. **GENERAL INSTRUCTIONS.** To make sure the magnetic azimuth detector mount is accurately boresighted, the instructions below shall be used.

a. Personnel must be familiar with the use and operation of the triaxial alignment set.

b. Personnel must know the principles of boresighting.

c. Boresighting should be done separately from other maintenance operations.

d. Mounting surfaces on aircraft and boresight adapters shall be clean and free of burrs. Attach bolts shall be clean and free of burrs and damaged threads.

e. Visually inspect for loose or missing sealant around nuts on equipment.

f. Visually inspect alignment set for corrosion, distortion, damage, and missing hardware.

4. AIRCRAFT BORESIGHT REQUIREMENTS.

5. The flexibility of the fuselage structure has no adverse affect on the magnetic azimuth detector mount boresight accuracy. For that reason, there are no special boresight requirements.

6. AIRCRAFT PREPARATION.

a. Make sure ground safety devices required during all ground operations are installed (A1-F18AC-PCM-000).

7. ALIGNMENT VERIFICATION/ REALIGNMENT PROCEDURE. See figure 1.

Support Equipment Required

NOTE

Alternate item type designations or part numbers are listed in parentheses.

Part Number or Type Designation	Nomenclature
74D110026-1003 (74D110026-1001)	Magnetic Azimuth Detector Mount Alignment Adapter
-	Torque Wrench, 0 to 50 Inch-Pounds

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
NAS1671-08L2	Jo-Bolt (3)
P-D-680 TYPE II	Dry Cleaning Solvent

a. Verify alignment of triaxial alignment set (WP045 00).

b. Set up and install boresight reference frame assembly (WP044 00).

c. Install 74D111167 triaxial detector unit (2) on boresight reference frame subassembly (BRFS) (1) at magnetic azimuth detector (MAD) target point with three attach bolts (3) handtight.

d. Remove door 23 (A1-F18AC-LMM-010).

e. Remove magnetic azimuth detector (A1-F18AC-730-300, WP009 00).

f. Install applicable 74D111074 magnetic azimuth detector mount alignment adapter subassembly (MAD alignment adapter) (4) on support (9) and bracket (11) (MAD mount) per substeps below:



Dry Cleaning Solvent, P-D-680, Type II

7

(1) Clean mating surfaces of MAD alignment adapter (4), support (9), and bracket (11) using cheesecloth moistened with solvent. Make sure three attach bolts (7 and 8) are clean and free of burrs and damaged threads.

(2) Position MAD alignment adapter (4) on support (9) and bracket (11) and install three attach bolts (7 and 8).

(3) Torque three attach bolts (7 and 8) 20 to 25 inch-pounds.

g. Install 74D111159 beam splitter assembly (22) on MAD alignment adapter (4) with three attach bolts (23) handtight.

h. Install 74D111180 laser (5) on cone bolts in MAD alignment adapter (4) per substeps below:

(1) Open two laser clamps (6).

(2) Slide laser (5) forward into MAD alignment adapter (4) until line on laser plate is aligned with aft edge of MAD alignment adapter.

(3) Rotate laser (5) until line on laser plate is aligned with up mark on MAD alignment adapter.

(4) Close two laser clamps (6).

(5) Hook chain (15) to MAD alignment adapter (4).

i. Position 74D111141 control/display unit (16) midway between BRFS (1) and MAD alignment adapter (4).

j. Connect laser cable to control/display unit (16).

k. Connect 74D111145-1001 cable (21) to triaxial detector unit (2) and to control/display unit (16).

l. Hook chain (14) to BRFS (1).

m. Connect 74D111145-1003 cable (19), with ground wire, to control/display unit (16) and to 74D111145-1005 cable (20).

n. Plug in cable (20) to electrical power source.

WARNING

Laser radiation, do not look into laser beam or eye injury could occur.

NOTE

The main laser light will illuminate when control/display unit is turned on. When laser return is not sensed by the control/display unit after approximately 7 seconds, it will inhibit the laser, causing the main laser light to go off.

o. Push control/display unit (16) switch (18) to on position.

NOTE

The mount yaw indication is displayed on control/display unit. The YAW display is graduated in 0.01 milliradian increments. Ignore PITCH and ROLL displays on control/display unit.

p. Read and record plus-minus YAW display (17) indication on control/display unit (16).

q. If YAW display (17) indication, recorded in step p, is 0.00 ~~3.50~~ milliradians, the MAD mount is aligned within alignment verification tolerance. If within tolerance, go to step s. If not within tolerance, do step r.

r. When the MAD mount is out of alignment tolerance, realign the mount per substeps below:

(1) Push control/display unit (16) switch (18) to off position.

(2) Remove laser (5) from MAD alignment adapter (4) per substeps below:

(a) Unhook chain (15) from MAD alignment adapter (4).

(b) Open two laser clamps (6).

(c) Slide laser (5) aft out of MAD alignment adapter (4).

(3) Remove MAD alignment adapter (4), with beam splitter assembly (22), by removing three attach bolts (7 and 8).

(4) Remove three Jo-Bolts (12), attaching bracket (11) to support (10).

(5) Loosen two bolts (13) securing bracket (11) to support (10). Do not remove bolts.

(6) Install MAD alignment adapter (4), with beam splitter assembly (22), on MAD mount per substeps below:

(a) Position MAD alignment adapter (4) on support (9) and bracket (11) and install three attach bolts (7 and 8).

(b) Torque two attach bolts (7) 20 to 25 inch-pounds.

(c) Tighten attach bolt (8) handtight, do not torque. Adapter must be free to rotate on this pivot point.

(7) Install laser (5) on cone bolts in MAD alignment adapter (4) per substeps below:

(a) Slide laser (5) forward into MAD alignment adapter (4) until line on laser plate is aligned with aft edge of MAD alignment adapter.

(b) Rotate laser (5) until line on laser plate is aligned with up mark on MAD alignment adapter.

(c) Close two laser clamps (6).

(d) Hook chain (15) to MAD alignment adapter (4).

WARNING

Laser radiation, do not look into laser beam or eye injury could occur.

(8) Push control/display unit (16) switch (18) to on position.

(9) While monitoring YAW display (17), manually shift inboard end of MAD alignment adapter (4), forward or aft, until YAW display (17) indication is 0.0 ± 0.0 milliradian.

(10) Torque three bolts (8 and 13) 20 to 25 inch-pounds.

(11) Read and record YAW display (17) indication on control/display unit (16).

(12) If YAW display (17) indication is 0.0 ± 0.0 milliradian, the mount is aligned within tolerance. If within tolerance, go to substep r(13). If not within tolerance, loosen three bolts (8 and 13) and repeat substeps r(9) through r(12).

(13) Push control/display unit (16) switch (18) to off position.

(14) Remove laser (5) from MAD alignment adapter (4) per substeps below:

(a) Unhook chain (15) from MAD alignment adapter (4).

(b) Open two laser clamps (6).

(c) Slide laser (5) aft out of MAD alignment adapter (4).

(15) Remove MAD alignment adapter (4), with beam splitter assembly (22), by removing three attach bolts (7 and 8).

(16) Make sure the three Jo-Bolt holes in bracket (11) and support (10) do not exceed $0.165 +0.003 -0.000$ inch diameter. If Jo-Bolt holes are within tolerance, do substep r(17). If not within tolerance, refer to engineering for a disposition.

(17) Install three NAS1671-08L2 Jo-Bolts (12), attaching bracket (11) to support (10).

(18) Install MAD alignment adapter (4), with beam splitter assembly (22), on MAD mount per substeps below:

(a) Position MAD alignment adapter (4) on support (9) and bracket (11) and install three attach bolts (7 and 8).

(b) Torque three attach bolts (7 and 8) 20 to 25 inch-pounds.

(19) Install laser (5) on cone bolts in MAD alignment adapter (4) per substeps below:

(a) Slide laser (5) forward into MAD alignment adapter (4) until line on laser plate is aligned with aft edge of MAD alignment adapter.

(b) Rotate laser (5) until line on laser plate is aligned with up mark on MAD alignment adapter.

(c) Close two laser clamps (6).

(d) Hook chain (15) to MAD alignment adapter (4).

WARNING

Laser radiation, do not look into laser beam or eye injury could occur.

(20) Push control/display unit (16) switch (18) to on position.

(21) Read and record YAW display (17) indication on control/display unit (16).

(22) If YAW display (17) indication, recorded in substep r(25), is 0.0 ± 0.0 milliradians, the MAD mount is aligned within realignment tolerance. If within tolerance, go to step s. If not within tolerance, repeat step r.

s. Push control/display unit (16) switch (18) to off position.

t. Unplug cable (20) from electrical power source.

u. Disconnect cable (19), and ground wire, from control/display unit (16) and cable (20).

v. Unhook chain (14) from BRFS (1).

w. Disconnect cable (21) from control/display unit (16) and triaxial detector unit (2).

x. Disconnect laser cable from control/display unit (16).

y. Remove laser (5) from MAD alignment adapter (4) per substeps below:

(1) Unhook chain (15) from MAD alignment adapter (4).

(2) Open two laser clamps (6).

(3) Slide laser (5) aft out of MAD alignment adapter (4).

(4) Close two laser clamps (6).

z. Remove beam splitter assembly (22) by removing three attach bolts (23).

aa. Remove MAD alignment adapter (4) by removing three attach bolts (7 and 8).

ab. Install magnetic azimuth detector (A1-F18AC-730-300, WP009 00).

ac. Inspect door 23 area for foreign objects.

ad. Install door 23 (A1-F18AC-LMM-010).

ae. Remove triaxial detector unit (2) from BRFS (1) by removing three attach bolts (3).

af. Remove and stow boresight reference frame assembly (WP044 00).

ag. Remove safety devices, as required (A1-F18AC-PCM-000).

8. INITIAL ALIGNMENT PROCEDURE. See figure 1.

Support Equipment Required

NOTE

Alternate item type designations or part numbers are listed in parentheses.

Part Number or Type Designation	Nomenclature
74D110026-1003	Magnetic Azimuth
(74D110026-1001)	Detector Mount Alignment Adapter
-	Torque Wrench, 0 to 50 Inch-Pounds

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
NAS1671-08L2	Jo-Bolt (3)
P-D-680, TYPE II	Dry Cleaning Solvent
a. Verify alignment of triaxial alignment set (WP045 00).	
b. Set up and install boresight reference frame assembly (WP044 00).	
c. Install 74D111167 triaxial detector unit (2) on boresight reference frame subassembly (BRFS) (1) at magnetic azimuth detector (MAD) target point with three attach bolts (3) handtight.	
d. Remove door 23 (A1-F18AC-LMM-010).	
e. Remove magnetic azimuth detector (A1-F18AC-730-300, WP009 00).	
f. Install applicable 74D111074 magnetic azimuth detector mount alignment adapter subassembly (MAD alignment adapter) (4) on support (9) and bracket (11) (MAD mount) per substeps below:	



Dry Cleaning Solvent, P-D-680, Type II

7

(1) Clean mating surfaces of MAD alignment adapter (4), support (9), and bracket (11) using cheesecloth moistened with solvent. Make sure three attach bolts (7 and 8) are clean and free of burrs and damaged threads.

(2) Position MAD alignment adapter (4) on support (9) and bracket (11) and install three attach bolts (7 and 8).

(3) Torque two attach bolts (7) 20 to 25 inch-pounds.

(4) Tighten attach bolt (8) handtight, do not torque. Adapter must be free to rotate on this pivot point.

g. Loosen two bolts (13), attaching bracket (11) to support (10). Do not remove bolts.

h. Install 74D111159 beam splitter assembly (22) on MAD alignment adapter (4) with three attach bolts (23) handtight.

i. Install 74D111180 laser (5) on cone bolts in MAD alignment adapter (4) per substeps below:

(1) Open two laser clamps (6).

(2) Slide laser (5) forward into MAD alignment adapter (4) until line on laser plate is aligned with aft edge of MAD alignment adapter.

(3) Rotate laser (5) until line on laser plate is aligned with up mark on MAD alignment adapter.

(4) Close two laser clamps (6).

(5) Hook chain (15) to MAD alignment adapter (4).

j. Position 74D111141 control/display unit (16) midway between BRFS (1) and MAD alignment adapter (4).

k. Connect laser cable to control/display unit (16).

l. Connect 74D111145-1001 cable (21) to triaxial detector unit (2) and to control/display unit (16).

m. Hook chain (14) to BRFS (1).

n. Connect 74D111145-1003 cable (19), with ground wire, to control/display unit (16) and to 74D111145-1005 cable (20).

o. Plug in cable (20) to electrical power source.

WARNING

Laser radiation, do not look into laser beam or eye injury could occur.

NOTE

The main laser light will illuminate when control/display unit is turned on. When laser return is not sensed by the control/display unit after approximately 7 seconds, it will inhibit the laser, causing the main laser light to go off.

p. Push control/display unit (16) switch (18) to on position.

NOTE

The mount yaw indication is displayed on control/display unit. The YAW display is graduated in 0.01 milliradian increments. Ignore PITCH and ROLL displays on control/display unit.

q. Align the MAD mount yaw per substeps below:

(1) While monitoring YAW display (17), manually shift inboard end of MAD alignment adapter (4), forward or aft, until YAW display (17) indication is 0.0 ± 0.1 milliradian.

(2) Torque three bolts (8 and 13) 20 to 25 inch-pounds.

(3) Read and record YAW display (17) indication on control/display unit (16).

(4) If YAW display (17) is 0.0 ± 0.1 milliradians, the mount is aligned within tolerance. If within tolerance, go to substep q(5). If not within tolerance, loosen three bolts (8 and 13) and repeat substeps q(1) through q(4).

(5) Push control/display unit (16) switch (18) to off position.

(6) Remove laser (5) from MAD alignment adapter (4) per substeps below:

(a) Unhook chain (15) from MAD alignment adapter (4).

(b) Open two laser clamps (6).

(c) Slide laser (5) aft out of MAD alignment adapter (4).

(7) Remove MAD alignment adapter (4), with beam splitter assembly (22), by removing three attach bolts (7 and 8).

(8) Locate and drill three 0.165 +0.003 -0.000 inch diameter Jo-Bolt holes in bracket (11) and support (10).

(9) Install three NAS1671-08L2 Jo-Bolts (12), attaching bracket (11) to support (10).

(10) Install MAD alignment adapter (4), with beam splitter assembly (22), on MAD mount per substeps below:

(a) Position MAD alignment adapter (4) on support (9) and bracket (11) and install three attach bolts (7 and 8).

(b) Torque three attach bolts (7 and 8) 20 to 25 inch-pounds.

(11) Install laser (5) on cone bolts in MAD alignment adapter (4) per substeps below:

(a) Slide laser (5) forward into MAD alignment adapter (4) until line on laser plate is aligned with aft edge of MAD alignment adapter.

(b) Rotate laser (5) until line on laser plate is aligned with up mark on MAD alignment adapter.

(c) Close two laser clamps (6).

(d) Hook chain (15) to MAD alignment adapter (4).

(13) Read and record YAW display (17) indication on control/display unit (16).

(14) If YAW display (17) indication, recorded in substep q(13), is 0.0 ~~2.0~~ milliradians, the MAD mount is aligned within initial alignment tolerance. If within tolerance, go to step r. If not within tolerance, do paragraph 7, step r, this WP.

r. Push control/display unit (16) switch (18) to off position.

s. Unplug cable (20) from electrical power source.

t. Disconnect cable (19), and ground wire, from control/display unit (16) and cable (20).

u. Unhook chain (14) from BRFS (1).

v. Disconnect cable (21) from control/display unit (16) and triaxial detector unit (2).

w. Disconnect laser cable from control/display unit (16).

x. Remove laser (5) from MAD alignment adapter (4) per substeps below:

(1) Unhook chain (15) from MAD alignment adapter (4).

(2) Open two laser clamps (6).

(3) Slide laser (5) aft out of MAD alignment adapter (4).

(4) Close two laser clamps (6).

y. Remove beam splitter assembly (22) by removing three attach bolts (23).

z. Remove MAD alignment adapter (4) by removing three attach bolts (7 and 8).

aa. Install magnetic azimuth detector (A1-F18AC-730-300, WP009 00).

ab. Inspect door 23 area for foreign objects.

ac. Install door 23 (A1-F18AC-LMM-010).

ad. Remove triaxial detector unit (2) from BRFS (1) by removing three attach bolts (3).










ae. Remove and stow boresight reference frame assembly (WP044 00).

WARNING

Laser radiation, do not look into laser beam or eye injury could occur.

(12) Push control/display unit (16) switch (18) to on position.

af. Remove safety devices, as required
(A1-F18AC-PCM-000).

INDEX NO.	NOMENCLATURE	PART NO.
1 	BORESIGHT REFERENCE FRAME SUBASSEMBLY	74D111115
2 	TRIAXIAL DETECTOR UNIT	74D111167
3	ATTACH BOLT	
4 	MAGNETIC AZIMUTH DETECTOR MOUNT ALIGNMENT ADAPTER SUBASSEMBLY	74D111074
5 	LASER	74D111180
6	LASER CLAMP	
7	ATTACH BOLT	
8	ATTACH BOLT	
9	SUPPORT	74T030380 OR 74A200943
10	SUPPORT	74T030380 OR 74A200943
11	BRACKET	74T030380
12	JO-BOLT	NAS1671-08L2
13	BOLT WASHER	NAS673V2 AN960PD10L
14	CHAIN	
15	CHAIN	
16 	CONTROL/DISPLAY UNIT	74D111141
17	YAW DISPLAY	
18	SWITCH	
19 	CABLE	74D111145-1003
20 	CABLE	74D111145-1005
21 	CABLE	74D111145-1001
22 	BEAM SPLITTER ASSEMBLY	74D111159
23	ATTACH BOLTS	

LEGEND




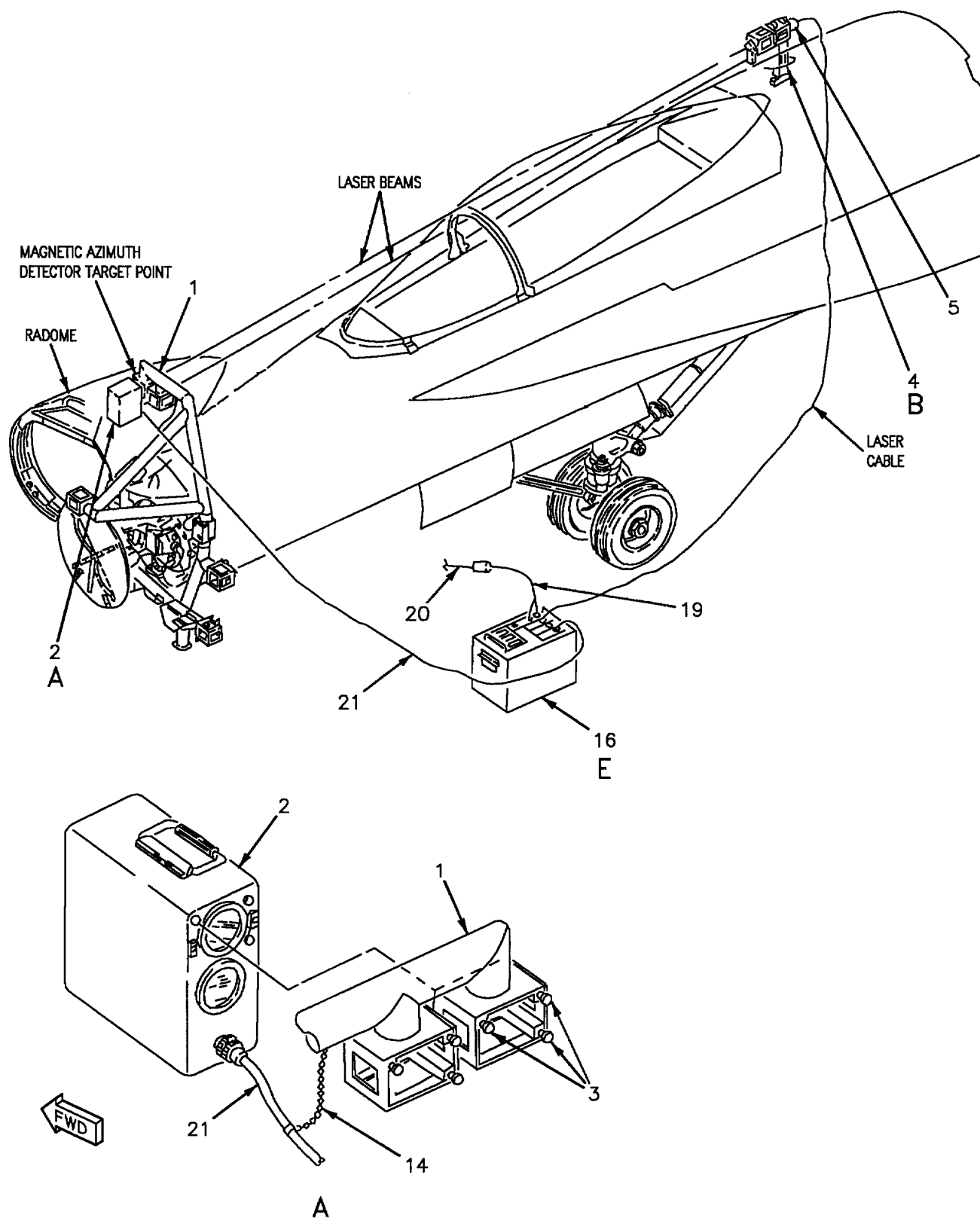
-  PART OF 74D110020 BORESIGHT REFERENCE FRAME ASSEMBLY OR 74D110163 BORESIGHT ALIGNMENT SET.
-  PART OF 74D110021 TRIAXIAL ALIGNMENT SET.
-  PART OF 74D110026-1001 MAGNETIC AZIMUTH DETECTOR MOUNT ALIGNMENT ADAPTER FOR 161353 THRU 161987.
PART OF 74D110026-1003 MAGNETIC AZIMUTH DETECTOR MOUNT ALIGNMENT ADAPTER FOR 162394 AND UP.

Figure 1. Magnetic Azimuth Detector Mount (Sheet 1)



18AC-SRM-222-(140-2)01-SCAN

Figure 1. Magnetic Azimuth Detector Mount (Sheet 2)

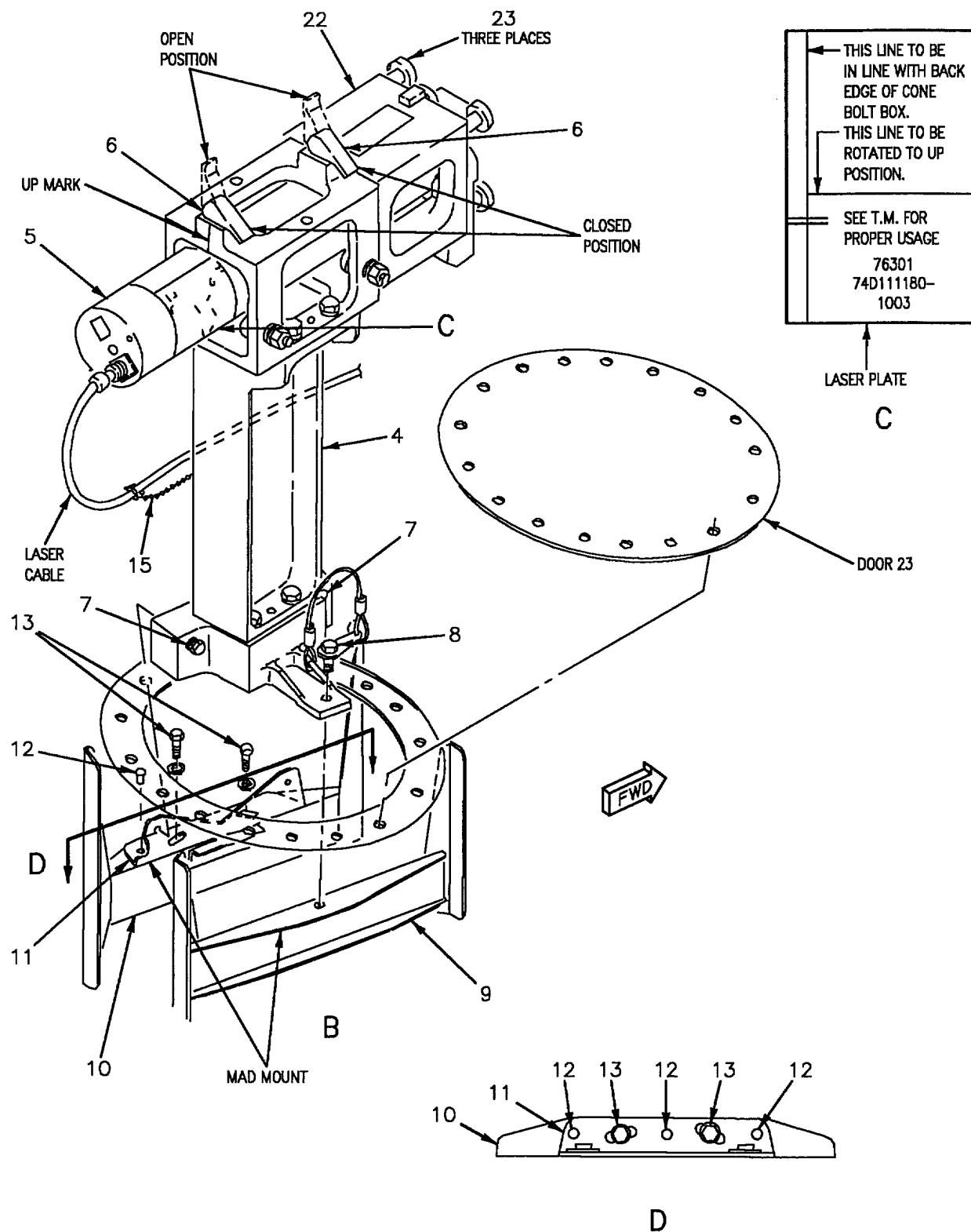
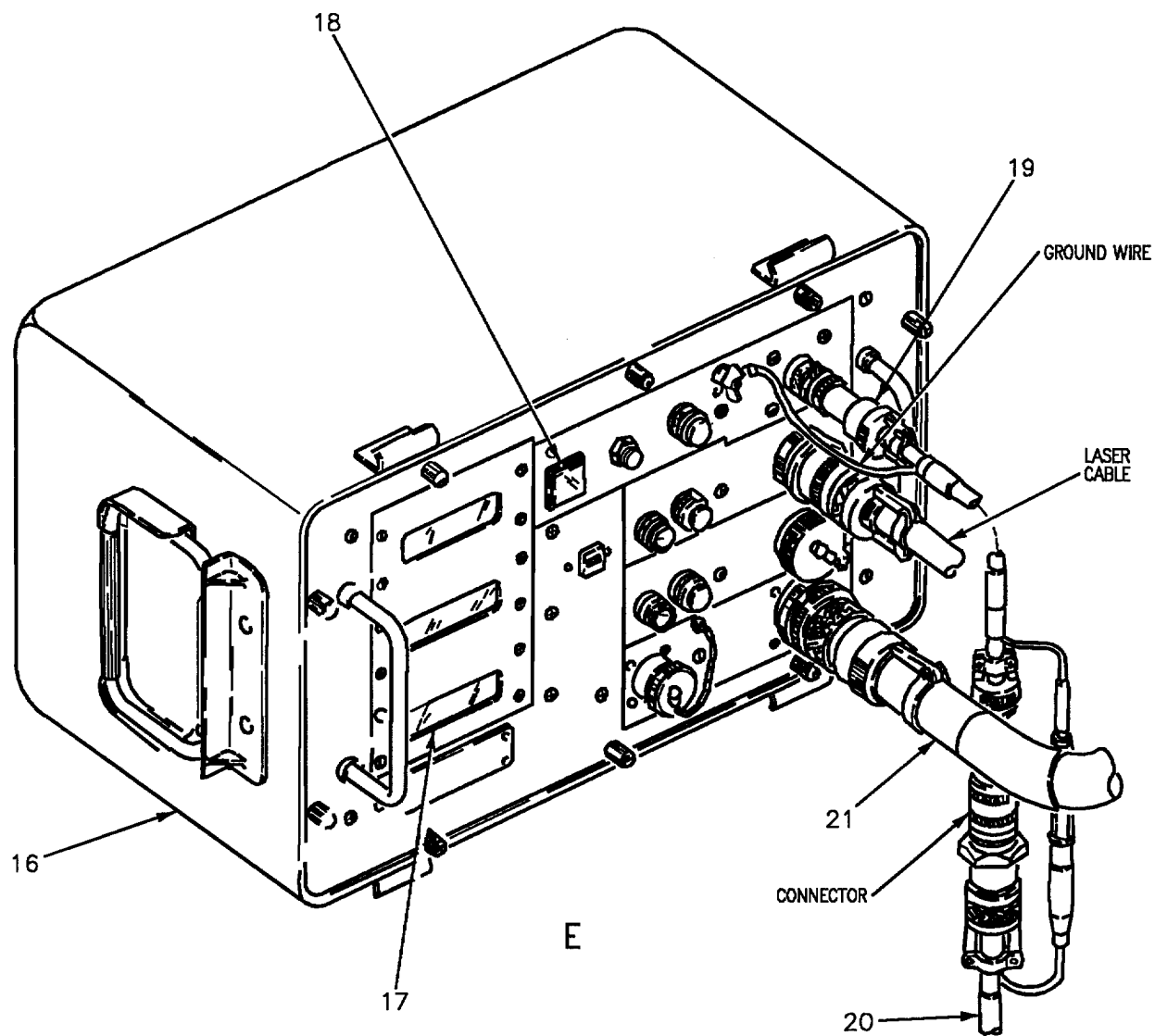


Figure 1. Magnetic Azimuth Detector Mount (Sheet 3)



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Figure 1. Magnetic Azimuth Detector Mount (Sheet 4)

DEPOT MAINTENANCE

AIRSTREAM DIRECTION SENSING UNIT TRU-185/A MOUNTS BORESIGHTING

Reference Material

Air Data Computer System	A1-F18AC-560-300
Airstream Direction Sensing Unit TRU-185/A (70A-A003 and 70A-B004)	WP005 00
Line Maintenance Access Doors	A1-F18AC-LMM-010
Line Maintenance Procedures	A1-F18AC-LMM-000
Plane Captain Manual	A1-F18AC-PCM-000
Structure Repair, Forward Fuselage	A1-F18AC-SRM-220
Boresight Reference Frame Assembly	WP044 00

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Aircraft Lowering	6
Aircraft Pitch Stabilization	2
Aircraft Preparation	2
Alignment Verification Procedure	3
Installation Alignment Procedure	4
Introduction	1
General Instructions	1

Record of Applicable Technical Directives

None

1. INTRODUCTION.

2. This work package contains depot level maintenance instructions required for boresighting the airstream direction sensing unit mounts located on the left and right sides of the forward fuselage. The boresighting instructions are divided into two separate procedures; an alignment verification procedure, and an installation alignment procedure. These two procedures are described below:

a. Alignment verification procedure, refer to paragraph 9. This procedure is used to determine if the left and right airstream direction sensing unit alignment pin holes in the sensing unit mounts are aligned with the aircraft pitch reference plane within tolerance.

b. Installation alignment procedure, refer to paragraph 10. This procedure is used to initially locate and drill the airstream direction sensing unit alignment pin holes in the sensing unit mounts when the mounts have been either replaced or repaired.

3. **GENERAL INSTRUCTIONS.** To make sure the airstream direction sensing units alignment pin holes in the sensing unit mounts are accurately located and drilled, the instructions below shall be used:

a. Personnel must be familiar with the use and operation of the clinometer, and must also know the principles of boresighting.

b. Boresighting should be done separately from other maintenance operations. If other maintenance operations must be done during boresighting operation, pitch stabilize the aircraft, using a fuselage jack, per paragraph 7, or misalignment of the airstream direction sensing unit alignment pin holes in the sensing unit mounts will occur.

c. Mounting pads on the aircraft, boresight reference frame subassembly, and sensing unit TRU-185/A alignment adapters shall be clean and free of burrs. Attach bolts shall be clean, and free of burrs and damaged threads.

d. Visually inspect for loose or missing sealant around nuts on equipment.

e. Visually inspect for corrosion, distortion, damage, and missing hardware.

4. AIRCRAFT BORESIGHT REQUIREMENTS.

5. Aircraft structural flexing affects boresight accuracy. To control the affect of this flexing and to be sure the mounts are accurately boresighted, the fuselage, forward of Y204.50, shall be as listed below:

a. Make sure all armament, avionics, electrical equipment and/or ballast is installed.

b. Make sure ammunition drum is empty.

c. Make sure door 3 is closed (A1-F18AC-LMM-010).

6. AIRCRAFT PREPARATION.

a. Make sure ground safety devices required during ground operations are installed (A1-F18AC-PCM-000).

7. AIRCRAFT PITCH STABILIZATION.

8. Pitch stabilization of the aircraft is required if other maintenance operations must be done during the boresighting operation. Pitch stabilize the aircraft per steps below:

Support Equipment Required

Part Number or Type Designation	Nomenclature
270AS100	20 Ton Hydraulic Tripod Jack-Forward Fuselage Jacking Pad
62A123D1-1	Wheel Chocks

Materials Required

None



To prevent damage to aircraft, minimum structural access doors must be installed/closed.

a. Make sure minimum structural access doors, required for jacking at wing and forward fuselage pads, are installed/closed (A1-F18AC-LMM-000).

b. Make sure radome, door 1, is closed and secured (A1-F18AC-LMM-010).

c. Open fuselage jack pad access door 16 (A1-F18AC-LMM-010).

NOTE

Wing jacks are not required for aircraft pitch stabilization.

d. Position fuselage jack under forward fuselage jack pad.

e. Raise jack until firm against fuselage jack pad.



Fuselage jack ground pads must rest on ground when aircraft is jacked.

f. Raise the fuselage jack until the jack ground pads rest firmly on the ground. Observe the dimension of jack ram extension from top of jack. Continue to raise the jack until the jack ram is extended 1 inch more. Tighten the jack ram locknut.

g. Tie down aircraft, if required.

9. **ALIGNMENT VERIFICATION PROCEDURE.** See figure 1.

Support Equipment Required

Part Number or Type Designation	Nomenclature
23-2052	Clinometer with Adjustable Base
74D110025-1001	Sensing Unit TRU-185/A
-	Transmitter Mount Alignment Adapter
-	Torque Wrench, 0 to 50 Inch-Pounds

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
P-D-680 TYPE II	Dry Cleaning Solvent

- a. Set up and install boresight reference frame assembly (BRFS) (WP044 00).
- b. Remove left and right Airstream Direction Sensing Units TRU-185/A, as required (A1-F18AC-560-300, WP005 00).
- c. Determine if two alignment pin holes in applicable left and/or right airstream direction sensing unit mounts (mounts) are within the alignment check tolerance per substeps below:
- (1) Measure and record the diameter of the two alignment pin holes in the left and right mounts.
- (2) If the diameter of the alignment pin holes, measured in substep c(1), are 0.1260 +0.0020 -0.0000 inch diameter the holes are within tolerance. If within tolerance, go to step d. If not within tolerance, refer to engineering for disposition.
- d. Install the applicable left, 74D111069-1001, or right, 74D111069-1002, sensing unit TRU-185/A align-

ment adapter subassembly (adapter) (3 or 2) on the applicable left or right mount per substeps below:



Dry Cleaning Solvent, P-D-680, Type II 7

- (1) Clean mating surfaces of adapter (3 or 2) and mount using cheesecloth moistened with solvent.
- (2) Install applicable adapter (3 or 2) on the mount with the pitch platform parallel (horizontal) to the Z plane. Install the three guide bolts (6) and the three hold down bolts (7) in mount platenuts (5). Tighten the three guide bolts (6) handtight. Do not torque, as the adapter must be free to be manually rotated.
- (3) Remove drill bushings (8) or ream bushings (16), if installed, from adapters.
- (4) Rotate the adapter until the two alignment step pins (10) can be inserted through the adapter and into the alignment pin holes in the mounts. Make sure the alignment step pins are seated against the adapter.
- (5) Torque the three hold down bolts (7) 20 to 25 inch-pounds.
- (6) Remove alignment step pins (10) from the adapter.
- e. Set the clinometer with adjustable base (clinometer) (13) to 0°0', by turning micrometer drum (14). Put the clinometer on BRFS (1) pitch platform (4) facing left.

NOTE

- Adjust the clinometer, by turning the adjustable base adjustment screw. Do not turn the micrometer drum.
- f. Neutralize the pitch attitude of the aircraft, by turning the clinometer adjustable base adjustment screw (11), until bubble level (12) indicates level.

NOTE

Do not change the clinometer micrometer drum setting from 0°0' or change the adjustable base adjustment screw setting, as these settings will be used to verify the alignment of the mounts.

g. Remove clinometer (13) from BRFS (1) pitch platform (4).

h. Put clinometer (13) on applicable adapter (3 or 2) pitch platform per substeps below:

(1) Left adapter (3): Put clinometer facing outboard.

(2) Right adapter (2): Put clinometer facing inboard.

i. Determine if the two alignment pin holes in the mounts are located in the pitch reference plane within the alignment verification tolerance per substeps below:

(1) Adjust clinometer (13), by turning micrometer drum (14), until bubble level (12) indicates level.

NOTE

Clinometer degree scale is graduated in 1° increments and is marked in plus (black) numbers from 0° to 90° and in minus (red) numbers from 0° to -10°. The micrometer drum is graduated in 1' increments and is marked in plus (black) numbers from 0' to 60' and in minus (red) numbers from 0' to 60'.

(2) Read clinometer (13) degree scale (15) and micrometer drum (14) settings in degrees, minutes, and estimate seconds. Record the data.

(3) If the clinometer degree scale and micrometer drum data, recorded in step i(2), is within the alignment verification tolerance of 0°0' 0" ~~±0.6"~~ the alignment pin holes in the mounts are aligned with tolerance. If within tolerance, go to step j. If not within tolerance, refer to engineering for disposition.

j. Remove clinometer (13) from adapter.

k. Loosen the adapters three hold down bolts (7) and the three guide bolts (6) and remove the adapters from the aircraft.

l. Inspect the mount areas for foreign objects.

m. Install the left and right Airstream Direction Sensing Units TRU-185/A, as required (A1-F18AC-560-300, WP005 00).

n. Remove and stow boresight reference frame assembly (WP044 00).

o. If the aircraft was pitch stabilized, per paragraph 7, lower the aircraft per paragraph 11.

p. Remove safety devices, as required (A1-F18AC-PCM-000).

10. INSTALLATION ALIGNMENT PROCEDURE. See figure 1.

Support Equipment Required

Part Number or Type Designation	Nomenclature
23-2052	Clinometer with Adjustable Base
74D110025-1001	Sensing Unit TRU-185/A Transmitter Mount Alignment Adapter
-	Torque Wrench, 0 to 50 Inch-Pounds

Materials Required

Specification or Part Number	Nomenclature
CCC-C-440 TYPE 1 CLASS 1	Cheesecloth
P-D-680 TYPE II	Dry Cleaning Solvent
0.1130 +0.0000 -0.0003 inch diameter (#33)	Drill Bit
0.1260 +0.0000 -0.0002 inch diameter	Reamer

a. Set up and install boresight reference frame assembly (BRFS) (WP044 00).

b. Install the applicable left, 74D111069-1001, or right 74D111069-1002, sensing unit TRU-185/A

alignment adapter subassembly (adapter) (3 and 2) on the applicable left or right airstream direction sensing unit mount (mount) per substeps below:



Dry Cleaning Solvent, P-D-680, Type II

7

(1) Clean mating surfaces of adapter (3 or 2) and mount using cheesecloth moistened with solvent.

(2) Install applicable adapter (3 or 2) on the mount with the pitch platform parallel (horizontal) to the Z plane. Install the three guide bolts (6) and the three hold down bolts (7) in mount platenuts (5). Tighten the three guide bolts handtight. Do not torque, as the adapter must be free to be manually rotated.

c. Set the clinometer with adjustable base (clinometer) (13) to 0°0', by turning micrometer drum (14). Put the clinometer on BRFS (1) pitch platform (4) facing left.

NOTE

Adjust the clinometer, by turning the adjustable base adjustment screw. Do not turn the micrometer drum.

d. Neutralize the pitch attitude of the aircraft, by turning the clinometer adjustable base adjustment screw (11), until bubble level (12) indicates level.

NOTE

Do not change the clinometer micrometer drum setting from 0°0' or change the adjustable base adjustment screw settings, as these settings will be used to align the adapter in relation to the aircraft pitch reference plane.

e. Remove clinometer (13) from BRFS (1) pitch platform (4).

f. Put clinometer (13) on applicable adapter (3 or 2) pitch platform, per substeps below:

(1) Left adapter (3): Put the clinometer facing outboard.

(2) Right adapter (2): Put the clinometer facing inboard.

g. Align adapter (3 or 2) in the pitch reference plane, by rotating the adapter until clinometer (13) bubble level (12) indicates level. Torque the three hold down bolts (7) 20 to 25 inch-pounds.

h. Make sure clinometer bubble level (12) still indicates level. If not, loosen hold down bolts (7) and repeat step g.

NOTE

Do not change the clinometer adjustable base adjustment screw setting as it will cause misalignment.

i. Remove clinometer (13) from the adapter and set aside.

j. Drill and ream the airstream direction sensing units two alignment pin holes in the mount per the substeps below:

(1) Insert captive drill bushing (8) into adapter at the upper alignment pin hole position. Lock the bushing in position with lock screw (9).

(2) Using a 0.1130 +0.0000 -0.0003 inch diameter (#33) drill, drill the upper alignment pin hole in mount.

(3) Remove drill bushing (8) and install ream bushing (16). Lock the bushing in position with lock screw (9).

(4) Using a 0.1260 +0.0000 -0.0002 inch diameter reamer, ream the upper alignment pin hole in mount.

(5) Remove ream bushing (16).

(6) Drill and ream lower alignment pin hole in mount by repeating step j(1) through j(5).

k. Loosen the adapter three hold down bolts (7) and the three guide bolts (6) and remove the adapters from the aircraft.

l. Deburr the alignment pin holes and remove foreign objects.

m. Determine if the diameter of the two alignment pin holes are within the installation alignment tolerance per substeps below:

(1) Measure and record the diameter of the alignment pin holes.

(2) If the diameter of the alignment pin holes, measured in step m(1), are 0.1260 +0.0015 -0.0000 inch diameter the holes are within tolerance. If within tolerance, go to step n. If the holes are undersize, hand ream, as required. If the holes are oversize, refer to engineering for disposition.

n. Reinstall applicable adapter (3 or 2) on the mounts per substeps below:

(1) Install the applicable adapter on the mount, with the pitch platform parallel (horizontal) to the Z plane. Install the three guide bolts (6) and the three hold down bolts (7) in mount platenuts (5). Tighten the three guide bolts handtight. Do not torque, as the adapter must be free to be manually rotated.

(2) Rotate the adapter until the two alignment step pins (10) can be inserted through the adapter and into the two alignment pin holes in the mount. Make sure the alignment step pins are seated against the adapter.

(3) Torque the three hold down bolts (7) 20 to 25 inch-pounds.

(4) Remove alignment step pins (10) from the adapter.

NOTE

Do not change the clinometer adjustable base adjustment screw setting, as it will cause the clinometer reading to be in error.

o. Put clinometer (13) on applicable adapter (3 or 2) pitch platform per substeps below:

(1) Left adapter (3): Put the clinometer facing outboard.

(2) Right adapter (2): Put the clinometer facing inboard.

p. Determine if the two alignment pin holes in the mounts are located in the pitch reference plane within tolerance per the substeps below:

(1) Adjust clinometer (13), by turning micrometer drum (14) until bubble level (12) indicates level.

NOTE

Clinometer degree scale is graduated in 1° increments and is marked in plus (black) numbers from 0° to 90° and in minus (red) numbers from 0° to -10°. The micrometer drum is graduated in 1' increments and is marked in plus (black) numbers from 0' to 60' and in minus (red) numbers from 0' to 60'.

(2) Read clinometer (13) degree scale (15) and micrometer drum (14) setting in degrees, minutes, and estimate seconds. Record the data.

(3) If the clinometer degree scale and micrometer drum data, recorded in substep p(2), is 0° 0' 0" ~~00' 30"~~ the alignment pin holes in the mounts are aligned within the installation alignment tolerance. If within tolerance, go to step q. If not within tolerance, refer to engineering for disposition.

q. Remove clinometer (13) from the adapter.

r. Loosen the adapters three hole down bolts (7) and the three guide bolts (6) and remove the adapters from the aircraft.

s. Inspect the mount area for foreign objects.

t. Install left and right Airstream Direction Sensing Units TRU-185/A, as required (A1-F18AC-560-300, WP005 00).

u. Remove and stow boresight reference frame assembly (WP044 00).

v. If the aircraft was pitch stabilized per paragraph 7, lower the aircraft per paragraph 11.

w. Remove safety devices, as required (A1-F18AC-PCM-000).

11. AIRCRAFT LOWERING.

a. Make sure minimum structural access doors, required for jacking at wing and forward fuselage pads, are installed/closed (A1-F18AC-LMM-000).






To prevent possible damage to the aircraft or equipment, remove the jack handle from jack before lowering aircraft.

b. Loosen jack ram locknut.

c. Open jack release valve and slowly lower aircraft.

d. Remove jack from under aircraft

e. Close fuselage jack pad access door 16 (A1-F18AC-LMM-010).

INDEX NO	NOMENCLATURE	PART NUMBER
1 	BORESIGHT REFERENCE FRAME SUBASSEMBLY	74D111115
2 	SENSING UNIT TRU-185/A ALIGNMENT ADAPTER SUBASSEMBLY RIGHT SIDE	74D111069-1002
3 	SENSING UNIT TRU-185/A ALIGNMENT ADAPTER SUBASSEMBLY LEFT SIDE	74D111069-1001
4	PITCH PLATFORM	
5	PLATENUTS	
6	GUIDE BOLT	
7	HOLD DOWN BOLT	
8	DRILL BUSHING	
9	LOCK SCREW	
10	STEP PIN	
11	ADJUSTABLE BASE ADJUSTMENT SCREW	
12	BUBBLE LEVEL	
13	CLINOMETER WITH ADJUSTABLE BASE	23-2052
14	MICROMETER DRUM	
15	DEGREE SCALE	
16	REAM BUSHING	

LEGEND



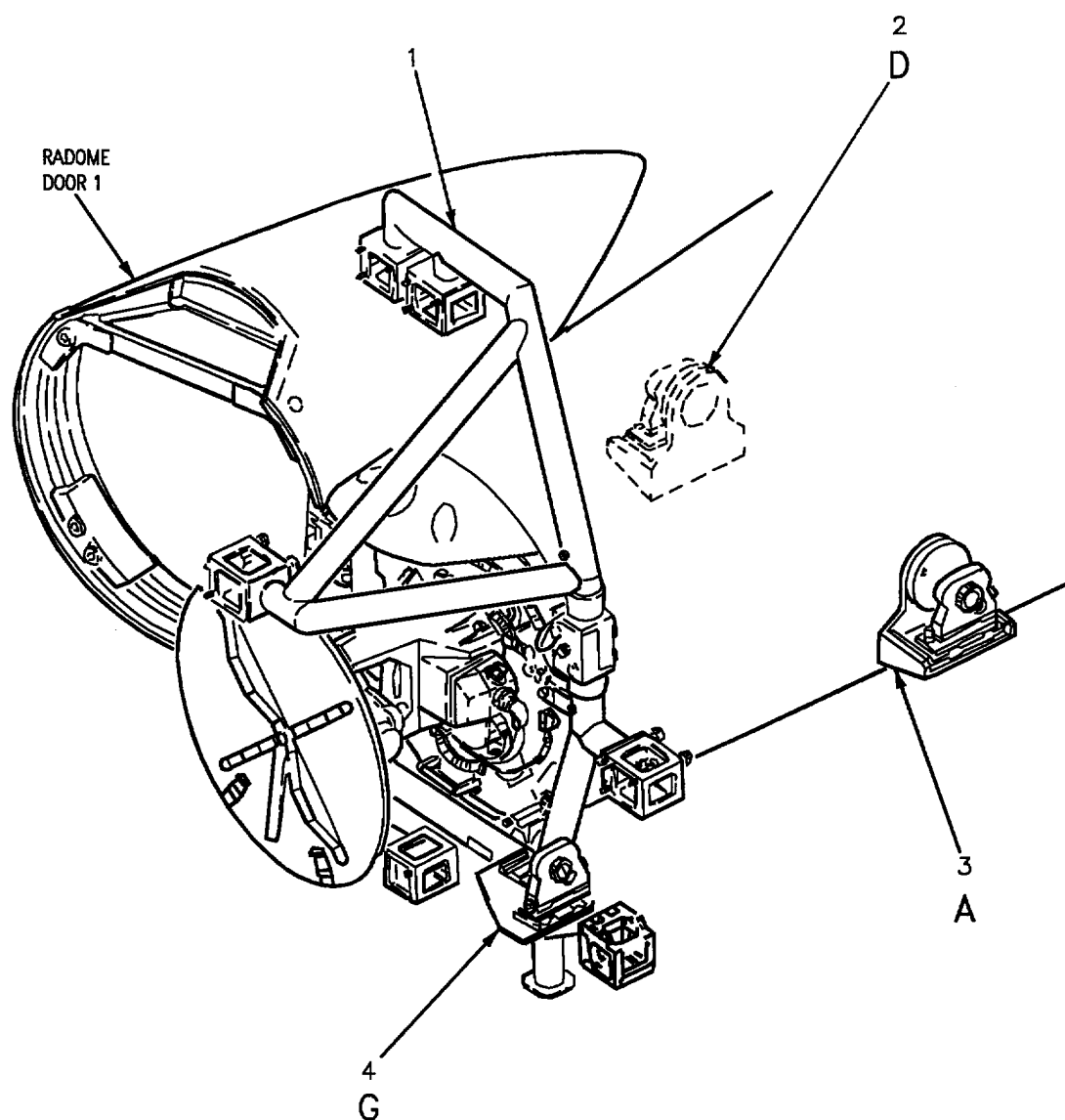
-  PART OF 74D110020 BORESIGHT REFERENCE FRAME ASSEMBLY OR 74D110163 BORESIGHT ALIGNMENT SET.
-  PART OF 74D110025-1001 SENSING UNIT TRU-185/A TRANSMITTER MOUNT ALIGNMENT ADAPTER.

Figure 1. Airstream Direction Sensing Unit TRU-185/A Mounts (Sheet 1)



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Figure 1. Airstream Direction Sensing Unit TRU-185/A Mounts (Sheet 2)

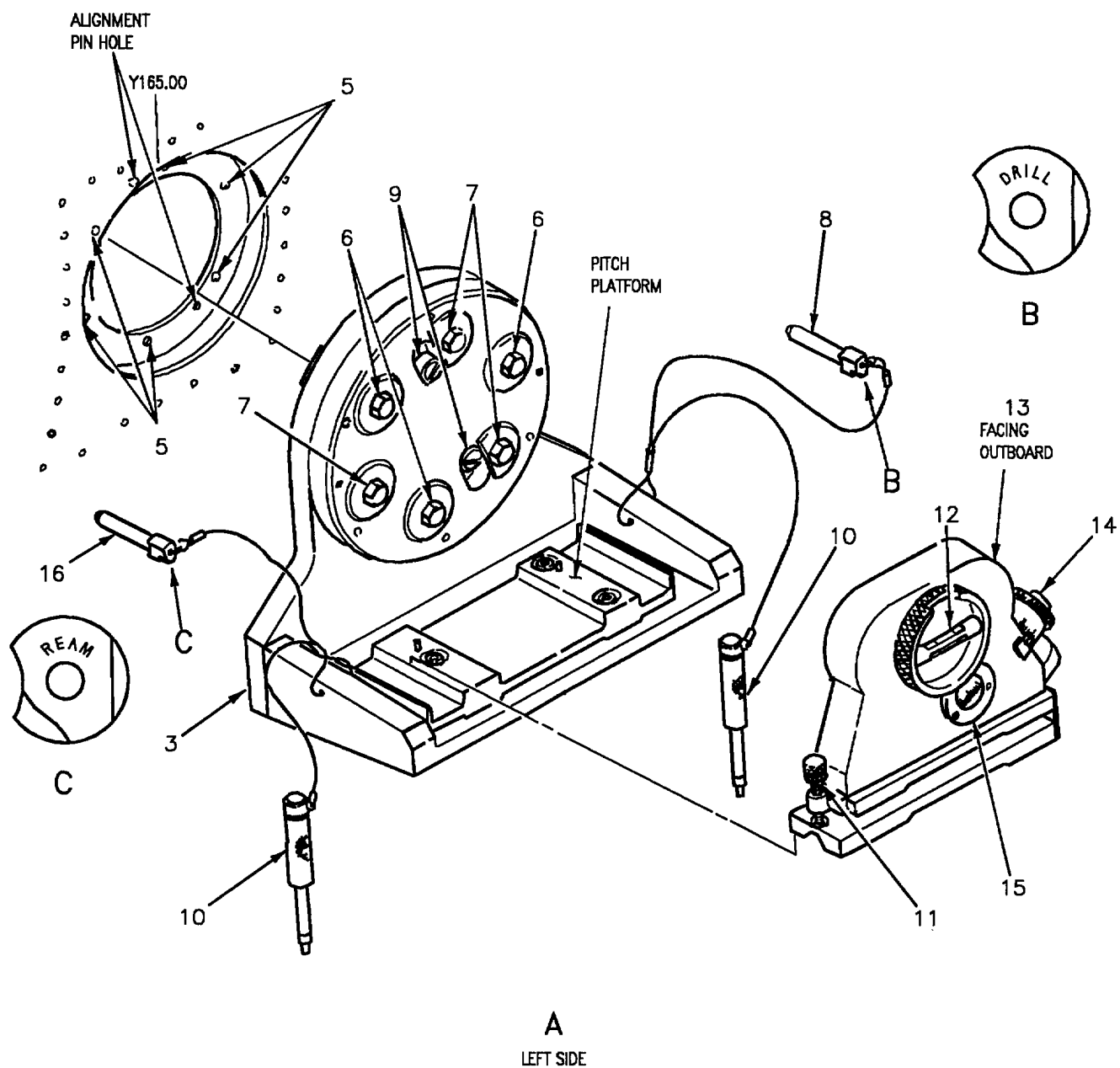
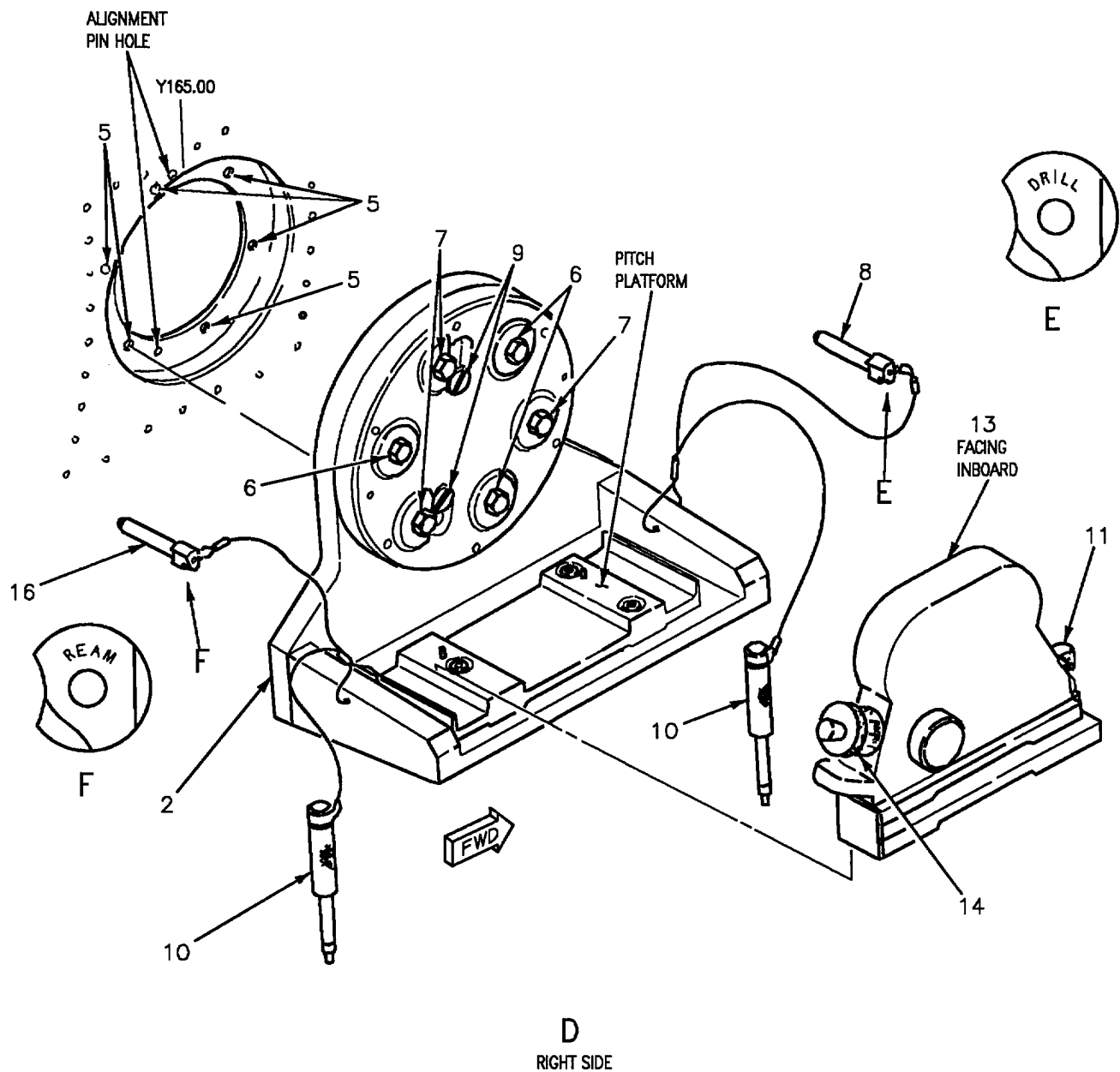
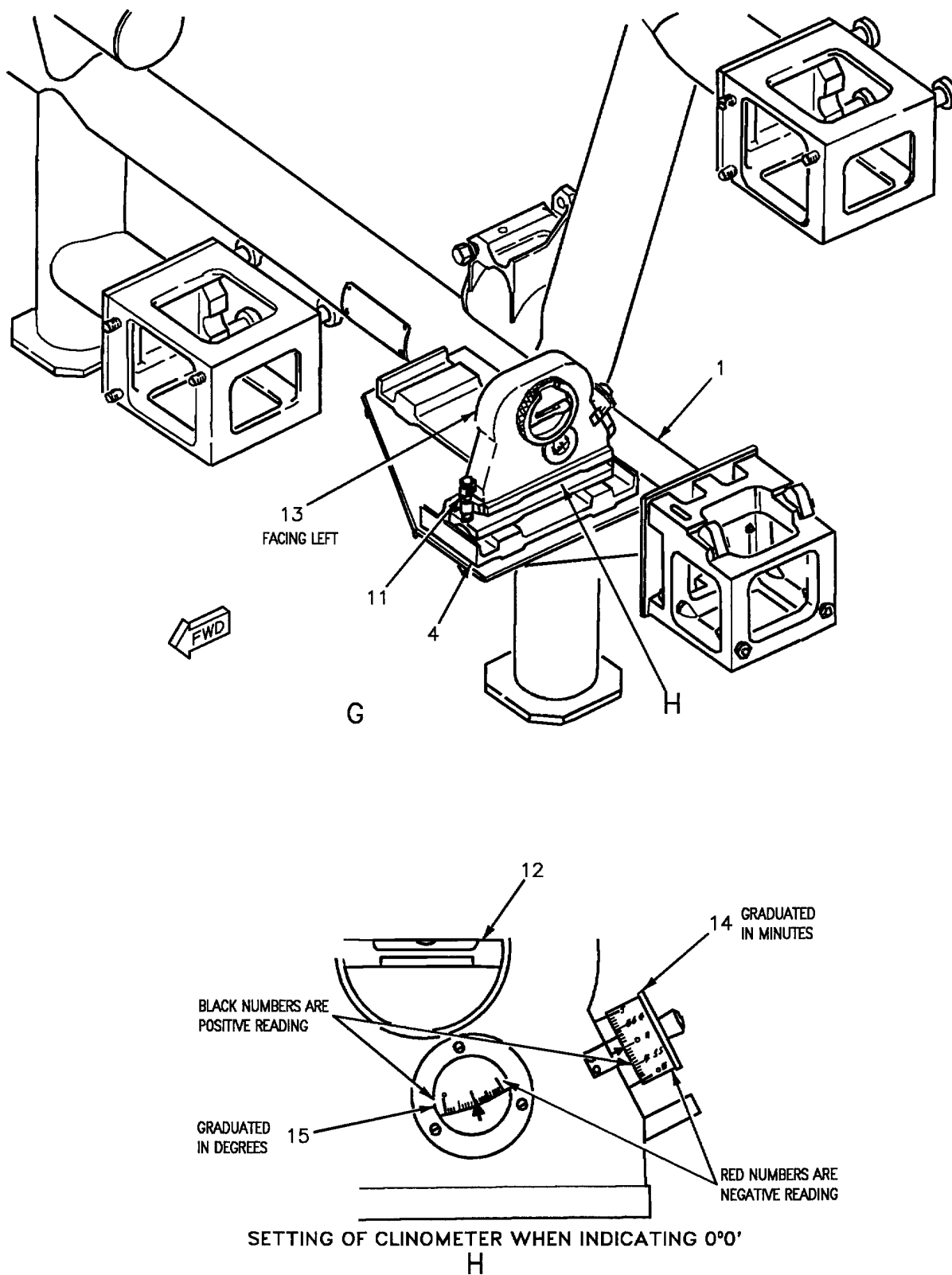


Figure 1. Airstream Direction Sensing Unit TRU-185/A Mounts (Sheet 3)





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Figure 1. Airstream Direction Sensing Unit TRU-185/A Mounts (Sheet 5)

ORGANIZATIONAL MAINTENANCE
BORESIGHT REFERENCE FRAME ASSEMBLY

Reference Material

Line Maintenance Access Doors	A1-F18AC-LMM-010
Plane Captain Manual	A1-F18AC-PCM-000
Radar System	A1-F18AC-742-300
Extension and Stowage of Radar Set AN/APG-65	WP003 00

Alphabetical Index

Subject	Page No.
Aircraft Preparation	1
Installation Procedure	2
Introduction	1
Removal and Stowage Procedure	4
Setup Procedure	1

Record of Applicable Technical Directives

None

1. INTRODUCTION.

2. This work package contains organization level maintenance instructions for setup, installation, and removal of the boresight reference frame assembly. This procedure is used for installing the boresight reference frame assembly on the radar bulkhead to establish a boresight target point for the triaxial alignment set.

3. AIRCRAFT PREPARATION.

a. Make sure ground safety devices required during all ground operations are installed (A1-F18AC-PCM-000).

4. SETUP PROCEDURE. See Figure 1.

Support Equipment Required

NOTE

Alternate item type designations or part numbers are listed in parentheses.

Part Number or Type Designation	Nomenclature
74D740001-1001	Antenna Cover
74D110163-1001 (74D110020-1001)	Boresight Alignment Set (Boresight Reference Frame Assembly)
-	Torque Wrench, 0 to 200 Inch-Pounds
-	Torque Wrench, 700 to 1600 Inch-Pounds

Materials Required

Specification
or Part Number

Nomenclature

CCC-C-440 TYPE 1
CLASS 1

Cheesecloth

P-D-680 TYPE II

Dry Cleaning Solvent

AN960JD516L

Washer (As Reqd)

a. Remove 74D111115 boresight reference frame subassembly (BRFS) (1) from storage case.

b. Set BRFS (1) on the two rubber pads.

c. Prepare BRFS (1) per substeps below:

(1) Remove two L-pins (3) securing BRFS in folded position.

(2) Unfold BRFS.

(3) Remove two tapered pins (2) from stowed position and install in hinge. Do not use hand tools on tapered pins.

(4) Initially torque nuts on tapered pins (2) to 80 ~~5-lb~~ inch-pounds. Continue torquing nuts sequentially in 10 inch-pound increments to 120 ~~5-lb~~ inch-pounds. Do not use hand tools on tapered pins.

(5) Torque hinge pivot bolt (4) to 1000 ~~50~~ inch-pounds.

(6) Retorque nuts on tapered pins (2) to 120 ~~5-lb~~ inch-pounds. Do not use hand tools on tapered pins.

5. INSTALLATION PROCEDURE. See figure 2.

a. Open radome (A1-F18AC-LMM-010).

b. Install antenna cover (7) on antenna.



Dry Cleaning Solvent, P-D-680, Type II

7

c. Clean mating surfaces of boresight reference frame subassembly (BRFS) (1) and aircraft attach points using cheesecloth moistened with solvent. Make sure three attach bolts (2, 3, and 4) are clean and free of burrs and damaged threads. Make sure attach point plate nut threads on bulkhead are clean and free of grease and foreign matter.

d. Make sure Radar Set AN/APG-65 is stowed (A1-F18AC-742-300, WP003 00).



Failure to compensate for repair doubler interference with BRFS will cause boresight error. Use minimum number of washers required to clear repair doubler.

NOTE

Repair doubler exists on a limited number of aircraft. It is approximately 10 inches long and installed on lower right side of bulkhead in place of machined bosses around alignment pin and radome latch striker.

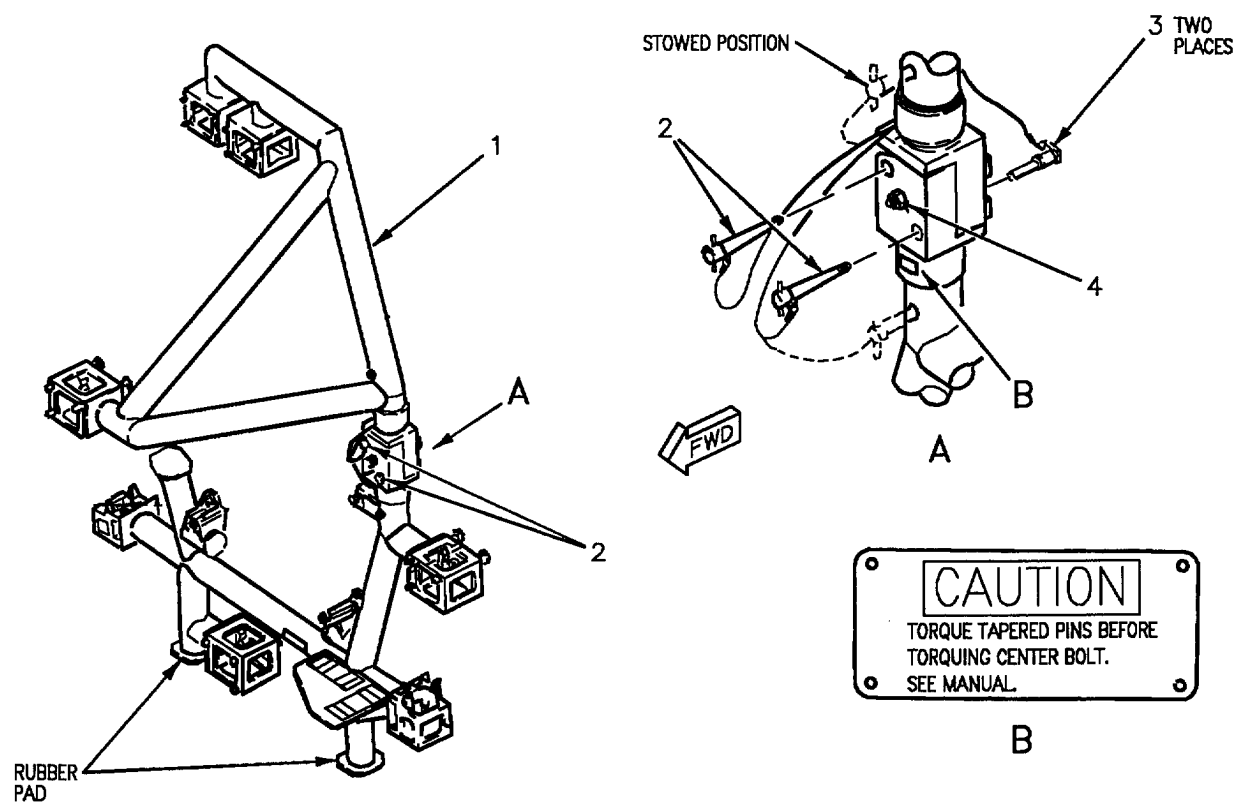
e. Inspect radar bulkhead for a repair doubler located on the forward right side near BRFS attach point. If doubler is installed, do substeps below:


(1) Install one AN960JD516L washer on each BRFS attach bolt (2, 3 and 4) between BRFS and bulkhead.

(2) Install BRFS per step f, and inspect to make sure BRFS is flush against washers and clear of repair doubler.

(3) If required, remove BRFS and install additional equal number of AN960JD516L washers on each attach bolt to clear repair doubler.

f. Install BRFS (1) on aircraft per substeps below:



INDEX NO.	NOMENCLATURE	PART NUMBER
1 	BORESIGHT REFERENCE FRAME SUBASSEMBLY	74D111115
2	TAPERED PIN	
3	L-PIN	
4	HINGE PIVOT BOLT, 1 -1/8 INCH	

LEGEND

 PART OF 74D110020 BORESIGHT REFERENCE FRAME ASSEMBLY OR 74D110163 BORESIGHT ALIGNMENT SET.

Figure 1. Boresight Reference Frame Subassembly, Setup

WARNING


BRFS weighs approximately 75 pounds and can be unstable when being raised to its installation height. Be careful when installing BRFS to avoid personal injury and/or damage to radar antenna planar array.


Do not lift BRFS by the triaxial alignment boxes, lift only at the main structure, or damage to BRFS may occur.


(1) Lift BRFS up, slide it on two alignment pins (5 and 6), and hold in position. Install upper attach bolt (4) handtight, then install two lower attach bolts (2 and 3) handtight.


(2) Check mating of BRFS attaching points with aircraft attaching points to make sure that BRFS is not warped or damaged.


(3) Torque three attach bolts (2, 3, and 4) in the sequence and torque per substeps below:


(a) Torque lower left bolt (2) to 90  inch-pounds.


(b) Torque lower right bolt (3) to 90  inch-pounds.


(c) Torque upper left bolt (4) to 90  inch-pounds.


(d) Torque lower left bolt (2) to 105  inch-pounds.

(e) Torque lower right bolt (3) to 105  inch-pounds.

(f) Torque upper left bolt (4) to 105  inch-pounds.

(g) Torque lower left bolt (2) to 120  inch-pounds.

(h) Torque lower right bolt (3) to 120  inch-pounds.

(i) Torque upper left bolt (4) to 120  inch-pounds.

6. REMOVAL AND STOWAGE PROCEDURE. See figure 3.

WARNING

BRFS weighs approximately 75 pounds and can be unstable when being removed from aircraft. Be careful when removing BRFS to avoid personal injury and/or damage to radar antenna planar array.

Do not lift BRFS by the triaxial alignment boxes, lift only at the main structure, or damage to BRFS may occur.

a. Hold boresight reference frame subassembly (BRFS) (1) in position and remove two lower attach bolts (2 and 3) then remove upper attach bolt (4). Being careful, slide BRFS off of two alignment pins (5 and 6) and set on the two rubber pads.

b. Remove washers, if installed in paragraph 5.

c. Stow BRFS (1) per substeps below:

(1) Remove two tapered pins (10), using the tapered pin nuts as extractors, and put in stowed position. Do not use hand tools on tapered pins.

WARNING

Upper half of BRFS will fold down when hinge pivot bolt is loosened. Guide upper half down carefully to avoid personal injury or damage to BRFS.

To prevent damage to hinge pivot bolt, loosen a maximum of one-half turn.

(2) Loosen hinge pivot bolt (9) one-half turn.


(3) Fold BRFS and install two L-pins (8).

(4) Put BRFS in storage case.

d. Inspect radome area for foreign objects.

e. Remove antenna cover (7).

f. Close radome (A1-F18AC-LMM-010).

INDEX NO.	NOMENCLATURE	PART NUMBER
1 	BORESIGHT REFERENCE FRAME SUBASSEMBLY	74D111115
2	ATTACH BOLT	
3	ATTACH BOLT	
4	ATTACH BOLT	
5	ALIGNMENT PIN	
6	ALIGNMENT PIN	
7	ANTENNA COVER	74D740001-1001

LEGEND


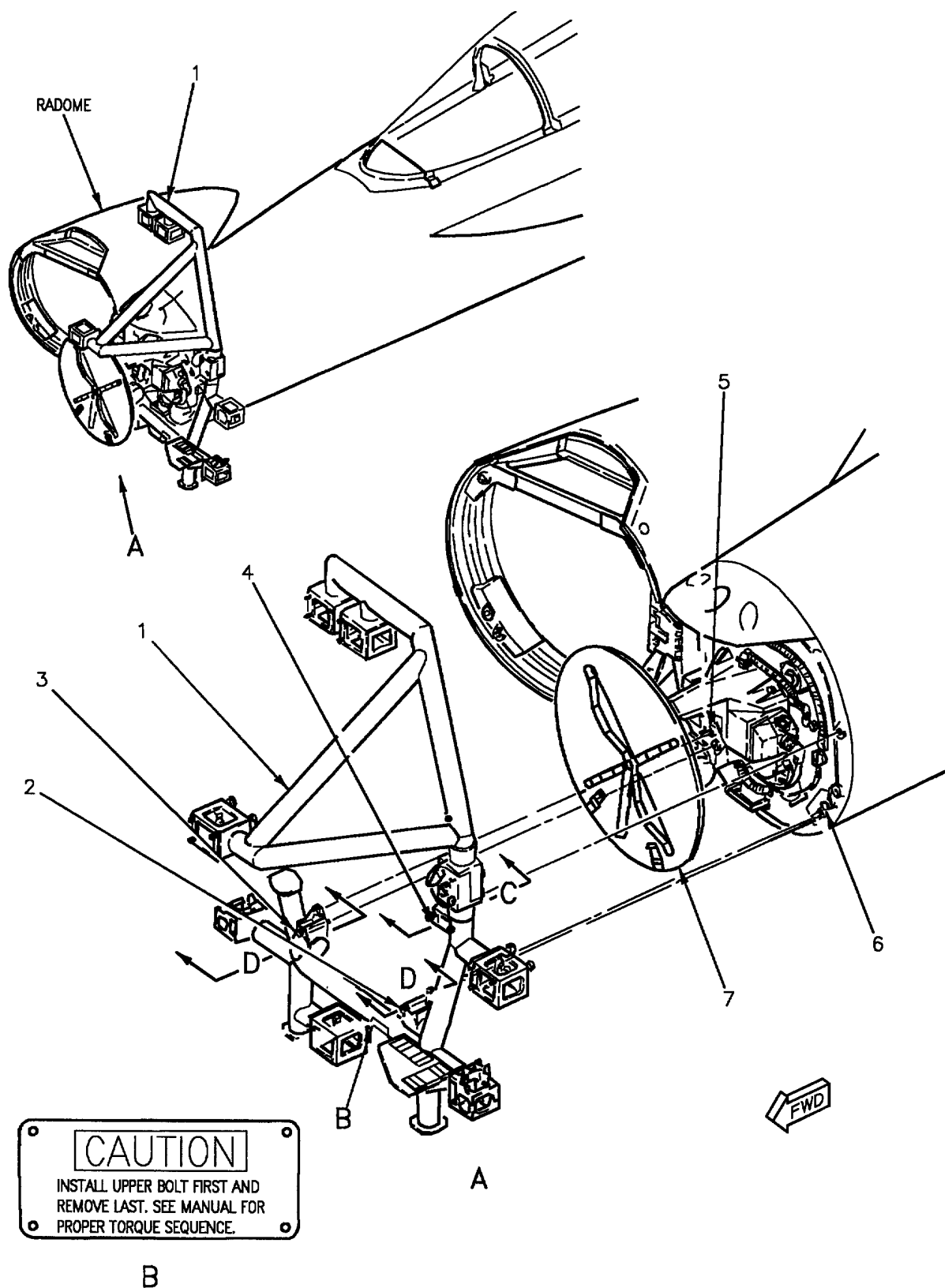
 PART OF 74D110020 BORESIGHT REFERENCE FRAME ASSEMBLY OR 74D110163 BORESIGHT ALIGNMENT SET.

Figure 2. Boresight Reference Frame Subassembly, Installation (Sheet 1)



18AC-SRM-222-(143-2)01-SCAN

Figure 2. Boresight Reference Frame Subassembly, Installation (Sheet 2)

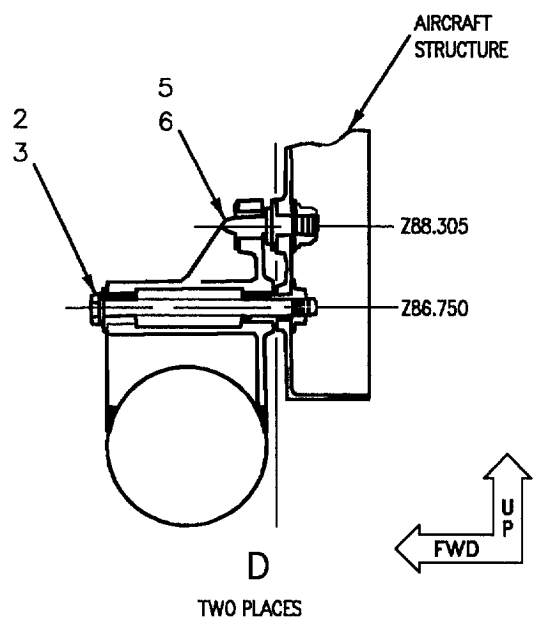
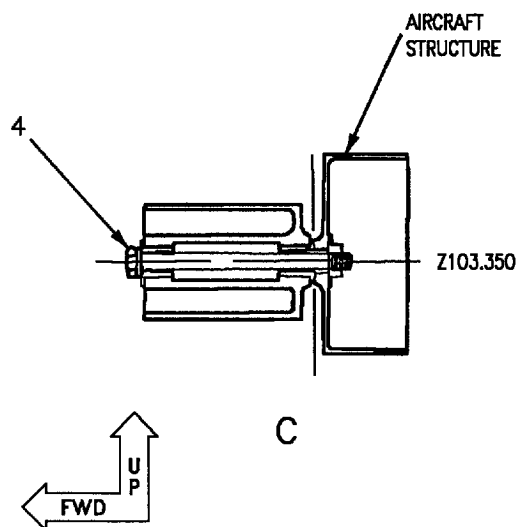



Figure 2. Boresight Reference Frame Subassembly, Installation (Sheet 3)

INDEX NO.	NOMENCLATURE	PART NUMBER
1 	BORESIGHT REFERENCE FRAME SUBASSEMBLY	74D111115
2	ATTACH BOLT	
3	ATTACH BOLT	
4	ATTACH BOLT	
5	ALIGNMENT PIN	
6	ALIGNMENT PIN	
7	ANTENNA COVER	74D740001-1001
8	L-PIN	
9	HINGE PIVOT BOLT	
10	TAPERED PIN	

LEGEND


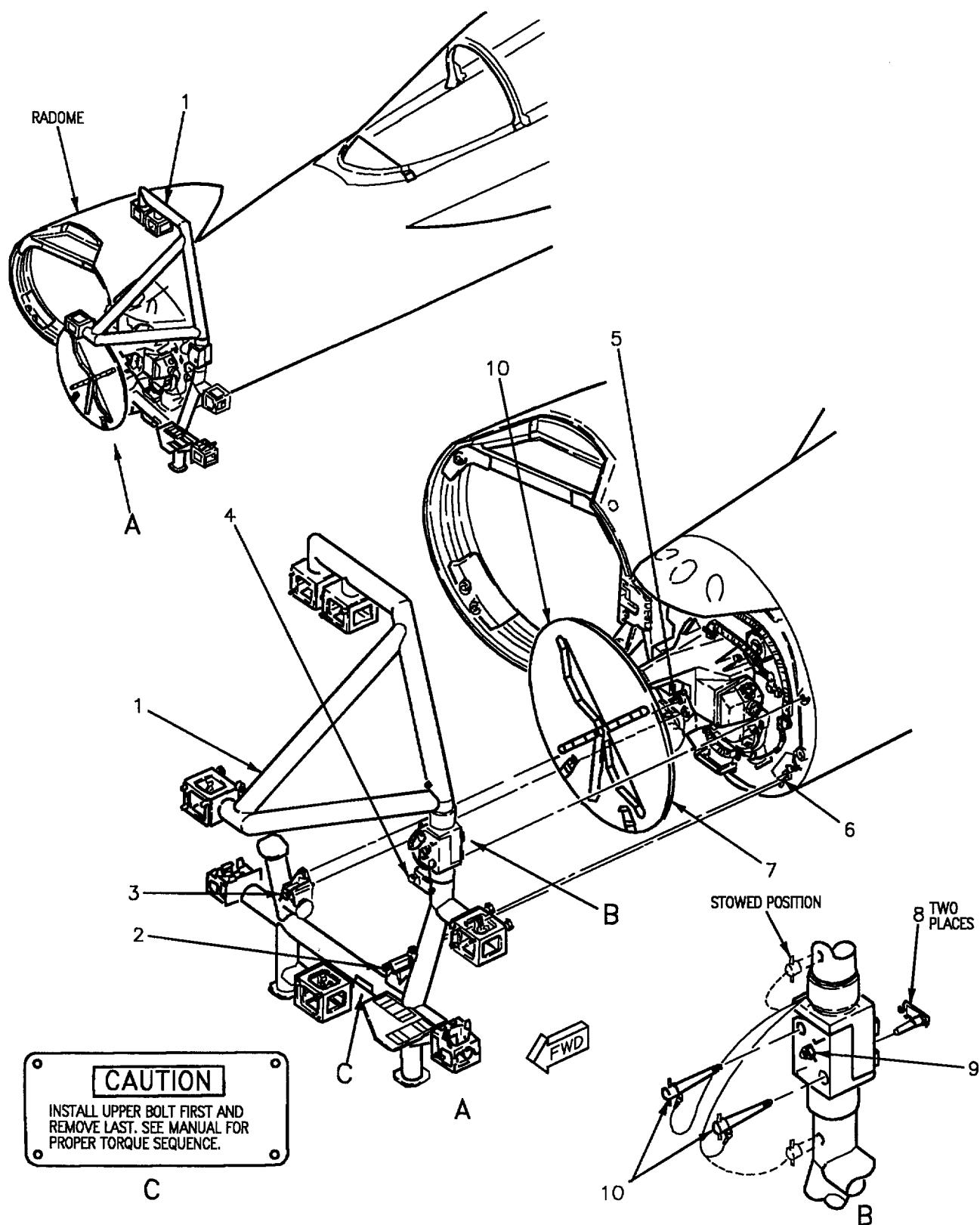
 PART OF 74D110020 BORESIGHT REFERENCE FRAME ASSEMBLY OR 74D110163 BORESIGHT ALIGNMENT SET.

Figure 3. Boresight Reference Frame Subassembly, Removal and Stowage (Sheet 1)



18AC-SRM-222-(144-2)01-SCAN

Figure 3. Boresight Reference Frame Subassembly, Removal and Stowage (Sheet 2)

ORGANIZATIONAL MAINTENANCE
TRIAXIAL ALIGNMENT SET CHECK FIXTURE

Reference Material

None

Alphabetical Index

Subject	Page No.
Alignment Verification Procedure	1
Introduction	1

Record of Applicable Technical Directives

None

1. INTRODUCTION.

2. This work package contains organizational level maintenance instructions for verifying the alignment of 74D110021 triaxial alignment set using triaxial alignment set check fixture. If more than one system is to be boresighted, the triaxial alignment set should be installed on the check fixture between procedures with equipment turned on. This will keep equipment at a constant operating temperature and help prevent accidental damage or misplaced equipment.

**Part Number or
Type Designation****Nomenclature**74D110163-1001
(74D110159-1001)Boresight Alignment Set
(Triaxial Alignment
Set Check Fixture)74D110021-1003
(74D110021-1001)

Triaxial Alignment Set

-

Camelhair Brush

Materials Required**3. ALIGNMENT VERIFICATION
PROCEDURE.** See figure 1.**Support Equipment Required****NOTE**

Alternate item type designations or part numbers are listed in parentheses.

**Specification
or Part Number****Nomenclature**MIR-O-LEN
CCC-C-440 TYPE 1
CLASS 1
P-D-680, TYPE II
BB-N-411
73
O-A-51Cleaning, Solution
CheeseclothDry Cleaning Solvent
Nitrogen
Cloth, Lens
Acetone, Technic



To prevent damage to optical surfaces, clean only when needed to remove dust, fingerprints, oil, or water spots. Reduce the need for cleaning by proper storage when not in use and by careful handling of equipment to avoid marring optical surfaces.

a. Clean dust from lens surfaces of 74D110021 triaxial alignment set, 74D111167 triaxial detector unit (1), 74D111159 beam splitter assembly (3), and 74D111180 laser (4) per substeps below:



Do not wipe optical surfaces with dry tissue or cloth. Damage to lens surface may result.

NOTE

Preferred method of dust removal is substep (1), alternate method is substep (2) and (3).



Nitrogen, BB-N-411, Type I (Gaseous) 25

(1) Remove dust from lens surfaces by blowing with compressed dry nitrogen.



Care must be taken to make sure brush is kept clean. A brush contaminated with dirt and/or oil will only spread contaminants on lens surface.

(2) Remove dust from lens surfaces using a clean camel hair brush.

(3) Remove any residual dust by wetting a clean lens cloth with Mir-O-Len and gently wipe lens in one direction only.

b. Clean fingerprints or other oily substances from lens surfaces of 74D110021 triaxial alignment set,

74D111167 triaxial detector unit (1), 74D111159 beam splitter assembly (3), and 74D111180 laser (4) per steps below.

(1) Wet a clean lens cloth with Mir-O-Len and gently wipe the lens in one direction only.



Acetone, O-A-51

26



Use acetone, technic sparingly so as not to degrade gaskets under lens retaining ring.

(2) Speed drying and minimize streaking by wiping lens with acetone, technic wetted lens cloth in one direction only.



Dry Cleaning Solvent, P-D-680, Type II

7

c. Clean mating surfaces of adapter assembly (2) and attaching boresight equipment using clean cheese-cloth moistened with dry cleaning solvent.

d. Install triaxial detector unit (1) on 74D111195 triaxial alignment set check fixture adapter assembly (adapter assembly) (2) with three attach bolts (11) handtight.

e. Install beam splitter assembly (3) on adapter assembly (2) with three attach bolts (9) handtight.

f. Install laser (4) in adapter assembly (2) per substeps below:

(1) Open two laser clamps (10).

(2) Slide laser over cone bolts until line on laser plate is aligned with end of adapter assembly (2).

(3) Rotate laser until up line on laser plate is aligned with up mark on adapter assembly (2).

(4) Close two laser clamps (10).

g. Position 74D111141 control/display unit (8) near adapter assembly (2).

h. Connect 74D111145-1001 cable (7) to triaxial detector unit (1) and to control/display unit (8).

i. Connect laser cable to control/display unit (8).

j. Connect 74D111145-1003 cable (5), with ground wire, to control/display unit (8) and to 74D111145-1005 cable (6).

k. Plug in cable (6) to electrical power source.

WARNING

Laser radiation, do not look into laser beams or eye injury could occur.

NOTE

The main laser light will illuminate when control/display unit is turned on. When laser return is not sensed by the control/display unit after approximately 7 seconds, it will inhibit the laser, causing the main laser light to go off.

l. Press control/display unit (8) switch (13) to on position.

m. Allow 30 minutes warmup.

NOTE

Normal equipment operation will allow the displayed ROLL reading to fluctuate as much as ~~0.50~~ milliradians about a median value. Operator judgement should be used to determine this median roll value.

n. Read and record PITCH (16), ROLL (15), and YAW (14) display indications on control/display unit (8).

o. If pitch and yaw indications recorded in step m are 0.00 ~~±0.50~~ milliradian and roll is 0.00 ~~±0.00~~ milliradian, the triaxial alignment set is aligned within tolerance. If within tolerance, go to step o. If not within tolerance, the triaxial alignment set must be recalibrated at depot maintenance.

p. Press control/display unit (8) switch (13) to off position.

q. Unplug cable (6) from electrical power source.

r. Disconnect cable (5), and ground wire, from control/display unit (8) and cable (6).

s. Disconnect laser cable from control/display unit (8).

t. Disconnect cable (7) from control/display unit (8) and triaxial detector unit (1).

u. Remove laser (4) from adapter assembly (2) per substeps below:









(1) Open two laser clamps (10).

(2) Slide laser out of adapter assembly (2).


(3) Close two laser clamps (10).

v. Remove beam splitter assembly (3) from adapter assembly (2) by removing three attach bolts (9).

w. Remove triaxial detector unit (1) from adapter assembly (2) by removing three attach bolts (11).

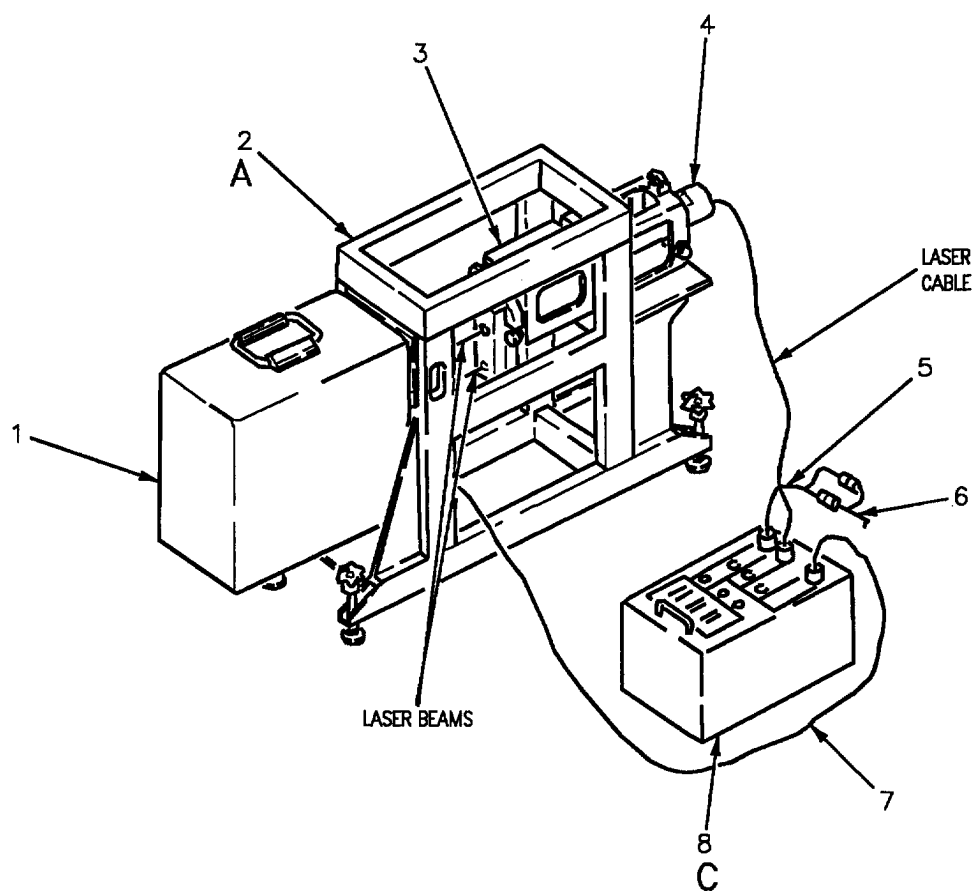
INDEX NO.	NOMENCLATURE	PART NUMBER
1 	TRIAXIAL DETECTOR UNIT	74D111167
2 	TRIAXIAL ALIGNMENT SET CHECK FIXTURE ADAPTER ASSEMBLY	74D111195
3 	BEAM SPLITTER ASSEMBLY	74D111159
4 	LASER	74D111180
5 	CABLE	74D111145-1003
6 	CABLE	74D111145-1005
7 	CABLE	74D111145-1001
8 	CONTROL/DISPLAY UNIT	74D111141
9	ATTACH BOLT	
10	LASER CLAMP	
11	ATTACH BOLT	
12	LEVELING FOOT	
13	SWITCH	
14	YAW DISPLAY	
15	ROLL DISPLAY	
16	PITCH DISPLAY	

LEGEND

 PART OF 74D110021 TRIAXIAL ALIGNMENT SET.

 PART OF 74D110159 TRIAXIAL ALIGNMENT SET CHECK FIXTURE OR 74D110163 BORESIGHT ALIGNMENT SET.

Figure 1. Triaxial Alignment Set Check Fixture (Sheet 1)

**Figure 1. Triaxial Alignment Set Check Fixture (Sheet 2)**

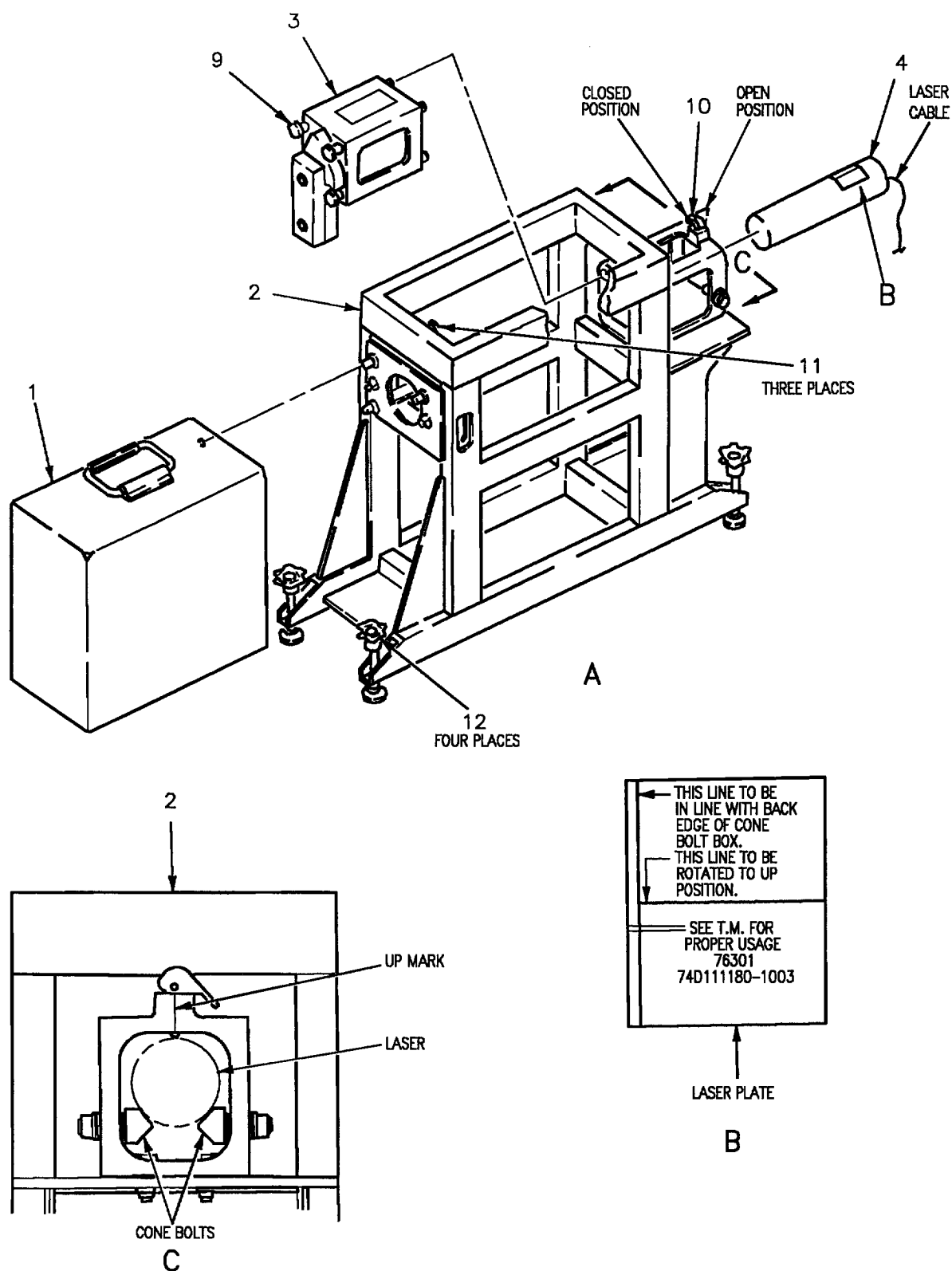


Figure 1. Triaxial Alignment Set Check Fixture (Sheet 3)

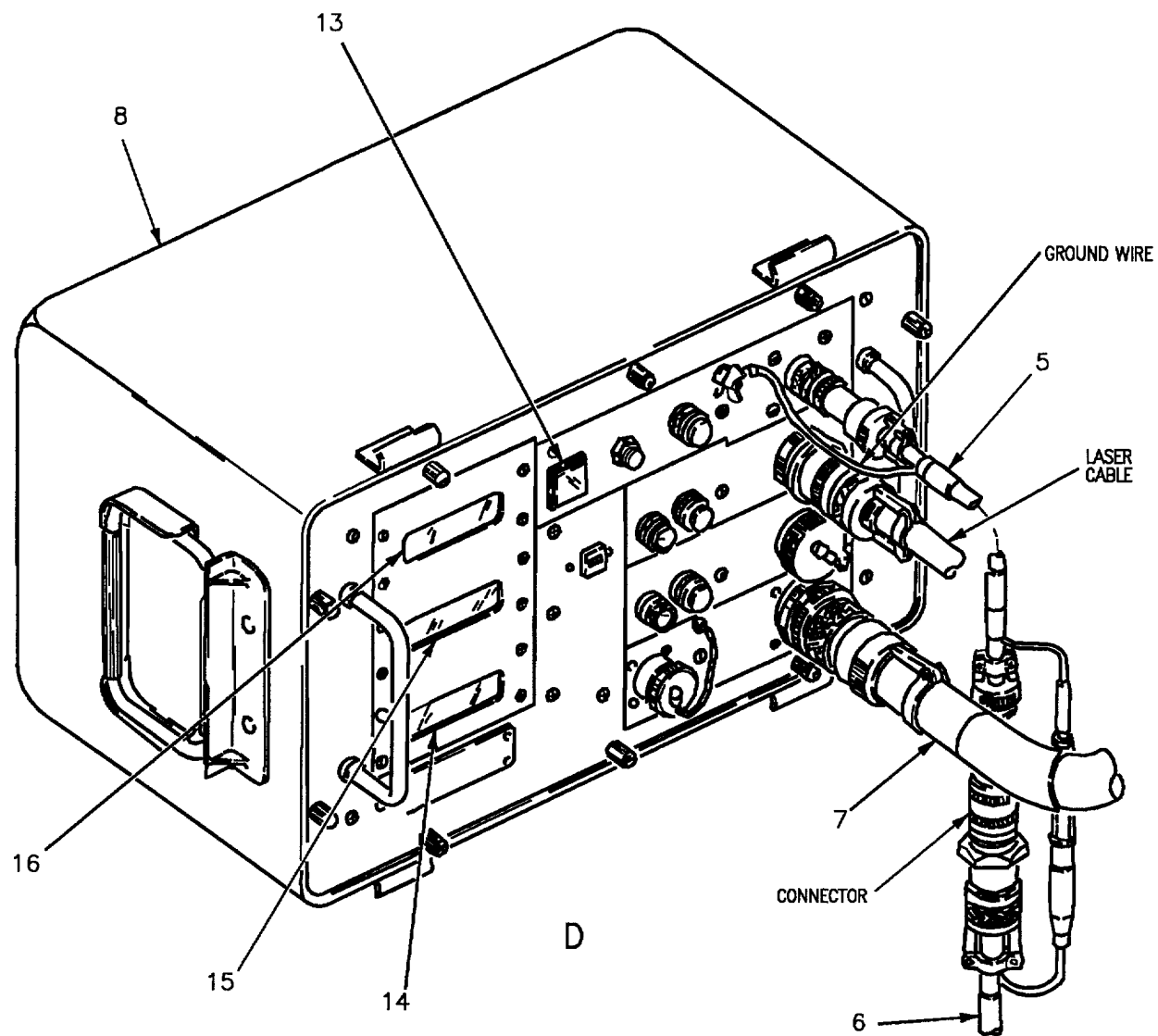


Figure 1. Triaxial Alignment Set Check Fixture (Sheet 4)

